

PRODUCT NAME**PVC94 Line****HMG PAINTS LTD**

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Issue date 16/02/2002
Formula number 1100 series
Product code TOPPVC
Printed date Tue 31/08/04 at 12:33:12

PACKAGING

Available in 1, 2½, 5 litre lever lid tins.

PRODUCT FUNCTION

P.V.C. 94 LINE is a coating for application to P.V.C, other selected plastics and other 'difficult' substrates.

P.V.C. 94 is easy to use and can be applied by brush or spray to offer the applicator high quality re-decoration and protection of the substrate. A wide variety of colours are available including metallics.

Due to its outstanding adhesion properties and flexibility usages include rigid PVC (Plastisol) cladding, PVC roofing, curtain sided trucks, interior and exterior automotive trim components, also over A.B.S. and certain other difficult substrates, including abraded powder coatings.

TECHNICAL INFORMATION

Solids	Approximately 30 to 40% dependent on colour
Flashpoint	Below 22°C
Specific Gravity	0.90 to 1.30 approximately dependent on colour
Viscosity	75 - 85 seconds B4 Ford Cup
Storage	12 months in original sealed containers
Colour retention	Excellent

APPLICATION AND USAGE DATA

Touch dry	5-10 minutes
Firm dry	30 minutes
Hard dry	24 hours
Thinners	THINNER 2661
Overcoating	10 minutes minimum, maximum indefinite
Eqp. cleaning	GUNCLEANER 401
Film thickness	100 microns WFT gives approximately 25 microns DFT
Coverage	10 square metres per litre (theoretical)
VOC	770g/l

COLOUR RANGE

Range of standard colours BS, RAL. Other colours are available on request.

SPECIAL PROPERTIES

- Excellent adhesion to plastic and other difficult surfaces, including powder coatings.
- Very fast drying.
- Extreme flexibility.

PREPARATION

Surfaces should be clean, dry and free of all contamination.

Pre-cleaning can be carried out using HMG Prep Clean 2805 onto New PVC substrates & HMG Prep Clean 2806 onto Old PVC substrates.

HOW TO USE

- | | | | |
|--|---|--|--|
| <input type="checkbox"/> Airless | <input checked="" type="checkbox"/> Brush | <input type="checkbox"/> Electrostatic | <input checked="" type="checkbox"/> HVLP |
| <input checked="" type="checkbox"/> Conventional spray | <input checked="" type="checkbox"/> Dipping | <input type="checkbox"/> Roller | <input checked="" type="checkbox"/> See application data |

APPLICATION

By Brush: Thin if required with up to 30%. Apply P.V.C. 94 LINE using a soft full brush with minimal laying off.
 Apply second coat with full brush - do not brush out otherwise this will re-dissolve first coat application.

By Spray: Thin to a spray viscosity of 20/40 seconds (dependent on equipment) with HMG Thinner 2661 only.

Technical Data Sheets are also available on our website at www.hmgpaint.com

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Apply 2 light coats allowing 5 - 15 minutes Flash off between coats.

If colour bands are to be applied, allow PVC to air dry for 4 hours before masking using low tak tape and applying colour bands. Avoid excessively high film thicknesses of PVC. 94 LINE as flexibility will be impaired in thick films.

An addition of 2K Hardener 9004 Std can be made to increase the durability of PVC94 Line. This addition made in a 10:1 ratio will increase durability, but will decrease the flexibility of the product.

HEALTH AND SAFETY

- Refer to health and safety data sheet and tin label prior to use.
- Wear suitable respiratory equipment when spraying.
- Air fed breathing equipment must be worn if using 2K Hardener 9004 Std.

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