



Coatings ■ Solutions



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INVIRAnamel

DESCRIPTION: A high quality, low 2.8 VOC, fast-drying, enamel specifically formulated for electrostatic applications. INVIRAnamel is suitable for interior or exterior surfaces. Meets or exceeds most federal and local VOC compliance regulations. Contact your local air quality authorities for restrictions.

USES: INVIRAnamel is perfect for surfaces which have been previously coated with finishes that are susceptible to lifting or wrinkling caused by the strong solvents of epoxies and urethanes. It also provides the solution to painting budgets, which do not allow for the use of an epoxy like INVIRApox or an acrylic urethane like INVIRAthane.

APPLICATION: Ransburg No. 2 Handgun -spray as packaged- no adjustment needed. All other electrostatic guns - reduce viscosity to 22-28 seconds, No. 2 Zahn cup. INVIRAnamel may also be applied by all other types of spray equipment (airless tip size .011 - .013)

SURFACE PREPARATION AND LIMITATIONS: It is imperative that all surfaces be properly prepared in order to achieve the adhesion and performance that this product is designed to give. Always follow proper cleaning procedures. Be sure to observe and follow safety precautions as printed on the label. All surfaces should be primed with INVIRAprime.

APPEARANCE: High Gloss (85+° reading on 60° gloss meter). Semi-Gloss (65° on a 60° gloss meter).

COVERAGE: 375-400 sq. ft per gallon. To achieve maximum durability 3 wet mils must be applied. Note: All colors are lead-free. Dark and bright colors produce far less hiding power than pastels. Coverage on these colors may be as low as 300 sq. ft. per gallon.

DRY TIMES: At 70° - To touch - 30 minutes. To handle - 2-4 hours. To recoat - between 4 and 24 hours. If recoated before 4 hours, lifting and/or loss of gloss may occur. Recoating after 24 hours will almost always cause lifting. After 24 hours, do not recoat for 7 days. Bake schedule to total cure - 150° for 30 minutes. Optimum coating temperature for application is 70°-77°F. Temperature

Restrictions: Surface of painted part and air temperature must remain over 55°F prior to application and for at least 2 hours after coating application.

FLASH POINT: 84° F

COLORS AVAILABLE: Full Range

THINNING (if necessary): Oxsol may be used for thinning. To extend flash off time add Oxsol.

PRIMER RECOMMENDED: Universal INVIRAprime, formulated for electrostatic applications. Surface must be prepared and primed prior to INVIRAnamel finish coat. Priming is necessary for all bare metal surfaces, contact your Perfection representative for all other surfaces.

URETHANE ADDITIVE: 4-6 fl. ozs. maximum of 2414B may be added for improved hardness, solvent resistance, and weathering.

Table with 12 columns: Type, Gloss, Dry Time (Recoat, Handle, Force, Cure), Solids (Wt, Vol), Coverage, VOC, Thinner, Clean Up. Row 1: Alkyd Enamel, See Above, 4-24 hrs, 2-4 Hrs, See Above, 7 Days, 58.7%, 51.6%, Approx. 827 sq. ft. per gl. @ 1 mil DFT, 2.8 Lbs. Per Gallon., Oxsol, Oxsol

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