

Water Lo Cure

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p><i>Water Lo-Cure</i> is a single component water borne acrylic coating specifically formulated to meet existing state and federal VOC regulations.</p> <p><i>Water Lo-Cure</i> is designed for use over a variety of substrates with results similar to solvent borne coatings. In most cases, direct replacement can take place.</p> <p><i>Water Lo-Cure</i> is suitable for various substrates that cannot tolerate high baking temperatures such as structural plastics, zinc or aluminum die castings, partial or pre-assembled products.</p> <p><i>Water Lo-Cure</i> is custom engineered to customer's specifications and can be textured using standard air pressurized spray equipment. It is also available as a self-texturing coating (single step application).</p> <p>CAUTION: AVOID FREEZING</p> <p>Randolph Products Co. warrants that its products meet its internal specifications and are of merchantable quality. However, the purchaser is solely responsible for the suitability of the product for any particular application. The purchaser should thoroughly test or qualify the product for serviceability, environmental compliance and health and safety factors prior to use. Further, our total liability is limited to the price of the product or replacement in kind.</p> <p>Randolph Products Company 33 Haynes Circle Chicopee, MA 01020 Phone: 413-592-4191 Fax: 413-594-7321 www.randolphproducts.com</p>	<p>Physical and chemical tests were performed on "Bonderite 1000" steel panels. All panels were force dried 30 minutes at 150°F followed by a 10 day cure period at room temperature.</p> <ol style="list-style-type: none"> 1. Volume Solids: 30 - 35% (varies by color) 2. Pencil Hardness: H – 2H 3. Cross Hatch Adhesion: 5B 4. Flexibility: Pass 1/8" Mandrel 5. Theoretical Coverage @ 1 mil dft: 481 - 561 ft²/gallon (varies by color) 6. Direct Impact: 40 inch lbs. 7. Reverse Impact: 40 inch lbs 8. Solvent Resistance: 25 double rubs – "No effect" is defined as no permanent softening of film and/or permanent change in appearance. Isopropyl Alcohol: No effect 13. Taber Abrasion (1000 grams; 1000 cycles; CS10 wheels): < 100 mg. loss. 14. Gloss @ 60°: 0 – 50 (varies by color and product) 15. VOC: 1.5 – 1.8 lbs/gallon 16. Shelf Life: 6 months 	<p>Use of conventional air, airless or isolated electrostatic spray equipment. Stainless steel is highly recommended.</p> <p>BASE COAT</p> <p>Fluid pressure and air pressure will vary according to nozzle and equipment combination.</p> <p>Spray Viscosity: 20 – 25 seconds #2 Zahn cup @ 68°F.</p> <p>Reduction: 5% reduction with tap water if needed NOTE: Viscosity adjustments by use of Zahn cup may be misleading due to the thixotropic nature of this product.</p> <p>Allow a minimum of 15 minutes flash off or prebake 5 minutes at 150°F before applying a texture coat.</p> <p>If smooth finish coat is desired, flash off 15 minutes then force dry 20 minutes at 150 - 180°F or air dry overnight.</p> <p>TEXTURE COAT</p> <p>Fluid pressure and air pressure will vary according to nozzle and equipment combinations as well as type of texture pattern desired.</p> <p>Viscosity: Use as supplied Flash off: 15 – 20 minutes prior to force drying 150 - 180°F for 20 minutes.</p> <p>CURE TIMES</p> <p><i>Water Lo-Cure</i> will cure at ambient room temperature. Five days minimum are required to achieve total cure.</p> <p>Air dry schedule: Dry to Touch: 10 minutes Dry to Handle: 15 – 30 minutes Dry to Package/perform secondary operations: Overnight (12 hours)</p>

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		<p>Force Dry schedule: 20 – 30 minutes at 150 - 180°F</p> <p>Complete cure: approximately 5 days. This time will vary based on ambient temperature and humidity.</p> <p>Times and temperatures can vary according to substrate tolerances. Temperatures should not exceed 200°F for an extended period of time.</p> <p>Strategic placement of fans and heat will help minimize flash off times especially during humid weather.</p> <p>Safety Precautions: This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>
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