

# PARACRYL® IF540

P52.01

## Description

- A two-pack, isocyanate-free catalysed acrylic coating.
- Approved to APAS-2919
- Conforms to AS/NZS 3750.5

## Product Characteristics

- Unlimited re-coatability.
- Excellent gloss retention.
- Excellent exterior durability.
- Good chemical and solvent splash resistance.
- Will cure down to 5°C
- Isocyanate-free.

## Colours and Gloss

- AS2700 colour card - full gloss

## Recommended Film Thickness (Per Coat)

|  | Minimum | Maximum | Typical |
|--|---------|---------|---------|
| Dry film thickness (µm)                        | 50      | 50      | 50      |
| Wet film thickness (µm)                        | 110     | 110     | 110     |
| Theoretical spreading rate (m <sup>2</sup> /l) | 9.0     | 9.0     | 9.0     |

## Basic Data at 25°C

|                        |                        |
|------------------------|------------------------|
| Solids content approx. | 45% by volume          |
| Mix ratio              | 4A:1B by volume        |
| Touch dry after        | 30 minutes             |
| Full cure              | 7 days                 |
| Temperature Resistance | 95°C (dry), 35°C (wet) |

## Surface Preparation

### PREVIOUS SUITABLE COAT

- Must be dry and free from chalking and contamination and sufficiently roughened if necessary.
- Oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning.
- Substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point.
- Relative humidity should not exceed 85%.

## Application Instructions

- Mixing ratio by volume 4A:1B.
- Mix Poly Paracryl IF540 Part A with Paracryl IF540 Part B only.
- induction time – none.
- Pot life at 25°C 8 hours. Do not use after this time even if the mix is still liquid.
- Stir the components and mixed product well using a mechanical mixer.
- This product must be thinned with the recommended thinner before application.

- Thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions.  
The temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity.
- Too much thinner will result in lower sag resistance and slower cure.
- Thinner should only be added after mixing the components.
- Freshly catalysed material should not be added to product that has been mixed for some time.
- Wattyl recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information.
- For recommendations outside those contained in this data sheet, refer to Wattyl.

## Application Methods

|                     | AIRLESS SPRAY       | AIR SPRAY*                 | BRUSH/ROLLER   |
|---------------------|---------------------|----------------------------|--|
| Recommended thinner | Thinner L747        | Thinner L747               | Thinner L754   |
| Volume of thinner   | 10-20%              | 15-25%                     | 5-10%  |
| Tip                 | 0.38mm (0.015 inch) | 1.4-1.8mm (0.06-0.07 inch) | <ul style="list-style-type: none"> <li>• Nylon/polyester or natural bristle brushes recommended.</li> <li>• Recommended roller cover should be 5-10mm woven with a solvent resistant core.</li> <li>• The maximum dry film thickness that can be achieved when brushing/rolling is 30 microns.</li> <li>• Multiple coats may be required to achieve the recommended dry film thickness.</li> </ul> |
| Fluid/Atomised      | 15 MPa (2100 psi)   | 3.4-4.1 bar (50-60 psi)    |  |
| Pump                | 30:1                | -                          |  |
| Filter              | 60 mesh             | -                          |  |
| Hose                | ¼" ID (6.3 mm)      | -                          |  |

\*At temperatures greater than 30°C, or in windy conditions, or where slower drying is required, part, or all, of Thinner L747 may be replaced with Thinner L748. However, film thicknesses must be closely monitored as excessive film builds may result in sagging

**CLEANING SOLVENT** | Thinner L747

## Safety Precautions

- Flammable. Avoid contact with heat and naked flame.
- Avoid contact with skin and eyes.
- Use gloves, mask and goggles during application.
- Provide adequate ventilation when using in confined spaces.

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- This product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the safety data sheet (SDS).

## Additional Data

### OVERCOATING TABLE

Overcoating interval for Paracryl IF540 when top coating with itself.

| Interval | 5°C   | 15°C | 25°C    | 35°C    |
|----------|---|------|---------|---------|
| Min      | 2 hrs   | 1 hr | 30 mins | 15 mins |
| Max      | Unlimited when dry and free from any chalking and contamination |      |         |         |

### CURING AND POTLIFE TABLE

| Paint temperature                 | 5°C     | 15°C    | 25°C    | 35°C    |
|-----------------------------------|---------|---------|---------|---------|
| Touch Dry                         | 2 hrs   | 1 hr    | 30 mins | 15 mins |
| Dry to handle                     | 72 hrs  | 32 hrs  | 16 hrs  | 12 hrs  |
| Full cure                         | 28 days | 14 days | 7 days  | 5 days  |
| Potlife (at applicable viscosity) |         | 12 hrs  | 8 hrs   | 4 hrs   |

\*Adequate ventilation must be continuously maintained during application and curing.

## Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.

## Product Compatibility

### PRIMERS

- Super Etch Primer
- Epinamel UC230
- Epinamel PR250
- Epinamel PR360ZPS
- Epinamel DTS680
- Epinamel DTM985

### TOPCOATS

- Paracryl IF540

## Storage and Packaging

- Shelf life at least 12 months.
- All components shall be stored in a dry internal environment at between 5°C and 35°C.
- Packaging: 20 litre kit (16 litre Part A, 4 litre Part B)  
5 litre kit (4 litre Part A, 1 litre Part B)
- Product line: 2017.

For the most up to date information, please visit our website at [www.wattylpc.com.au](http://www.wattylpc.com.au), or contact us at Australia 132 101 (Australia) 0800 825 7727 (New Zealand).

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