
MANOR

PRODUCT DATA SHEET

HI BUILD VINYL



INTENDED USE

DECORATION OF BUILDINGS

A rapid drying high performance 'one coat', anti-corrosive, self priming low sheen topcoat, giving a tough flexible film with remarkable adhesion to many difficult substrates .

VOC Classification 2004/42 Cat A(i) = 500g/L.
Apply by brush, do not add thinners.

Typical uses are:

- Cladding Paint; dries at low temperatures down to 5 C for use throughout the year. SEE SUPPLEMENTARY DATA SHEET FOR USE AS A CLADDING PAINT.
- Metal Railings and Fencing; adheres directly to galvanised metal or steel with no need for mordant solutions or etch primers.
- Galvanised or steel structures subject to high humidity; such as steel roof trusses in swimming pools

Not suitable for use in areas subject to chemical / solvent attack

ARTICLES - that are not part of a building structure (and are therefore outside the scope of the building products VOC Product Directive)

Typical uses are: machinery, process steelwork, fixed plant, exteriors of pipelines and tanks; for areas exposed to high humidity and certain chemicals (seek advice from Manor Coating Systems Technical Department)

Not suitable for use in areas subject to chemical / solvent attack

METAL FINISHING

A rapid dry 'one coat' anti corrosive self priming low sheen topcoat, giving a tough flexible film with remarkable adhesion to many difficult substrates with excellent re-coat characteristics.

Typical uses are:

- General Metal Fabrication; used to overcome problems associated with conventional alkyd paints subject to severe exposure conditions often associated with poor adhesion
- Wrought ironwork fabrication, applied direct with no need for a mordant or etch primers
- Metalwork subject to low temperatures, Hi Build Vinyl remains flexible
- Metalwork subject to high humidity

Not suitable for use in areas subject to chemical / solvent attack

NICHE END USES ON SOME PLASTICS

Some rigid and flexible plastics; such as Foamex and PVC. Always test prior to painting. Seek advice from Manor Coating Systems Technical Department.

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

Not suitable for use in areas subject to chemical / solvent attack

SUITABLE SUBSTRATES AND PREPARATION

Untreated steel and wrought ironwork; for best results blast clean prior to painting to SA 2 1/2, otherwise manually abrade using powered hand tools and abrasives to ST2.

Weathered Galvanised Steel; remove all traces of oil or grease, lightly abrade with P600 wet or dry paper. Remove dust

Heavily Chromated Galvanised Steel; alkali clean and then proceed as for Bright Spangled Galvanised Steel.

Bright Spangled Galvanised Steel and Newly Galvanised Steel (less than six months since galvanising); remove oil and grease, thoroughly abrade with P600 wet or dry abrasive, remove dust.

Cladding; see separated Data Sheet and follow instructions prior to painting

Aluminium; use 1 Pack Etch Primer CT, see data sheet for details

Always prepare a test area.

Other substrates including plastics; seek advice from Manor Coating Systems Technical Department

AVAILABILITY

A low satin finish in 5 litre containers in a range of colours.

A Hi Build Vinyl MIO (Micaceous Iron Oxide) in 5 litre containers in Graphite Grey.

PRODUCT INFORMATION

Composition Based on a modified vinyl resin pigmented with suitably selected pigments and modified zinc phosphate anticorrosive pigment.

Volume Solids 44% for semi-matt black

Weight Solids 64% for sem-matt black

VOC content 500 g/litre

Typical film thickness Typically 170 microns wet and 75 microns dry

Galvanised items; inc rails & fences to prevent zinc salts migrating a minimum dft of 75 microns is required

If items are in coastal location a minimum 120 microns d.f.t. is required

Theoretical coverage 5.8 sq metres/litre at 170 microns wet film thickness

Dry heat resistance 60 C

Flash Point Within the range 21-31 C

APPLICATION DETAILS

PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE

Note To comply with VOC Products Directive for the DECORATION OF BUILDINGS no thinner may be added

Airless spray: **cold** Up to 5% thinners may be added to suit equipment. Typical tip size 13-19 thou. (0.33-0.48mm) Typical fluid pressure 200 kg/sq metre or 2800 p.s.i.

heated Not recommended

Conventional spray Thin up to 15% with thinner, apply 2 to 3 coats to achieve the required film thickness

 Do not hot spray

Brush Roller Apply evenly using a well loaded brush, do not attempt to brush out or lay off

Thinner Industrial Thinner. Fast Flash Thinner may be used for quicker flash off in a spray shop.

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	25 microns	60 microns
Maximum	75 microns	170 microns

DRYING AND RECOATING

Approximate drying times at 75 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10C	1 hour	3 hours	Indefinite
20C	30 minutes	1 hour	Indefinite

Environmental conditions

The air temperature should be at least 5 C with a surface temperature 3 C above dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur during application or drying.

The drying times will be significantly extended in cold, damp conditions

Do not apply to external surfaces if the forecast is for rain to fall within the next 24 hours as surface may water mark during curing.

In exposed windy conditions a minimum air temperature of 8 C is recommended.

Overcoating / repainting

An additional coat of Hi Build Vinyl may be applied if required .

If spraying Wet on Wet application can be undertaken

SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

**SAFETY
PRECAUTIONS**

Refer to Manor Safety Data Sheet

LIMITATIONS

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department . If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing . Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

REFERENCES

Amended: 13/10/2016

Reference: HV Version: 9.0