



## WeldMark Shielding Gas Purple (Metallic) APPLICATION GUIDE

**PRODUCT TYPE:** THIS IS A LOW V.O.C. WATER REDUCIBLE ACRYLIC ENAMEL COATING. SINCE IT IS A COATING SYSTEM CONTAINING WATER, FULL CURE TIME WILL VARY DEPENDING ON THE HUMIDITY, TEMPERATURE, AND THE THICKNESS OF THE COATING APPLIED.

**IF A FASTER DRY TIME IS NEEDED, PLEASE CONTACT CYL-TEC FOR WELDMARK PURPLE SOLVENT BASED FAST DRY PAINT. CUSTOMER SERVICE TOLL FREE NUMBER; 1 (888) 429-5832**

**TYPICAL CURE SCHEDULE:**  
(AT 1.5 TO 2.0 MILS THICKNESS)

DRY TO TOUCH: 15 - 20 MINUTES (50% REL. HUMIDITY, 70F)  
DRY TO RECOAT: 1 ½ HOURS (50% REL. HUMIDITY, 70F)  
DRY TO HANDLE: 2 - 4 HOURS (50% REL. HUMIDITY, 70F)  
100% FULL CURE: 36 - 48 HOURS

**SURFACE PREP:** THE CYLINDER SURFACE SHOULD BE CLEAN, FREE FROM DIRT AND OIL. THIS COATING IS DESIGNED TO BE APPLIED DIRECT TO BARE SHOT BLASTED CYLINDERS OR COMPATIBLE ACRYLEX BRAND PRIMER PAINTED CYLINDERS. PAINTING OVER OTHER FINISH COATINGS IS POSSIBLE, BUT SHOULD BE TESTED ON A CYLINDER FIRST, AS INCOMPATIBILITY BETWEEN OTHER COATING SYSTEMS MAY CAUSE ADHESION OR DURABILITY PROBLEMS.

**PRIMER:** THIS IS A DIRECT TO METAL COATING SYSTEM, SO PRIMER IS NOT NECESSARY. BUT, IF YOU USE A PRIMER, USE A COMPATIBLE PRIMER SUCH AS ACRYLEX BRAND WATER REDUCIBLE PRIMER.

### **ACCEPTABLE APPLICATION METHODS:**

ALWAYS MIX THE PAINT THOROUGHLY BEFORE STARTING TO COAT CYLINDERS. WELDMARK PURPLE IS AN ENCAPSULATED HI SPARKLE METAL FLAKE COATING SYSTEM, AND IT WILL LOOK BEST WHEN THE PAINT IS THOROUGHLY MIXED AND APPLIED WITH SPRAY EQUIPMENT.

**1. SPRAY:** SINCE THIS IS A METAL FLAKE COATING, CONVENTIONAL OR HVLP SPRAY EQUIPMENT IS HIGHLY RECOMMENDED. DO NOT THIN THE PAINT, AS IT IS READY TO SPRAY RIGHT FROM THE PAIL. APPLY THE 1<sup>ST</sup> COAT TO THE CYLINDER. A 1 MIL THICK 1ST COAT IS RECOMMENDED. ALLOW A MINIMUM OF 1 ½ HOUR DRY TIME, AND APPLY SECOND 1 MIL COAT IF NECESSARY FOR PROPER COVERAGE. A FINISH COATING THICKNESS OF 2 MIL IS RECOMMENDED. CHECK ABOVE CURE SCHEDULE FOR TYPICAL FULL CURE TIME.

**2. PIPE ROLLER:** IF YOU CAN NOT SPRAY THIS COATING, (SPRAY IS HIGHLY RECOMMENDED) USE A SEGMENTED PIPE ROLLER FOR ROLL APPLICATION. DO NOT USE A CONVENTIONAL STRAIGHT ROLLER OR BRUSH. PRE-CONDITION THE ROLLER IN THE TRAY BY ROLLING IT IN THE PAINT TO ELIMINATE NAP. APPLY ONE EVEN COAT TO THE CYLINDER, ALLOW A MINIMUM OF 1 ½ HOUR DRY TIME. ONLY APPLY THE SECOND COAT IF NECESSARY FOR PROPER COVERAGE, BUT KEEPING THE COATING THICKNESS DOWN TO LESS THAN 2 MILS IS DESIRED. A THICKER COATING WILL ONLY INCREASE THE DRY TIME AND ALLOW FOR THE COATING TO CHIP OFF THE CYLINDER IN THE FIELD. CHECK ABOVE CURE SCHEDULE FOR TYPICAL FULL CURE TIME.

**COVERAGE COMMENTS:** SINCE THIS IS AN ENCAPSULATED TYPE METALLIC COATING SYSTEM, THE PIGMENT AND METAL FLAKE SHOULD STAY IN SUSPENSION LONGER THAN OTHER METALLIC COATINGS, BUT SOME SEPARATION IS POSSIBLE, ESPECIALLY WHEN THE PAINT IS APPLIED BY BRUSH, OR BY ROLLER. TO AVOID THIS SEPARATION IN NON SPRAY APPLICATIONS, USE A SEGMENTED ROLLER, AND APPLY 2 EVEN COATS. ALLOW 1.5 HR. DRY TIME BETWEEN COATS.

**SAFETY PRECAUTIONS:** CONSULT MSDS