SUNBURST COATINGS
2401 South 12th Street
Phoenix, AZ 85034
(602) 495-6000

PRODUCT DATA SHEET
SUN/CHARGE #15 SERIES
ELECTROSTATIC ACRYLIC SEALER

DESCRIPTION

Sun/Charge Enamels are fast drying electrostatic finishes for general industrial use on steel either as a single topcoat over properly primed surfaces or as a DTM finish when used with two coats. The first coat must have an overnight dry.

Sun/Charge is formulated to exacting specification for use primarily with Ransburg No. 2 gun. The product is ready to use with both the viscosity and Ohm level optimized. No need for field adjustments.

ADVANTAGES

- VOC 3.28 lb/gal (394 g/l)
- Fast air drying
- Polarity adjusted for application with a Ransburg #2 Gun
- Viscosity adjusted for application with a Ransburg #2 Gun
- Excellent corrosion resistance
- Excellent adhesion to untreated clean metal, both cold and hot rolled steel
- Free of lead and chromate hazards
- Application by various spray methods

SURFACE PREPARATION

Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties.
New Galvanized Steel: Use recommended primer. Do not apply direct to galvanized metal.
Aged Galvanized Steel: Use recommended primer. Do not apply direct to galvanized metal.
Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surfaces with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

Product Limitations:

- Package stability is 12 months. Indoor storage at 50-90ºF is recommended.
- Do not spray at air temperatures below 50ºF.
- Heavier film thickness will give slower dry time and higher gloss. Follow recommended film thickness for optimum performance.

APPLICATION

APPLICATION TEMPERATURE:
Substrate temperature between 55 to 100° F
Product temperature between 75 to 90 ° F

APPLICATION EQUIPMENT
Electrostatic Spray:
Recommend using Ransburg No. 2 /Deuce Hand Gun Unit
Other brands and types of electrostatic guns are also acceptable.

Conventional Spray:
Any spray gun for fine finishes are acceptable.

Note: Use oil & water extractor in air line per manufactures instructions. Drain daily or more often as needed especially in area or period of high humidity.

Airless Spray:
Reducer: Xylene or Acetone
Reduction: None - As needed
Pressure: 1800-2300 psi
Tip: .013”

Air Assisted Airless:
Air pressure: 15-30 psi
Fluid Pressure: 600-900 psi
Cap/Tip: .011” - .013”
Reducer: Xylene or Acetone
Reduction: None - As needed

HVLP: (Mach I)
Air Pressure: 70-90 psi
Fluid Pressure: 3-10 psi
Fluid nozzle: #94 (.055”)
Reducer: Xylene or Acetone
Reduction: As needed

Thinning: Thinning will not be required for most applications. If thinning is necessary and permitted by local regulations, small amounts of Xylene may be used to increase flow for spray applications. Use Aromatic 100 to slow film in extremely hot weather.

CLEAN-UP
Clean with Lacquer Thinner or Xylene. Follow manufacturer’s safety recommendations when using any solvent.

CHARACTERISTICS

GLOSS: Matte/Satin, 25+

COLOR: Clear

SOLIDS BY WEIGHT: 25 ± 2% (may vary by color)
SOLIDS BY VOLUME: 20 ± 2% (may vary by color)

VISCOSITY
30-35 seconds using a EZ Zahn #2 viscosity cup

RECOMMENDED FILM THICKNESS
Mils wet: 3.0 – 3.9
Applications, greater than 6 mils, paint will run
Mils dry: 1.0 – 1.3
RECOMMENDED SPREADING RATE: (no application loss)
@ 1 mil dft: 496 sq ft/gal
DRYING SCHEDULE: 1.0 mils dft, 77° F, 50% RH:
To touch: 30-45 minutes
To handle: 60-90 minutes
Tack free: 45-60 minutes
To recoat: overnight
To pack: overnight

NOTE: Good air movement and humidity control are necessary for proper drying of coatings. Coating millage and substrate temperature effect the above drying schedule. Please contact your salesman if you are unsure how environmental conditions may affect your results.

FLASH POINT: 00° F
Highly Flammable Liquid

PACKAGE LIFE: 1 year, unopened

VOC

COATING VOC: 3.28 #/gal or 304 g/l
This is an "artificial" VOC computation that the EPA and AQMD use to regulate paints and coatings that contain either water or exempt solvents. The *COATING VOC* is sometimes called the *Regulatory VOC,* and this is the VOC that air quality districts use to determine whether or not the paint is in compliance with the limits set by a rule.?

MATERIAL VOC: 3.28 #/gal or 120 g/l
This is the *actual or real amount of VOC that a gallon of paint contains.* Always use the MATERIAL VOC to calculate actual VOC emissions.?

STORAGE

FLAMMABLE LIQUID
Use All Appropriate Cautions for Storage and Handling.

WINTER:
Store inside a building, preferably with heat to maintain a climate of no less than 50° F. If stored outside, protect with blanket material and store under canopy if possible.?

SUMMER:
PROTECT FROM EXTREME HEAT:
Store inside a building or under canopy to prevent direct sunlight exposure. Extreme heat may cause an explosion and fire.

CAUTIONS

Do not apply product to exposed steel if threat of rain is imminent.

Thoroughly review product label for safety and cautions prior to using this product. A Safety Data Sheet is available from our web site or your local Sunburst Coatings Distributor. Please direct any questions or comments to your local Sunburst Coatings Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable.

Note: Sunburst Coatings believes the technical data presented in this bulletin is currently accurate: however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date information visit our web site or contact your local Sunburst Coatings Distributor.

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