

## | Introduction

Alka 410 is an Industrial Rapid-Cure Protective Enamel. Alka 410 is a solvent-borne finishing coating engineered for decorative and protective applications on metal and prepared substrates. The formulation incorporates advanced fast-reacting resin technology to achieve rapid surface drying, high gloss development, and durable film formation suitable for industrial production and maintenance operations.

The coating is designed to deliver an aesthetically uniform finish while maintaining good resistance to atmospheric exposure and general service conditions.

Alka 410 is a fast-drying industrial coating designed to provide durable surface protection and an attractive finish for metal, machinery, equipment, and structural components. It is specially formulated with quick-curing resins and protective pigments that allow coated surfaces to dry rapidly, reducing downtime and increasing production efficiency in industrial applications.

This enamel offers excellent resistance to weathering, moisture, abrasion, and mild chemicals, making it suitable for both indoor and outdoor environments. It forms a hard, smooth, and glossy or semi-gloss protective film that enhances the appearance and longevity of coated surfaces. Common applications include industrial machinery, steel structures, automotive components, storage equipment, and maintenance painting.

Alka 410 is valued for its ease of application, fast handling time, and strong adhesion to properly primed surfaces. It can be applied using spray, brush, or roller methods. Its quick curing properties make it ideal for workshops, factories, and projects requiring fast turnaround and reliable protective performance.

## | Where it could be used.

- Fabricated steel structures
- Machinery and industrial equipment
- Transport containers and fabricated assemblies
- OEM finishing systems
- Workshop maintenance applications
- Commercial and light industrial metal surfaces

Suitable for both interior and exterior exposure environments when applied over compatible primer systems.

## | Compatible Substrates

This coating system may be applied over:

- Zinc phosphate primers
- Etch primers for galvanised steel
- Existing aged coatings after compatibility testing
- Properly prepared steel and fabricated metal surfaces

Where maintenance repainting is required, damaged or exposed metal areas should be spot-primed before topcoat application.

## | How to Apply

### Surface Preparation

- Remove all grease, oil, dirt, salts, and loose contaminants before coating,
- Abrade glossy or weathered coatings to promote adhesion,
- Ensure substrate is dry and free from surface contamination prior to application,
- Galvanised substrates should be treated with a suitable etching primer before top coating,
- Ensure repaired or exposed steel areas are appropriately primed.

### Recommended Application Methods

- Conventional spray
- Airless spray
- Brush or roller for small areas and touch-up work
- Temperature: 10°C – 40°C
- Relative Humidity: Below 85%
- Thinner: Toluene / Xylene blend
- Equipment cleaning: Same as thinner

### Storage Conditions

Store in a cool, dry, and well-ventilated area away from direct sunlight and sources of ignition. Recommended storage temperature: 5°C – 35°C.

Property	Typical Value
Flash Point	Approx. -3°C
Dangerous Goods Classification	Flammable Liquid
Storage Conditions	Cool, dry, ventilated area

### Shelf life

12 months in unopened original containers under recommended storage conditions

## Health & Safety

Use only in well-ventilated areas. Wear appropriate PPE during application. Keep away from heat, sparks, and open flames. Refer to SDS before use.

## Environmental Information

- Prevent coating materials and solvents from entering waterways or drainage systems.
- Dispose of waste coatings and solvents according to local environmental regulations.
- Clean application equipment using approved handling and disposal procedures.

## | Important Notes

- Do not add any water.
- Do not apply Alka 410 on any substrates where significant vapor pressure may occur.
- Always ensure good ventilation when using Alka 410 in a confined space.
- Freshly applied Alka 410 should be protected from damp, condensation and water for at least 24 hours.
- If in doubt about the use or application of this product, or further information please contact our Alka Technical Department.
- Avoid contact with skin and eyes.
- Wear protective gloves and eye protection during work.
- If skin contact occurs, wash skin thoroughly.
- If in eyes, hold eyes open, flood with warm water and seek medical attention without delay.
- Avoid contact with foodstuffs and utensils.

A full Material Safety Data Sheet is available from Alka on request.

Property	Value
Appearance	High Gloss
Colours	Standard industrial colours and custom shades
Surface Hardness	Medium
Solvent Resistance	Moderate
Dry Film Condition	Inert after full cure
Recommended Reducer	Industrial enamel thinner
Recommended Thinning	Up to 10%
Theoretical Coverage	Approx. 10 m <sup>2</sup> /L @ 40 µm DFT
Initial Surface Dry	Approximately 15 minutes
Recoat Window	Approximately 8 hours
Gloss Level	Greater than 85 GU @ 60°

#### Performance Notes:

- Actual spreading rate depends on surface texture, film build, and application losses.
- Increased coating thickness or adverse weather conditions may extend drying times.

All products are subject to Alka terms and conditions. Read the full version on our website prior to any purchase.

#### | Contact us

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