

Guidelines

Airless Spray Gun & Nutech Paint Systems

Nutech manufactures a wide variety of solvent and water based paint systems comprising undercoat and top coatings. The viscosity of these coatings varies significantly and consideration needs to be given to the correct selection of airless spray gun tip sizes.

The table on page 2 provides a guide as to the correct tip size for various Nutech products.

Spray gun and spray tip manufacturers commonly refer to the tip size in the following manner e.g. 123521 or just 521.

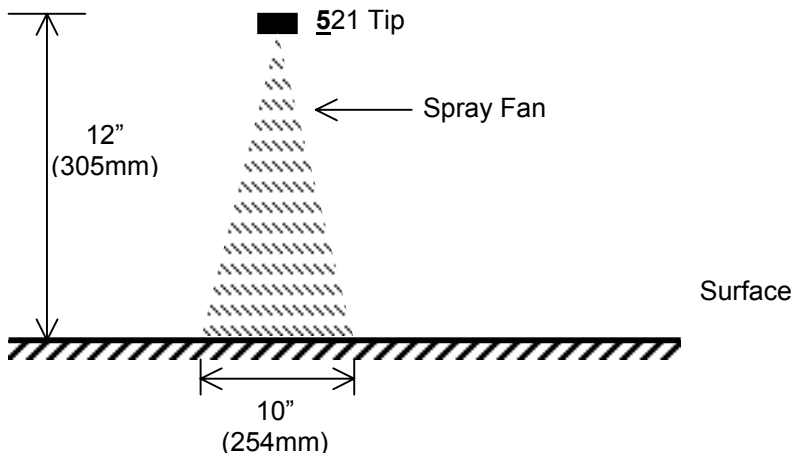


Code Number

This number is usually printed on the side of the tip. This number is not relevant and is not used by some companies, i.e Wagner. The last three numbers of the code are relevant and relate to the spray fan and tip aperture.

Spray Fan

The first number of the last three numbers refers to the spray fan measured in degrees. The **5**21 Wagner tip has a 50° spray fan. The **3**21 Wagner tip has a 30° spray fan as indicated in the diagram below. As a rough guide double the first number. This number represents the width of the fan approximately 12" from the surface.



5 x 2 = 10" fan when the spray tip is 12" above the surface

Spray Aperture

The last 2 digits of the tip number refer to the aperture size. A **521** tip has a 21 thousandth of an inch aperture.

When applying paint with an airless spray gun, wind and technique can result in as much as 30% to 50% product wastage as overspray.

This is not taken into consideration by many applicators and actual dry film thickness can be substantially less than anticipated due to product loss in this situation.

For example, an application may apply 2 coats of acrylic top coat at 4 square metres per litre per coat. This theoretically results in 500 microns wet film build. NuFlex has 38% solids and the dry film build should therefore be 190 microns thick. However, if 30% is lost during application, the dry film build will only be 133 microns thick.

In very strong wind resulting in 50% overspray the dry film may be reduced to as low as 95 microns. This is a significant factor because 95 microns is considered marginal as a roof coating. A coating of 190 microns is a very good coating thickness, which will provide many years of durable service.

We strongly recommend that you contact your nearest Nutech office if you require any technical advice regarding airless spray application of any Nutech product.

Recommended Tip Sizes for Nutech Products

<u>Product</u>	<u>Recommended Tip Size</u>
<u>Roof Products</u>	
Nuprime	517 – 521
Master Sealer	519 – 521
GP Primer	523 – 525
ColourFast	519 – 521
NuFlex	519 – 521
TileFlex 2000	521 – 523
Anti Corrosion Metal Primer	523 – 525
Asbestos Sealer	519 – 521
Insulguard	531
<u>Solvent Products</u>	
Accopol 847	517 - 519
Terra Glaze	517 - 519
Silicon Sealer	515 - 517
PaveCoat	517 - 519
PR-100	517 - 519
SO2000	517 - 519
NuBond	519 - 521
<u>Architectural Paints</u>	
Interior/Exterior 100% Acrylic Low Sheen Paint	515 -517
Timber Coat	515 - 519
Flexible Membrane	525 - 531
Ceiling Paint	515 - 519
Timber & Plasterboard Primer	515 - 519
Fence Paint	515 - 519
SS Membrane	521 - 525