

#### DESCRIPTION

One Stroke Lettering Enamel is an extremely high hiding, high gloss paint specially formulated to meet the requirements of the sign industry for an easy working, one stroke enamel. These paints are designed to flow nicely, dry to a clean edge and leave no brush marks. With brilliant colors, One Stroke Lettering Enamels feature excellent gloss and superior durability with outstanding fade resistance for a beautiful, long-lasting finish.

#### RECOMMENDED USES

Hand-lettering, pinstriping and other graphics on interior or exterior billboards, signs, vehicles and other surfaces.

#### SURFACE PREPARATION

All surfaces must be clean, free from loose or peeling paint, grease, oil, dirt, rust, mill scale and other contaminants. If this procedure is not observed, the drying and adhesion of any coating will be adversely affected.

**Previously Painted Surfaces:** Dull gloss areas by light sanding to enhance adhesion. If necessary, prime with Ronan Sticktite White or Prime-All.

**Metal Surfaces:** Remove loose rust and scale with a wire brush, steel wool and/or sandpaper. All oil, grease and contamination must be removed. Acidic or alkaline surfaces should be neutralized. Prime with Ronan Universal Primer.

**Galvanized Metal and Aluminum:** Surface should be wiped with solvent to remove oil and grease. A mild solution of phosphoric acid should be used for etching to assume a good bond. If acids are not available slight surface sanding will be beneficial. Prime with Ronan Universal Primer.

**Concrete:** A white powdery deposit (efflorescence), often found on concrete and masonry surfaces should be completely removed with a stiff wire brush. New concrete should set four (4) to six (6) weeks before coating. All concrete surfaces should be etched with a solution of four (4) parts water to one (1) part muriatic acid. Let solution soak on surface for 15 minutes before rinsing with clean water. Allow 48 hours to dry before painting. Primer with Ronan Prime-All.

**MDO Plywood:** Clean surface to eliminate oil, grease and other contaminants. Prime face with Prime-All. All edges should be puttied and then primed with two coats of Ronan Prime-All.

**Masonite:** Clean surface to eliminate oil, grease and other contaminants. Prime with Prime-All.

**Vinyl Surfaces:** Pretreat by wiping with xylene or alcohol to help adhesion. Allow to dry completely before painting. Prime with Ronan Vinyl Cote. Note: Because of the many different types of vinyl on the market, it is recommended that each coating be tested on each type before using. To test apply the recommended primer and/or finish coat, let dry fully (8 hours). Apply a piece of tape to the coated area, then remove tape. If coating does not lift when tape is removed, then it is suitable for use for that type of vinyl.

**Fiberglass, Glass, Ceramic, Other Glossy Surfaces:** Solvent wipe to eliminate oil, grease, etc. Slight sanding of surface will be beneficial. Prime with Ronan Prime-All.

#### APPLICATION

Follow surface preparation instructions. Stir thoroughly before use. Use any good quality bristle brush. May also be applied by roller with 1/2" lambs wool or 1/4 - 1/2" synthetic cover. Keep the roller wet. Roll in one direction, rewet, then cross roll.

# TECHNICAL DATA SHEET—PAGE 2

## ONE STROKE LETTERING ENAMEL

<b>THINNING</b>	Do not thin under normal conditions. To create transparent colors mix Sign Finishing Clear into the Bulletin Enamel.
<b>TINTING</b>	All One Stroke Lettering Enamels may be intermixed for different shades, tints and tones.
<b>CLEAN UP</b>	Mineral Spirits
<b>DRY TIMES</b>	At 70°F and 50% relative humidity, Lettering Enamel will be dry to touch in three (3) to four (4) hours. Wait six (6) to eight (8) hours to handle and twelve (12) hours to recoat. Wait seven (7) days for a full cure. Dry times may take longer in cooler and/or more humid conditions.
<b>APPLICATION CONDITIONS</b>	Minimum temperature: 50°F Maximum temperature: 95°F Maximum humidity: 90%
<b>FINISH</b>	Gloss (90+ measured at 60°)
<b>WEIGHT PER GALLON</b>	Varies by color, 7.8—10.9 lbs (approximate)
<b>SOLIDS %</b>	Varies by color, 52.9—69.4% by weight
<b>VISCOSITY</b>	72-80 KU at 75°F
<b>THEORETICAL COVERAGE</b>	Approximately 400 square feet at 4 mils wet
<b>SPREAD RATE</b>	642 square feet @ 1 mil dry
<b>FLASH POINT</b>	105°F
<b>PACKAGING</b>	US Gallon (128 fl oz), 4/case US Quart (32 fl oz), 6/case US Pint (16 fl oz), 6/case US Half Pint (8 fl oz), 24/case
<b>STORAGE TEMPERATURE</b>	Minimum: 40°F Maximum: 95°F
<b>SHELF LIFE</b>	Two (2) years
<b>VOC INFO</b>	Varies by color but will not exceed 450 grams/liter
<b>CAUTIONS</b>	Read Safety Data Sheet and/or all warnings on the label before handling or using this product.
<b>PRODUCT WARRANTY</b>	All recommendations for the use of Ronan products are based on tests and experience believed to be reliable. It is the responsibility of the purchaser to determine the suitability of this product for its intended use. Since the methods of use, conditions of application and the application itself are beyond the manufacturer's and seller's control, product warranty is restricted to replacement of defective materials only. No other warranty, written or oral, is expressed or implied.
<b>REVISION DATE</b>	July 1, 2018