

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 37 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, windows 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. Any rust left on the surface could cause adhesion failure. All oil, grease and contamination must be removed. For best results, treat with a mild phosphoric acid solution. Acidic or alkaline surfaces should be neutralized. Prime with Ronan Universal Metal 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 ensure a good bond. If acids are not available slight surface sanding will be beneficial. Following sanding by priming with Ronan Universal Metal 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. Prime with Ronan Prime-All.

MDO Plywood: Clean surface to eliminate oil, grease and other contaminants. Prime face with Prime-All or Sticktite White. All edges should be puttied and then primed (two coats).

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, if possible. Prime with Ronan Prime-All.

APPLICATION

Follow above surface preparation instructions. Stir thoroughly before use.

Use any good quality bristle brush designed for hand-lettering or pinstriping.

May also be applied by roller. Use 1/2" lambs wool or 1/4 - 1/2" synthetic roller cover. Keep the roller wet. Roll in one direction, rewet, then cross roll. Do not reduce for application by roller.

May also be applied by spray gun or airbrush (reduce with Ronan Low-Temp Reducer, R-722, or High-Temp Reducer, R-724).

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ONE STROKE LETTERING ENAMEL

THINNING	If reduction is desired for brush application, add up to 5-10% Reducer. Use Low-Temp Reducer (R-722) under 75°F. Use High-Temp Reducer (R-724) above 75°F. For spray applications, reduce by up to 20-25%.
FLOW ENHANCER	F-440 Flow Enhancer may be used in place of Reducer. This additive extends open time, reduces drag and eliminates brush strokes for a beautiful finish when hand-lettering or pinstripping. For best results, add several drops into an ounce of One Stroke Lettering Enamel or Outdoor Bulletin Enamel color, then stir well before palleting the brush. Do not add Flow Enhancer when spray-applying enamel color.
ENAMEL HARDENER	Use H-100 Enamel Hardener when applying pinstripping, lettering or other art that will be topcoated with an automotive-grade clearcoat. Hardener increases gloss and durability in Ronan's One Stroke Lettering Enamels, Outdoor Bulletin Enamels and other similar paints, while also cutting dry and cure times. Add in up to 10% Hardener, then stir well before use. Wait 24 hours (at 70°F) before topcoating with a clear. Apply two light coats of clear and allow to dry hand-slick before following with subsequent coats as normal, according to the clearcoat manufacturer's recommendations. Beware that enamel paint will have a limited pot life (about 2-3 hours working time) once Hardener is added.
JACK'S CREAM	Jack's Cream is a heavy-bodied blending medium. Use this to extend open times and allow for the blending of different colors in Ronan's One Stroke Lettering Enamel, Outdoor Bulletin Enamel and other similar paints.
ALKYD FLATTENING PASTE	Use M6997 Alkyd Flattening Paste to reduce the gloss in Ronan's One Stroke Lettering Enamel and Outdoor Bulletin Enamel colors. Use up to one quart of M6997 for each gallon of paint.
TINTING	All One Stroke Lettering Enamels may be intermixed for different shades, tints and tones.
CLEAN UP	Mineral Spirits or Ronan Enamel Reducer (R-722, R-724).
DRY TIMES	At 70°F and 50% relative humidity, Ronan 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.
APPLICATION CONDITIONS	Minimum temperature: 50°F Maximum temperature: 95°F Maximum humidity: 90%
FINISH	Gloss (90+ measured at 60°)
WEIGHT PER GALLON	Varies by color, 7.8—10.9 lbs (approximate)
SOLIDS %	Varies by color, 52.9—69.4% by weight
VISCOSITY	72-80 KU at 75°F
THEORETICAL COVERAGE	Approximately 400 square feet at 4 mils wet
SPREAD RATE	642 square feet @ 1 mil dry
FLASH POINT	105°F
PACKAGING	US Gallon (128 fl oz), 4/case US Quart (32 fl oz), 6/case US Pint (16 fl oz), 24/case US Half Pint (8 fl oz), 24/case US Quarter Pint (4 fl oz), 30/case
STORAGE TEMPERATURE	Minimum: 40°F Maximum: 95°F
SHELF LIFE	Two (2) years
VOC INFO	Varies by color but will not exceed 450 grams/liter
CAUTIONS	Read Safety Data Sheet and/or all warnings on the label before handling or using this product.
PRODUCT WARRANTY	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.
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