

TECHNICAL DATA SHEET

Date of issue: 28/04/2016

Last updating: n.6 12/10/2017



Name: ACRYLAC CLEAR, GLOSS

Definition: Acrylic clear

Code: 60.1.00001

Category: Top coat

V.O.C. ready to use: 630 g/l

Product outside the uses referred to
2004/42/CE

NATURE OF THE PRODUCT

Two-pack topcoat, based on acrylic resins and not yellowing isocyanate adduct to mix before use.

GENERAL USES

Protective product for general use. Fit for iron, galvanised sheet, aluminium and light alloys.¹

PREPARATION OF SURFACES

The cleaning of the application surface should be painstaking and it is a fundamental condition to obtain a positive result of the painting cycle. This means that presence of grease, oils, rust and calamine on the surfaces, is absolutely not allowed.

- Ferrous surfaces: SA2 1/2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents.
- Galvanised sheet: accurate sanding by using scotch brite coarse grain, then degreasing with solvents.
- Aluminium: light sanding followed by careful degreasing with organic solvents. Considering the large variety of surfaces, we recommend performing some preliminary tests.
- Glass: by adding the additive 03.029 the products has excellent performances even on glass.

PREPARATION OF THE PRODUCT

	Code	Name	By Weight	By Volume
Component A	60.1.00001	Acrylac clear, gloss	100 parts	100 parts
Component B	01.014	Polirex Not yellowing hardener	33 parts	33 parts

Carefully mix until an even consistency is obtained. For standard airmix application dilute with 07.013 acrylic thinner at 20% to obtain a viscosity of 15-20" Ford 4.

APPLICATION

Spray gun: nozzles of 1,4-1,7 mm. diameter and 3-5 atm. pressure.

Elettrostatic: suitable

Roller or brush²: Only for small surfaces.

TECHNICAL DATA

PRODUCT TYPE: Two pack product.

FILM APPEARANCE (ASTM D 523): Glossy, 92±5 gloss

COLOURS: Transparent

SPECIFIC WEIGHT (ISO 2811): A+B 0,98 kg./l (± 0,05)

SUPPLY VISCOSITY (DIN 53211): 25" (± 5") Ford 4

¹ Considering the large variety of surfaces, we recommend performing some preliminary tests.

² You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools.

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SOLID ON VOLUME:	A + B 42% ($\pm 2\%$)		
SOLIDS CONTENT:	A + B 42% ($\pm 3\%$).		
DRYING AT 20°C	- Dust dry:	20-30 minutes	
	- Touch dry:	2-4 hours	
	- Total hardening :	24 hours	
	- Forced drying	30 minutes at 60-80° C	
	- Maximum chemical resistance:	After 7 days	
RECOMMENDED COATS:	One or two		
THICKNESS:	40-50 μm		
THEORETIC YIELD ³:	10-12 m ² /kg.		
POT-LIFE AT 20° C:	3 hours. At higher temperatures, pot-life decreases.		
ADHESION (ASTM D 3359):	B=5 on surfaces treated like above reported		
IMPACT TEST (ASTM D 2794):	36 kg direct, 15 kg inverse on sanded iron		
YELLOWING (ASTM D 4587):	after 3000 hours, $\Delta E < 5$		
CHEM. RESIST .⁴ (UNI EN ISO 12720):			
	HCl solut. 10%	vote 4	7 days
	HNO ₃ solut. 10%	vote 2	5 days
	H ₂ SO ₄ solut. 10%	vote 5	7 days
	Acetic acid solut. 10%	vote 4-3	7 days
	Mix of NaCl 10%, Lactic acid 5%	vote 5	7 days
	Synthetic sweat	vote 5	7 days
	H ₂ O ₂ 35%	vote 1	2 days
	NH ₃ solut. 30%	vote 5	7 days
	NaOH solut. 10%	vote 5	7 days
	Acetone	vote 4-3	7 days
	Cyclohexanone	vote 1	2 days
	Solvent naphta	vote 5	7 days
	Ethyl acetate	vote 3	7 days
	Ethanol	vote 5	7 days
	Synthetic oil	vote 5	7 days
	Idraulic oil	vote 5	7 days
	Transmission oil SAE 30	vote 5	7 days

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

⁴ The quality of chemical resistance goes from a value of 5 (means optimum) to 1 (means not good). For further information, please contact Siro's technical service.

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Cutting oil	vote 5	7 days
Unleaded gasoline	vote 5	7 days

REPAINTING:

After 6 hours. If complete hardening of the film occurred, it is better a light sanding before overcoating.

STORAGE STABILITY:

One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.