

TECHNICAL DATA SHEET

Date of issue: 22.11.2000

Last updating: N° of 19.02.13



Name:	CLEAR SEMIGLOSSY ACRYLAC	Category:	Special finishing
Definition:	Poly-acrylic two-pack enamel	V.O.C. ready to use:	670 g/l
Code:	60.2.00001	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Two-pack acryl-urethane topcoat, based on acrylic resins and isocyanic adduct to mix before use.

GENERAL USES

Product for general use, furniture, machines tools, coach work, industrial applications, plastics, aluminium and galvanized sheets coatings, etc.

APPLICATION METHOD

PREPARATION OF SURFACES

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

Ferrous surfaces. SA2 sandblasting or very careful mechanical cleaning followed by degreasing using thinners, then proceed with the application of the cycle.

Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners.

Galvanized sheet. Delicate sanding followed by degreasing using thinners.

Kind of primers suggested: polyurethane primers like 69.3 or epoxy primer 29.3 or 29W5.

The product can be applied on direct adhesion, but for outdoor applications, to guarantee an higher corrosion resistance is better to use the suggested primers.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	60.2.00001	Semimatt clear Acrylac	100 parts	100 parts
Component B	01.014	Not yellowing Polirex	20 parts	20 parts
alternative ¹	01.012	Slow not yellowing Polirex	20 parts	20 parts

Carefully mix until an even consistency is obtained. For standard airmix application dilute with 07.013 acrylic thinner in a percent of 20% to obtain a viscosity of 16-20" Ford 4 .

APPLICATION

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

Roller or brush²: Only for small surfaces.

¹ When temperature goes above 25°C it is possible to have some overspray problems. To solve this this hardner in combination with slow thinner 07.030 are suggested.

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

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TECHNICAL DATA

PRODUCT TYPE: Two pack product.

FILM APPEARANCE (ASTM D 523): Semiglossy, 65-80 gloss depending on the quality of the surface to be painted and the dilution..

COLOURS: Transparent

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

SUPPLY VISCOSITY (DIN 53211): 24" Ford 4 a 25°C. ($\pm 5''$)

SOLID ON VOLUME: A + B 39% ($\pm 2\%$)

SOLIDS CONTENT: A + B 39% ($\pm 3\%$).

DRYING AT 20°C

- Dust dry:	10-20'	- Touch dry:	2 hours
- Total hardening :	24 hours	- Forced drying	30' at 80°C.

- Maximum chemical resistance: 7 days

RECOMMENDED COATS: One-two

THICKNESS: 40-60 μm

THEORETIC YIELD³: 10-12 mq/kg.

POT-LIFE AT 20°C: 2 hours. At higher temperatures, pot-life decreases.

CHEMICAL RESISTANCES **Double pass with soaked cotton bowl with the specific substance**

Ethyl alcohol	50 double pass	No variation at all
Acetone	10 double pass	No variation, over 10 start to soften

REPAINTING: After 4 hours or after the complete hardening of the film, 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.

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