

TECHNICAL DATA SHEET

Date of issue: 14/12/2021

Last updating: n°1 22/12/2021



Name:	ACRYLAC GLOSS WHITE	Category:	2K high performance Alj enamel
Definition:	Two-pack acrylic enamel	V.O.C. ready to use:	500 g/l
Code:	60.1.90130	V.O.C. limit:	500 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

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

GENERAL USES

Product for high quality applications on machines tools, operating and agricultural machines, furniture and plastics.

Suitable for use with direct adhesion on metals and plastics. Considering the variety of commercially available materials, we strongly recommend doing preliminary tests¹. To improve the adhesion on metal we suggest acid washing with our SLOW ACID THINNER 07.044 and diluting the product with the same thinner.

Applied on epoxy primer **EPOFIX GREY** (code 29.3.70121), the product is suitable for contact with food, for coating surfaces intended for food processing or for containing drinking water.

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 the presence of grease, oils, dirty, 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.
- **Galvanized sheet:** accurate sanding by using scotch brite coarse grain, then degreasing with solvents. Otherwise, accurate degreasing with our QUICK ACID THINNER 07.115 or our SLOW ACID THINNER 07.044, and final cleaning with QUICK SILICONE REMOVER 07.051. The use of acidic thinners such as 07.044, slow, and 07.115, quick, improve greatly the adhesion performance on this surface, especially if, contrary to what is specified above, it has been sanded short before.
- **Aluminum:** accurate sanding followed by careful degreasing with our QUICK ACID THINNER 07.115 or our SLOW ACID THINNER 07.044, and final cleaning with QUICK SILICONE REMOVER 07.051. When it is not possible to sand the surface, the use of acids thinners such as 07.044, slow, and 07.115, quick, improves greatly the adhesion performance on this surface.
- **Plastics²:** elimination of any molding release agents. Sanding with brown scotch brite followed by accurate degreasing with suitable solvents.

If the use of a primer is required, we recommend **ACRYDUR series 69.3**, **EPOFIX series 29.3**, **BASIC 2 series 69.4**. Follow the surface preparation instructions reported in the technical sheet of the selected primer.

¹ To improve the adhesion on metal we recommended using the additive 03.040 at 3-5% (calculated by weight on the product without hardener, an excess can give a slight haze in the gloss colours).

² Considering the big variety of plastics, we recommend performing some preliminary tests.

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PREPARATION OF THE PRODUCT

	Code	Name	By Weight	By Volume
Component A	60.1	Acrylac gloss	100 part	100 part
Component B	01.014	Polirex NY	33 parts	35 parts
As an alternative	01.012	Polirex NY slow	33 parts	35 parts

Carefully mix until an even colour and consistency are obtained. For standard airmix applications, dilute with our POLYURETHANE THINNER 07.013 at maximum 5% (for temperatures over 25°C we suggest using the SLOW POLYURETHANE THINNER 07.030 and the SLOW HARDENER 01.012).

For food contact applications, reduce the dilution to 5-8%.

APPLICATION

Spray gun: nozzles of 1.4-17 mm diameter and 3-5 atm pressure

Electrostatic spray gun: suitable

Roller or brush: only for large surfaces³

TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE (ASTM D 523): Gloss, 90±5 gloss

COLOURS: White

SPECIFIC WEIGHT (ISO 2811): 1.18 ± 0.05 Kg/lit (A+B)

SUPPLY VISCOSITY (DIN 53211): 15" ± 3" Ford 8

SOLID ON VOLUME: 44 ± 2% (A+B)

SOLIDS CONTENT: 50 ± 3% (A+B)

DRYING AT 20°C

- Dust dry: 15-20 minutes
- Touch dry: 2 hours
- Total hardening : 24 hours
- Forced drying 30-40 minutes at 60-80°C
- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One light coat and one standard coat

RECOMMENDED THICKNESS: 40-50 µm

THEORETIC YIELD: 8-10 m²/kg

POT-LIFE AT 20° C: 6 hours. At higher temperatures, pot-life decreases

³ You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools

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FOOD CONTACT CERTIFICATION:

The product hardened with POLIREX hardener 01.014 and applied over EPOFIX GREY epoxy primer 29.3.70121 (hardened with EPOREX for 29.3, code 02.150) was tested according to the migration tests of DM 06/04/04 n°174 and of the Regulation CE N.1935/2004. The test results comply with these standards, therefore it is suitable for contact with food and drinking water.

SALT SPRAY TEST (ASTM B 117): - 150 hours if applied DTM with a final dried film thickness of 50µm.
- 500 hours if applied over epoxy primer 29.3.70121 or acrylic primer 69.3.R7035 with a final film thickness of 120-140µm.

ADHESION (ASTM D 3359): B=5 on surfaces treated like above reported

IMPACT TEST (ASTM D 2794): 36 kg direct on sanded iron

YELLOWING (ASTM D 4587): after 1000 hours, $\Delta E < 3$

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	3 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
Solvelso 100	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
Engine oil 15W40	vote	5	7 days
Unleaded gasoline	vote	5	7 days

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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REPAINTING: After minimum 6 hours. After total hardening, it is better a light sanding before overcoating.

For food contact applications, overcoat after 24 hours.

STORAGE STABILITY: Eighteen months for A component, twelve months for B component, stored in closed packs, in a cool, dry place, away from any sources of heat.