

TECHNICAL DATA SHEET

Date of issue: 29/07/2014

Last updating:n°3 27/07/2015



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Name:	ACRYPLAST BUMPER	Category:	Special finish
Definition:	1K acrylic enamel	V.O.C. limit:	840 g/l
Code:	48.3 – 48.3T	V.O.C. ready to use:	720 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

One-pack very quick drying enamel based on acrylic resins.

GENERAL USES

Painting of plastic surfaces like ABS, polyamide, PMMA-plexiglass, PUR and PP bumpers.

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.

We always suggest a preliminary slight scratching with scotch-brite, then proceed degreasing with organic thinners to remove any possible trace of grease, dust and humidity.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. Dilute with our acrylic thinner 07.013 or 07.019 in a percent of 30% to obtain a viscosity of 20-25" Ford 4.

APPLICATION

Spray gun: nozzles of 1,2-1,4 mm. diameter and 3-5 atm. pressure.

Roller or brush: Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: monocomponent

FILM APPEARANCE Matt, 6 Gloss (± 3) in the T version the product is texturized.
(ASTM D 523):

COLOURS: Black (48.3.90128 – 48.3T90128) and anthracite (48.3.70250 – 48.3T70250)

SPECIFIC WEIGHT 1,02 kg/l ($\pm 0,05$)
(ISO 2811):

SUPPLY VISCOSITY 15" Ford 8 at 20°C (± 3)
(DIN 53211):

SOLID ON VOLUME: 31% ($\pm 2\%$)

SOLIDS CONTENT: 32% ($\pm 2\%$)

DRYING AT 20°C	- Dust dry:	10-15'	- Touch dry:	30'
	- Total hardening :	12 h	- Forced drying ¹	15-20' at 50-60°C

RECOMMENDED One crossed coat

¹ Baking the product can change the final gloss result, it could result more matt

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COATS:

THICKNESS²: 20-30 µm

THEORETIC YIELD³: 8-10 m²/kg

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

REPAINTING: With the same product after at least 24 hours.

STORAGE STABILITY: One year in closed packs, stored in a cool, dry place, away from any sources of heat.

² Considering a dry film.

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