

TECHNICAL DATA SHEET

Date of issue: 19/02/2013

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Name:	ALUCHROME	Category:	Base coat
Definition:	Chrome effect basecoat	V.O.C. ready to use:	870 g/l
Code:	082.100	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Metallic aluminium particles dispersed in a one pack solvent based base coat.

GENERAL USES

Fancy goods, furniture, handicrafts, bicycle, motorcycle, car interiors, alloy wheels, 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.

The product has always to be applied over a 2k glossy system like our glossy enamel 60.1 or 62.1, black color is the most indicated for the best chrome effect.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the base enamel (60.1 or 62.1), or, if preferred, with the application of a primer and then the cycle of application for 082.100.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the direct application of the base enamel and go on with the application cycle for 082.100.
- Galvanized sheet. Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the base enamel and go on with the application cycle for 082.100.
- Plastick substrates : elimination of any mold release. Sanding followed by thorough degreasing with suitable solvents. Then proceed with the direct application of the base enamel and go on with the application cycle for 082.100.

The 2k glossy base (60.1 or 62.1) has to be passed in oven at 40-50° for 10-15' (or 30'-1 hour at the air), and then cleaned carefully in a way to remove any trace of dust or fingerprints. Then after drying the 082.100 for 20-30' at 25-35°C (or 30'- 1 hour at 20 °C), proceed with the application of the transparent like our 61.1.X30 or 61.1.X5. Apply half coat of transparent, wait 10-15' at 20°C and then apply a full coat of transparent, this procedure to avoid to remove the 082.100 just applied and lose part of the chrome effect.

PREPARATION OF THE PRODUCT

Carefully mixing until an even colour and consistency are obtained; Dilute with 70-100% of our acrylic thinner 07.013 or 07.093 and then apply the product fading slightly. If you apply too much product the aluminum will "drown" and you'll lose the chrome effect. With dilution to 200%, on glossy black supports, the chrome effect is highlighted because aluminum particles have better disposition because of the high dilution that prevents the application of too much product.

APPLICATION

Spray gun: nozzles of 1,1-1,3 mm. diameter and 1-1.5 atm. pressure.

TECHNICAL DATA

PRODUCT TYPE: Monocomponent

¹ A preliminary adhesion test is suggested due to the big variety of plasick support on the market.

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APPEARANCE (ASTM D 523): Semimatt (50±10 gloss).

COLOURS: Chrome effect

SPECIFIC WEIGHT (ISO 2811): 0,84 kg/l. (± 0,03).

SUPPLY VISCOSITY(DIN 53211): n.d.

SOLIDS CONTENT: 4 % (± 2%)

DRYING AT 20°C	- Dust dry:	3-5'	- Touch dry:	15'
	- Total hardening :	10-15' at 60°C		

RECOMMENDED COATS: One

THICKNESS²: 5-10 µm

THEORETIC YIELD³: 15 m²/kg

REPAINTING: After 30' at 20°C or 10-15' at 60°C.

STORAGE STABILITY: 1 year, stored in closed packs, 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.