

TECHNICAL DATA SHEET

Date of issue: 21/03/2016

Last updating:n°1 31/03/2016

Name:	1K ACRYLIC ENAMEL	Category:	Monocomponent enamel
Definition:	Acrylic enamel with direct adhesion	V.O.C. ready to use:	650 g/l
Code:	48.1	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Product based on acrylic modified resins that are able to give adhesion on a wide range of substrates, metallic and plastics¹.

GENERAL USES

Product for general use, specific for protection of zinc plated, aluminium and light alloys constructions or artefacts. The product can also be used as aerosol and filled into pre-charged spray cans.

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.

Remove all traces of grease, rust, moisture, fingerprints and polishes by degreasing with organic solvents.

- Ferrous surfaces very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if particular corrosion resistances are requested, of a primer like 79.2 or 29.3 and then the topcoat..
- Aluminium. Chromate or phosphorous chromate treatment or in alternative delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product.
- Galvanized sheet. Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product.

PREPARATION OF THE PRODUCT

Carefully mix until an even consistency is obtained. For standard airmix application dilute with 10% b.w. of our acrylic thinner 07.013, when temperature is over 25°C slow acrylic thinner 07.030 is suggested.

APPLICATION²

Spray gun: nozzles of 1,2-1,5 mm. diameter and 2.5-5 atm. pressure.

Brush/roller Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: One pack product.

APPEARANCE³ (ASTM D 523): glossy (88±5 gloss).

¹ A preliminary test is always suggested due to the wide range of plastics and metallic alloys present in the market.

² Minimum temperature for the application: + 10° C.

³ With an high level of humidity and low air ventilation, the film can do a thin white layer.

TECHNICAL DATA SHEET



Date of issue: 21/03/2016

Last updating:n°1 31/03/2016

Name:	1K ACRYLIC ENAMEL	Category:	Monocomponent enamel
Definition:	Acrylic enamel with direct adhesion	V.O.C. ready to use:	650 g/l
Code:	48.1	Product outside the uses referred to	2004/42/CE

COLOURS:	By request (the binder 48.1.K1 is used in ratio 80/20 with the tinters of solvent based tintometric system) ⁴		
SPECIFIC WEIGHT (ISO 2811):	0.99 ± 0.07 kg/l		
SUPPLY VISCOSITY(DIN 53211) :	16" ± 2" Ford 4		
SOLID ON VOLUME:	34 % (± 2%)		
SOLIDS CONTENT:	34 % (± 2%)		
DRYING AT 20°C	- Dust dry:	5-10'	- Touch dry: 30-45'
	- Total hardening :	24 hours	- Forced drying 30' at 60°C
	- Maximum chemical resistance:	After 14 days	
RECOMMENDED COATS:	One crossed coat		
THICKNESS⁵:	20-30µm		
THEORETIC YIELD⁶:	10-12 m ² /kg		
IMPACT TEST (ASTM D 2794):	36 kg direct and 10kg reverse		
ADHESION (ASTM D 3359):	B= 5 on surfaces treated like above reported.		
REPAINTING⁷:	With himself wet on wet or after 24 hours from the first coat.		
STORAGE STABILITY:	One year stored in closed packs, in a cool, dry place, away from any sources of heat.		

⁴ With metallic tinters the final gloss will be lower depending on the amount of metallic tinter used

⁵ Considering a dry film.

⁶ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

⁷ The solvent must be completely flash-off from the film. Preliminary tests are necessary.