

TECHNICAL DATA SHEET

Date of issue: 09.02.2000

Last updating: n°3 27/04/2021



Name: ACRYLAC OFM SEMIMATT

Category: high performances two-pack paint

Definition: acrylic micaceous iron enamel

V.O.C. expected: 550 g/l

Code: 60.3.OFM

V.O.C. ready to use: 500 g/l

Product according to Directive 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

Micaceous iron acrylic topcoat with direct adhesion and anticorrosive properties, suitable for steel products, steel structural works, galvanized sheet metal. Excellent ageing and weathering resistance and stability.

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 on the substrate of substances, such as grease, oils and dirt (and obviously, for other reasons, rust and calamine) is absolutely not tolerated.

- Ferrous surfaces. SA2 ½ sandblasting or very careful mechanical cleaning by sanding to remove rust and calamine, followed by degreasing using aqueous solutions of surfactants or organic solvents.
- Galvanized sheet. accurate sanding with coarse-grain scotch brite, followed by degreasing using solvents.
- Aluminium. Chromate conversion coating or phosphochromate treatment. Alternatively light sanding followed by degreasing using organic solvents.

For applications on iron surfaces, which must be exposed to the outside, in order to increase corrosion resistance, apply a coat of acrylic primer series 69.3 or epoxy series 29.3, while for indoor applications it is possible to apply the product by direct adhesion.

PREPARATION OF THE PRODUCT

			In weight	In volume
Component A	60.3.OFM	Acrylac OFM, semimatt	100 parts	100 parts
Component B	01.014	Polirex NY	20 parts	30 parts
As an alternative	01.012	Polirex NY slow	20 parts	30 parts

Carefully mix until an even colour and consistency are obtained. For airless applications it is not necessary to dilute, for standard applications with airmix dilute with our diluent 07.013 at 15-25%, to obtain a viscosity of 20-25 "Ford 4 (when the temperature exceeds 25° C we suggest the use of slow diluent 07.030 and slow hardener 01.012).

APPLICATION:

- Spray gun use nozzles of 1.4-1.7 mm diameter and 3-5 atm pressure.
- Airless nozzle 0,09 inches, 180-240 bar
- Electrostatic coating: suitable
- Brush or roller: only for large surfaces¹

TECHNICAL DATA

PRODUCT TYPE: Two pack product.

FILM APPEARANCE (ASTM D 523): matt (20±5 gloss)

¹ You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools.

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COLOURS:	Those of the micaceous iron colour card (the 60.3.OFM binder must be used in a 95/5 ratio with the tinters of the solvent base tinting system).
SPECIFIC WEIGHT (ISO 2811):	1,39 ± 0,05 kg/l (Component A only)
SPECIFIC WEIGHT (ISO 2811):	1,33 ± 0,05 kg/l (A + B)
SUPPLY VISCOSITY (DIN 53211):	25" ± 5" Ford 8
SOLID ON VOLUME:	48% ± 2% (A+B)
SOLIDS CONTENT:	65% ± 3% (A+B)
DRYING AT 20°C:	- Dust dry: 20-30 minutes - Touch dry: 2-4 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 then one standard coat.
THICKNESS:	40-50 µm
THEORETIC YIELD²:	8 m ² /kg.
POT LIFE AT 20°C:	6 hours. At higher temperatures, pot-life decreases.
SALT SPRAY TEST (ASTM B 117):	250 hours if apply on direct adhesion with a dry thickness of 80 µm. If applied on an epoxy primer 29.3.70121 or acrylic primer 69.3.F7035 with a final thickness of 120-140 µm, 500 hours.
ADHESION (ASTM D 3359):	B=5, on surfaces treated as described above.
IMPACT TEST (ASTM D 2794):	36 kg direct on sanded iron.
YELLOWING (ASTM D 4587):	after 1000 hours ΔE<3
REPAINTING:	Within 4 hours minimum. 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. Stored in closed packs, in a cool, dry place, away from any sources of heat.

² The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.