

TECHNICAL DATA SHEET



Date of issue: 01/06/2010

Last updating: n°9 23/04/2021

Name: UHS ACRYLIC ENAMEL
Definition: Two-pack acrylic topcoat
Code: 50.1

Category: B/d
V.O.C. ready to use: 420
V.O.C. limit: 420

Product according to 2004/42/CE

NATURE OF THE PRODUCT

Topcoat based on acryl resin and isocyanic adduct to mix before use.

GENERAL USES

Car refinishing, industrial vehicles and vans. General high level aesthetic topcoats, when resistance features are requested.

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the application surface should be painstaking and it is the fundamental condition to obtain a positive result of the painting cycle.

- Ferrous surfaces. SA2 1/2 grade sandblasting. Alternatively, perfect mechanical cleaning of the support by sanding with elimination of rust, calamine followed by degreasing with aqueous solutions of surfactants or with organic solvents. Then proceed with application of the primer and topcoat cycle.
- Galvanized sheet. Careful sanding with scotch brite coarse grain followed by degreasing using thinners. Then proceed with the application of a primer and then the topcoat.
- Aluminium. Delicate sanding followed by degreasing using organic thinners. Then proceed with the application of a primer and then the top coat.

The product requires the application of a primer coat like our 29.3 epoxy primer, 69.3 acrylic primer, 69.4 acrylic primer or 29W5 water base primer.

PREPARATION OF THE PRODUCT

	Code	Name	By weight	By volume
Comp. A	50.1	UHS acrylic enamel	100	100
Comp. B	01.H10T	Acryrex UHS extra plus	25	30
As an alternative	01.H10	Acryrex HS	25	30

Mix carefully until an even colour and consistency are obtained, dilute at 5-20% with our 07.060 extra acrylic thinner or 07.055 medium or 07.075 extra slow, in order to reach a final viscosity of 20-28" Ford 4.

APPLICATION

Airmix: nozzles of 1,2-1,4 mm diameter and 2-2.5 atm pressure.

Roller or brush: Only for small surfaces¹

TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE (ASTM D 523): Glossy (>90 gloss)

COLOURS: By request (the binder 50.1.K1 has to be used in a ratio 70/30 with the solvent tinting system tinters)

SPECIFIC WEIGHT (ISO 2811): (A+B) 1,03 ± 0,05 g/cm³

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SUPPLY VISCOSITY (DIN 53211): 35-45" cup Ford 8 (A comp. only).

SOLID ON VOLUME: 60 ±2%

SOLIDS CONTENT: 65±2%

DRYING AT 20°C: Dust free: 20-30 minutes
Touch free: 3 hours
Total hardening: 24 hours
Forced hardening: 45' at 60°C
Maximum chemical resistance: after 7 days.

RECOMMENDED COATS: One half coat and then one crossed coat.

RECOMMENDED THICKNESS: 60-70 µm

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

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THEORETIC YIELD: 8-10 m²/kg

POT-LIFE AT 20° C: 1,5 hours. At high temperatures, the pot-life decreases.

SALT SPRAY TEST (ASTM B 117): The primer and the top coat cycle (total thickness: 180 µm) allows 500 resistance hours.

UNI EN ISO 12944-6 CERTIFICATION:

When applied on **epoxy primer 29.3.90130** or **acrylic primer 69.3.90150**, the 50.1 topcoat complies with **UNI EN ISO 12944-6** Corrosion protection of steel structures in class C4M, suitable for industrial and coastal areas with moderate salinity (final thickness 180 µm).

ADHESION (ASTM D 3359): B=5 on iron, aluminium and galvanized sheet. These surfaces have to be prepared like above specified.

IMPACT TEST (ASTM D 2794): 36 kg direct 36 kg reverse.

YELLOWING (ASTM D 4587): after 1000 hours, ΔE<4.

CHEM. RESIST .² (UNI EN ISO 12720):

Substance	mark	days
Hydrochloric acid-HCl solut. 10%	4-3	7
Nitric acid-HNO ₃ solut. 10%	4-3	7
Sulfuric acid-H ₂ SO ₄ solut. 10%	5-4	7
Acetic acid solut. 10%	4	7
Mix of NaCl 10%, Lactic acid 5%	5	7
Synthetic sweat	5	7
Hydrogen peroxide 35%	5-4	7
Ammonia solut. 30%	5	7
Sodium hydroxide solut. 10%	5	7
Acetone	5-4	7
Cyclohexanone	1	7
Solvento 100	3	7
Ethyl acetate	5-4	7
Ethanol	5	7
Synthetic oil	5	7

REPAINTING: After minimum 4-8 hours. 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. In closed packs, in a cool, dry place, away from any sources of heat.

² 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.