

TECHNICAL DATA SHEET

Date of issue: 15/03/2019

Last updating: n.



SIRO S.r.l.

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Name:	Brushable synthetic enamel, glossy	Category:	high performances 1K paint
Definition:	Brushable synthetic enamel	V.O.C. limit:	500 g/l
Code:	37.1.K3	V.O.C. ready to use:	450 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

High quality and high resistance anticorrosion 1K glossy enamel. Particularly suitable for new, old or rusty iron surfaces. It can also be applied on wood. The paint film remains elastic and with good adhesion even after a long outdoor exposure.

GENERAL USES

Decorative enamel for furniture, window fixtures, metal structural work, agricultural machinery, etc.

APPLICATION METHOD

PREPARATION OF SURFACES

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

- Ferrous surfaces: remove carefully all traces of grease and moisture by degreasing using thinners. Apply 1 or two coats of primer SIRNOX N 79.2 or 79.4. After about 24 hours, proceed with the application of the topcoat. The synthetic enamel can be used also direct to metal, but in this case it is necessary to apply at least two coats (three is better), by obtaining a dry film thickness of minimum 80 microns.
- Aluminium and zinc plated: to obtain maximum adhesion on this support, the traditional anticorrosive product is replaced with a specific primer like our Sirodour series 49.9. It is recommended to overpaint the primer with the 37.1 as soon as possible (30 minutes - 1 hour).
- Wood: on new woods, apply one or two coats of sealant polyurethane primer or other suitable sealant. After drying of the primer, sand it carefully with abrasive paper and then apply one or two coats of topcoat.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. For brush applications: dilute with our thinner 07.005 at 5-10%. For spray gun applications: dilute maximum at 15%.

APPLICATION

Spray gun: nozzles of 1.4-1.6 mm diameter and 2.5-3 atm pressure.

Brush/roller Following the indicated dilution

TECHNICAL DATA

PRODUCT TYPE: One pack product

APPEARANCE (ASTM D 523): Glossy (85±5 gloss).

COLOURS: By request (the binder 37.1.K3 has to be used in a ratio 80/20 with the tintometric system tinters)

SPECIFIC WEIGHT (ISO 2811): 1.15 ± 0.07 kg/l

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SUPPLY VISCOSITY(DIN 53211) :	35" $\pm$ 5" Ford 8
SOLID ON VOLUME:	56% ($\pm$ 2%)
SOLIDS CONTENT:	64% ($\pm$ 2%)
DRYING AT 20°C	- Dust dry: 2 hours - Touch dry: 6 hours - Total hardening : 24-36 hours - Maximum chemical resistance: After 14 days
RECOMMENDED COATS:	One or two
THICKNESS ¹:	40-80 μ m
THEORETIC YIELD ²:	8-10 m ² /kg
IMPACT TEST (ASTM D 2794):	36 kg direct on scratched iron
ADHESION (ASTM D 3359):	B=5 on surfaces treated like above reported.
REPAINTING³:	The product can be repainted wet on wet or within 2 weeks with himself. Use only thinners based on white spirit or with a low content of aromatic solvents.
STORAGE STABILITY:	One year, stored in closed packs, in a cool, dry place, away from any sources of heat.

¹ Considering a dry film.

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

³ The solvent must be completely flash-off from the film. Preliminary tests are necessary.