

TECHNICAL DATA SHEET

Date of issue: 26.01.2009

Last updating: n°10 18.01.2023



Name: ACRYLAC INDUSTRIAL DTM
ENAMEL, SEMI-MATT

Category: two-pack high performance A/J product

Definition: Industrial acrylic 2K enamel

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

V.O.C. limit: 500 g/l

Code: 62.3

Product according to 2004/42/CE

NATURE OF THE PRODUCT

Two-pack acryl-urethane topcoat, based on hydroxylated acrylic resins and aliphatic isocyanic adduct to mix before use.

GENERAL USES

Product for general use, furniture, machines tools, coachwork, industrial applications, concrete coatings, doors and windows frames, plastics.

Suitable for direct adhesion applications on metals¹ and plastics

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.

The product can be applied with direct adhesion without a primer application².

To improve adhesion on metal, it is recommended to wash the surface with SLOW ACID THINNER code 07.044, and to dilute the product with the same thinner.

- Ferrous surfaces: SA2 1/2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents.
- Galvanized sheet: accurate sanding by using scotch brite coarse grain, then degreasing with solvents. Alternatively, accurate degreasing with our thinner 07.115 or 07.044, and final cleaning with silicone remover 07.051. The use of acidic thinners such as 07.044, slow, and 07.115, fast, greatly improve the adhesion performance on this surface.
- Aluminium: Accurate sanding followed by careful degreasing with our thinner 07.115 or 07.044, and final cleaning with silicone remover 07.051. When it is not possible to sand the surface, the use of acids thinners such as 07.044, slow, and 07.115, fast, greatly improves the adhesion performance on this surface. Nevertheless, we suggest testing the adhesion on a sample before proceeding with large applications.
- Plastics³: elimination of any molding release agents. Sanding with brown scotch brite followed by accurate degreasing with suitable solvents.

If conditions require the use of a primer, we recommend: Acrydur 69.3 series, Epofix 29.3 series, Basic 2 69.4 series. Follow the surface preparation instructions given in the TDS of the selected primer.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	62.3	Acrylack DTM industrial, semimatt	100 parts	100 parts
Component B	01.014	Polirex N.Y.	20 parts	25 parts

¹ To improve adhesion on metal surfaces, we recommend adding 3-5% of 03.040 (calculated by weight on the non-catalysed product). An excess of additive can give a slight haze in gloss colours.

² This solution is recommended for indoor applications. For outdoor applications it is preferable to increase the corrosion resistance of the system by applying a coat of primer of the type recommended above.

³ Considering the big variety of plastics, we recommend performing some preliminary tests.

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Carefully mix until an even colour and consistency are obtained. Dilute with our POLYURETHANE THINNER, code 07.013, at maximum 20%. For temperatures over 25°C use the SLOW POLYURETHANE THINNER, code 07.030, in combination with the POLIREX SLOW POLYURETHANE HARDENER, code 01.012, (following the same ratio as 01.014) until the optimal viscosity of 20"-25" Ford 4 at 20°C.

If the product is required for particular resistance to yellowing and exposure to atmospheric agents, remember to use the anti-UV additive, 03.007, in a measure of 1.5-3% (calculated by weight on the non-catalyzed product).

APPLICATION

Spray gun: nozzles of 1.4-1.7 mm diameter and 3-5 atm pressure.

Airless⁴: nozzle 0.09 inches, 180-240 bar

Roller or brush⁵: only for large surfaces

TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE (ASTM D 523): Semimatt, 30±10 gloss (60° angle)

COLOURS: By request (using the binder 62.3.K1 in a ratio 80/20 with the tinters of the solvent base tinting system)

SPECIFIC WEIGHT (ISO 2811): 1,28 ± 0,07 kg/l. (component A only)

SPECIFIC WEIGHT (ISO 2811): 1,23 ± 0,07 kg/l. (A+B)

SUPPLY VISCOSITY (20°C): 10-18" Ford 8 (component A only)

SOLIDS CONTENT: 60 ± 3% (A+B)

SOLID ON VOLUME: 50 ± 3% (A+B)

DRYING AT 20°C

- Dust dry: 20-30 minutes
- Touch dry: 2-4 hours
- Total hardening : 24 hours
- Forced drying: 30 minutes at 60°C
- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One or two crossed coats

THICKNESS: 60-90 µm

THEORETIC YIELD: 8 m²/kg

POT-LIFE AT 20° C: 4 hours. At higher temperatures, pot-life decreases

SALT SPRAY TEST (ASTM B 117): For 80µm dry applied DTM on iron, 200 hours. If applied in a cycle with primer and topcoat with a final dry film thickness of 140 µm dry, 500 hours.

⁴ For airless applications it is not necessary to dilute the product after hardening.

⁵ You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools.

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ADHESION (ASTM D 3359)⁶: B=5 on iron, aluminium, galvanised sheet previously sanded.

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

YELLOWING (ASTM D 4587): after 500 hours, $\Delta E < 4$

HEAT RESISTANCE: The film of paint resists until 180°C

CHEM. RESIST.⁷ (UNI EN ISO 12720):

HCl solut. 10%	vote	4	7 days
HNO ₃ solut. 10%	vote	2	7 days
H ₂ SO ₄ solut. 10%	vote	4	7 days
Acetic acid solut. 10%	vote	3-2	7 days
Mix of NaCl 10%, Lactic acid 5%	vote	5-4	7 days
Synthetic sweat	vote	5	7 days
H ₂ O ₂ 35%	vote	1	4 days
NH ₃ solut. 30%	vote	5	7 days
NaOH solut. 10%	vote	3-2	7 days
Acetone	vote	5	7 days
Cyclohexanone	vote	1	1 days
Solvello 100	vote	5	7 days
Ethyl acetate	vote	4-3	7 days
Ethanol	vote	5	7 days
Synthetic oil	vote	5	7 days
Idraulic oil	vote	5	7 days
Transmission oil SAE 30	vote	5	7 days
Engine oil 15W40	vote	5	7 days
Viakal	vote	5	7 days
Unleaded gasoline	vote	5	7 days

REPAINTING: Apply the second coat in a short time, wet on wet (within 15 minutes) or after minimum 6 hours. After complete hardening of the film, it is better a light sanding before over-coating.

STORAGE STABILITY: 18 months for A component. 12 months for B component. Stored in closed packs, in a cool, dry place, away from any sources of heat.

⁶ Adhesion, according to the standard, is indicated on a scale from 5 (excellent, no detachment) to 0 (very bad, all the product is removed).

⁷ 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.