

TECHNICAL DATA SHEET

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Name:	EMBOSSSED EPOXY ENAMEL	Category:	high performances bicomponent paint
Definition:	Epoxy two pack top coat	V.O.C. limit:	500 g/l
Code:	21.6	V.O.C. ready to use:	410 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Two-pack epoxy-amino top coat

GENERAL USES

Product for general use on steel, zinc plated iron, aluminium, plastics, light alloys¹. Fit for coats of automatic machine tools and manufacturing machine. Not recommended for external use

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 shows direct adhesion on metals² without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before.

Eventual suggested primers for this product are: Acrydur serie 69.3, Epofix serie 29.3, Basic 2 serie 69.4.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer (serie 29W3 or 29.3) and then the top coat.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer (serie 29W3 or 29.3) and then the top coat.
- Galvanized sheet. Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer (serie 29W3 or 29.3) and then the top coat.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	21.6	Epolux embossed	100 parts	100 parts
Component B	02.120	Eporex standard type	20 parts	30 parts
Component B	02.150	Eporex rapid type	20 parts	30 parts

Carefully mix until an even colour and consistency are obtained. Normally to obtain a good embossed effect it is suggested to apply a first film of product diluted with 10-15% of our thinner 07.006 (to obtain a viscosity of 24-26" Ford 4), then within 24 hours apply a film of product not diluted with the apposite spry gun for embossed.

APPLICATION

Spray gun: nozzles of 1,8-2,2 mm. diameter and 1-2 atm. pressure.

¹ Given the variety of alloys on sale, we recommend carrying out a few preliminary adhesion tests.

² If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

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Airless.

Spry gun for use nozzles of 1.7-2.5 mm diameter and 3-4 atm pressure
embossed:

Roller or brush: Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE semiglossy 75±5 gloss
(ASTM D 523):

COLOURS: By request

SPECIFIC WEIGHT 1,45 kg/L (± 0,05).
(ISO 2811):

SUPPLY VISCOSITY 5000-7000 CPs
(DIN 53211):

SOLID ON VOLUME: 50% (± 3%) A+B

SOLIDS CONTENT: 73% (± 5%) A+B

DRYING AT 20°C

- Dust dry:	30-40'	- Touch dry:	5-6 hours
- Total hardening :	36 hours	- Forced drying ³	45' at 60°C

- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One diluted coat of product followed, after 2-3 hours, by a not diluted coat with apposite gun for embossed

THICKNESS⁴: 70-80 µm

THEORETIC YIELD⁵: 4-5 m²/kg

POT-LIFE AT 20°C: 8 hours at temperature of 20°C. At higher temperatures, pot-life decreases.

SALT SPRAY TEST
(ASTM B 117): With a dry film of 100 µm on iron treated like above reported, 450 hours

IMPACT TEST
(ASTM D 2794): direct 10-15 kg depending on the nature of the support.

ADHESION (ASTM D 3359): B=5, perfect if applied on surfaces treated like above reported.

CHEM. RESIST.⁶ (UNI EN ISO 12720):

³ Baking the product can change the final gloss result, it could result more matt, and also the final colour can result more yellow.

⁴ Considering a dry film.

⁵ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

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Product according to 2004/42/CE

Hydrochloric acid-HCl solut. 10%	solut. vote	4-3	7 days
Nitric acid-HNO ₃ solut. 10%	vote	2-1	7 days
Sulfuric acid-H ₂ SO ₄ solut. 10%	vote	2-1	7 days
Acetic acid solut. 10%	vote	2-1	7 days
Mix of NaCl 10%, Lactic acid 5%	vote	4-3	7 days
Synthetic sweat	vote	5	7 days
Hydrogen peroxide 35%	vote	1	7 days
Ammonia solut. 30%	vote	5	7 days
Sodium hydroxide solut. 10%	vote	4	7 days
Acetone	vote	5-4	7 days
Cyclohexanone	vote	2-1	7 days
Solvelso 100	vote	5-4	7 days
Ethyl acetate	vote	5	7 days
Ethanol	vote	5-4	7 days
Synthetic oil	vote	5-4	7 days
Idraulic oil	vote	5	7 days
Transmission oil SAE 30	vote	5	7 days
Engine oil 15W40	vote	5	7 days

REPAINTING: Within 24 hours or, after the complete hardening of the film, it is better a light sanding before overcoating

STORAGE STABILITY: Two years in closed packs, in a cool, dry place, away from any sources of heat.

⁶ 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.