

# TECHNICAL DATA SHEET

Date of issue: 25.06.2001

Last updating: n°2 21.10.2016



SIRO S.r.l.

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Name: **ACRYLAC, SEMIMATT**

Definition: **Two-pack acrylic enamel**

Code: **60.3**

Category: **2K high performance Alj enamel**

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

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

**Product according to 2004/42/CE**

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## NATURE OF THE PRODUCT

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

## GENERAL USES

Product for high quality applications on machines tools, operating and agricultural machines, furniture and plastics.

Suitable for use with direct adhesion on metals and plastics. Considering the variety of commercially available materials, we strongly recommend doing preliminary tests<sup>1</sup>. To improve the adhesion on metal we suggest acid washing with our 07.044 thinner and diluting the product with the same thinner.

If special yellowing resistance to and to exposure to atmospheric agents is required, we recommend using the anti-UV additive 03.007, at 1.5-3% (calculated by weight on the product without hardener).

## 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 of grease, oils, dirty, rust and calamine on the surfaces is absolutely not allowed.

- 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. Otherwise, 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, quick, improve greatly the adhesion performance on this surface, especially if, contrary to what is specified above, it has been sanded short before.
- Aluminum: 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, quick, improves greatly the adhesion performance on this surface. For this application we suggest using the additive 03.040 (3% to 5% by weight in the product without hardener, an excess can give a slight haze in the gloss colours). Nevertheless, we suggest testing the adhesion on a sample before proceeding with large applications.
- Plastics<sup>2</sup>: elimination of any molding release agents. Sanding with brown scotch brite followed by accurate degreasing with suitable solvents. We suggest testing the adhesion on a test sample before proceeding with large applications.

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.

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<sup>1</sup> To improve the adhesion on metal we recommended using the additive 03.040 at 3-5% (calculated by weight on the product without hardener, an excess can give a slight haze in the gloss colours).

<sup>2</sup> Considering the big variety of plastics, we recommend performing some preliminary tests.

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## PREPARATION OF THE PRODUCT

|                   | code   | name                     | By Weight | By Volume |
|-------------------|--------|--------------------------|-----------|-----------|
| Component A       | 60.3   | Acrylac enamel, semimatt | 100 part  | 100 part  |
| Component B       | 01.014 | Polirex NI               | 20 parts  | 25 parts  |
| As an alternative | 01.012 | Polirex NI slow          | 20 parts  | 25 parts  |

Carefully mix until an even colour and consistency are obtained. Dilute with our polyurethane thinner 07.013 in a percent of 10-15% to obtain a viscosity of 23-28" Ford 4 (at temperatures over 25°C use 07.030 thinner and also 01.012 hardener).

## APPLICATION

Spray gun: nozzles of 1,4-1,7 mm. diameter and 3-5 atm. pressure

Airless Nozzle 0,09 inches, 180-240 bar

Electrostatic spray gun: suitable

Roller or brush<sup>3</sup>: only for large surfaces

## TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE (ASTM D 523): Semimatt, 30±5 gloss

COLOURS: On request, (the binder 60.3.K1 must be used in a binder/tinters ratio of 80/20 with the tintometric system tinters).

SPECIFIC WEIGHT (iso 2811): 1,25 kg/L (±0,10 A+B)

SUPPLY VISCOSITY (DIN 53211): 30" ± 5" Ford 8

SOLID ON VOLUME: A+B 48% (±2%)

SOLIDS CONTENT: A+B 60% (± 3%).

DRYING AT 20°C

- Dust dry: 20-30 minutes
- Touch dry: 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 one standard coat

RECOMMENDED THICKNESS: 40-60 µm

THEORETIC YIELD <sup>4</sup>: 10 m²/kg

<sup>3</sup> You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools

<sup>4</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

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|                                      |                                                                                                                                                                                               |
|--------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>POT-LIFE AT 20° C:</b>            | 6 hours. At higher temperatures, pot-life decreases                                                                                                                                           |
| <b>SALT SPRAY TEST (ASTM B 117):</b> | 300 hours if applied DTM with a final dried film thickness of 80µm.<br>500 hours if applied on epoxy primer 29.3.70121 or acrylic primer 69.3.R7035 with a final film thickness of 120-140µm. |
| <b>ADHESION (ASTM D 3359):</b>       | B=5 on surfaces treated like above reported                                                                                                                                                   |
| <b>IMPACT TEST (ASTM D 2794):</b>    | 36 kg direct on sanded iron                                                                                                                                                                   |
| <b>YELLOWING (ASTM D 4587):</b>      | after 1000 hours, $\Delta E < 3$                                                                                                                                                              |

**CHEM. RESIST .<sup>5</sup> (UNI EN ISO 12720):**

|                                           |      |   |        |
|-------------------------------------------|------|---|--------|
| HCl solut. 10%                            | vote | 5 | 7 days |
| HNO <sub>3</sub> solut. 10%               | vote | 1 | 5 days |
| H <sub>2</sub> SO <sub>4</sub> solut. 10% | vote | 5 | 7 days |
| Acetic acid solut. 10%                    | vote | 3 | 3 days |
| Mix of NaCl 10%, Lactic acid 5%           | vote | 5 | 7 days |
| Synthetic sweat                           | vote | 5 | 7 days |
| H <sub>2</sub> O <sub>2</sub> 35%         | vote | 1 | 2 days |
| NH <sub>3</sub> solut. 30%                | vote | 5 | 7 days |
| NaOH solut. 10%                           | vote | 2 | 2 days |
| Acetone                                   | vote | 5 | 7 days |
| Cyclohexanone                             | vote | 1 | 2 days |
| Solvesso 100                              | vote | 5 | 7 days |
| Ethyl acetate                             | vote | 5 | 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 |
| Unleaded gasoline                         | vote | 5 | 7 days |

**REPAINTING:** After minimum 6 hours. After total hardening, 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.

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<sup>5</sup> The quality of chemical resistance goes from a value of 5 (means optimum) to 1 (means not good). For further informations please contact Siro's technical service.