

TECHNICAL DATA SHEET

Date of issue: 20.03.2003

Last updating: n° 8 26.04.2021



Name:	POLIFAN GLOSSY	Category:	top coat
Definition:	Polyurethane two-pack top coat	V.O.C. ready to use:	585 g/l
Code:	68.1	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Two-pack polyurethane topcoat based on polyester resins and isocyanic hardener to mix before use.

GENERAL USES

Product for general use, industrial applications and bodywork, machine tools, furniture, various coatings.

APPLICATION METHOD

PREPARATION OF SURFACES

The product shows direct adhesion on metals without a previous primer application (29.3 or 29W3) or polyacrylurethane or polyurethane 69.3, 69.4 or 69W4 series.

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.

- Ferrous surfaces. Sandblasting SA2 ½. Alternatively, perfect mechanical cleaning of the surface by sanding to remove rust, calamine and subsequent cleaning by degreasing with aqueous solutions of surfactants or solvents. Then proceed with the application of the primer.
- Galvanized sheet. Accurate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the application of the primer.
- Aluminium. Mechanical cleaning of the support by sanding followed by degreasing with solvents. Then proceed with the application of the primer.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	68.1	Polifan glossy	100 parts	100 parts
Component B	01.014	Polirex NY for external use	50 parts	50 parts
Alternatively	01.012	Slow Polirex NY for external use	50 parts	50 parts
Alternatively	01.017	Fast Polirex NY for external use	50 parts	50 parts
Alternatively	01.025	Polirex for internal use	50 parts	50 parts

Carefully mix until an even colour and consistency are obtained. Dilute with our polyurethane thinner 07.013 at 10-20% to obtain a viscosity of 18"-20" Ford 4 at 20° C.

For temperatures above 25°C it is suggested to use our slow hardener 01.012 and our slow polyurethane thinner 07.030.

APPLICATION

Spray gun:	Nozzles of 1,2-1,4 mm diameter and 3-4 atm pressure.
Roller or brush:	Only for large surfaces. ¹

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

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SIRO S.r.l.

Via Meucci, 5 - Z.I. Selve
35037 Teolo - Padova
Tel. 049.990.11.22
Fax 049.990.15.36
e-mail: vendite@siropaints.com
www.siropaints.com

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TECHNICAL DATA

PRODUCT TYPE: Two pack product.

FILM APPEARANCE (ASTM D 523): Gloss, >90

COLOURS: By request (the binder 68.1.K1 has to be used in a ratio 70/30 with the solvent base tinting system).
The version 68.1.90130, POLIFAN EXTRA BIANCO, applied over the primer 29.3.90130, is suitable for contact with food and drinking water, having passed the tests required by current regulations (DM 06/04/04 n° 174 and Regulation (CE) N. 1935/2004).

SPECIFIC WEIGHT (ISO 2811): 1,02 ± 0,1 kg/l, (component A only)

SPECIFIC WEIGHT (ISO 2811): 1,02 ± 0,1 kg/l, (A+B)

SUPPLY VISCOSITY (DIN 53211): 19" Ford 8 at 20° C. (± 3").

SOLID ON VOLUME: 40±3% ready to use

SOLIDS CONTENT: 60 ± 2% (A+B)

DRYING AT 20°C

- Dust dry: 20-30 minutes
- Touch dry: 6-7 hours
- Total hardening : 24-36 hours
- Forced drying 30 minutes at 60-80°C
- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One crossed coat.

THICKNESS: 40-50 µm

THEORETIC YIELD: 10 m²/kg

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

SALT SPRAY TEST (ASTM B 117): If applied on a cycle with primer and topcoat with a final dried film thickness of 150 µm, 500 hours.

CERTIFICATION EN ISO 12944-6: The product applied on epoxy primer **29.3.90130** or on acrylic primer **69.3.90150**, complies with EN ISO 12944-6, 'Corrosion protection of steel structures by protective paint systems', class C4M, suitable for industrial environments and coastal areas with moderate salinity (final thickness 180 µm).

IMPACT TEST (ASTM D 2794): 15 kg direct

ADHESION (ASTM D 3359): B=5, optimal of surfaces prepared like above specified

YELLOWING (ASTM D 4587): DE< 4 after 500 hours

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CHEM. RESIST.² (UNI EN ISO 12720):

Hydrochloric acid solut. 10%	vote	5	7 days
Nitric acid solut. 10%	vote	5-4	7 days
Sulfuric acid solut. 10%	vote	5	7 days
Acetic acid solut. 10%	vote	5	7 days
Mix of Sodium chloride 10%, Lactic acid 5%	vote	5	7 days
Synthetic sweat	vote	5	7 days
Hydroger peroxide 35%	vote	5	7 days
Ammonia solut. 30%	vote	5	7 days
Sodium hydroxide solut. 10%	vote	5-4	7 days
Acetone	vote	4	7 days
Cyclohexanone	vote	3-2	7 days
Solvelso 100	vote	3	7 days
Ethyl acetate	vote	3	7 days
Ethanol	vote	5-4	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 6 hours minimum. If overpainting is planned before the first layer has completely hardened (24-36 hours), it is advisable to check the sandability and, if possible, to lightly sand the surface.
After 36 hours a light sanding is always necessary.

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.

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.