

TECHNICAL DATA SHEET

Date of issue: 21/02/2005

Last updating: n° 5 26/04/2021



Name: SEMIMATT POLIFAN

Category: topcoat

Definition: Polyurethane two-pack enamel

V.O.C. ready to use: 580 g/l

Code: 68.3 (for products formulated using 68.3.K2 binder)

Product outside the uses referred to 2004/42/CE

NATURE OF THE PRODUCT

Two-pack topcoat, based on polyester resins and isocyanic adduct to mix before use.

GENERAL USES

Product for general use, coachwork, furniture.

APPLICATION METHOD

PREPARATION OF SURFACES

The product does not have good direct adhesion properties on metal so it requires the application of a primer coat such as those of the epoxy series 29.3 or 29W5, or polyacryl-urethane or polyurethane, series 69.3, 69.4.

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. Alternatively, perfect mechanical cleaning of the surface by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or solvents. Then proceed with the application of the primer.
- Galvanized sheet. Accurate sanding (with coarse grain scotch brite paper) followed by degreasing using solvents. Then proceed with the application of the primer.
- Aluminium. Mechanical cleaning of the surface 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	68.3	Polifan semimatt	100 parts	100 parts
Component B	01.014	Polirex NY for external use	25 parts	30 parts
Alternatively	01.012	Polirex NY for external use, slow	25 parts	30 parts
Alternatively	01.017	Polirex NY for external use, fast	25 parts	30 parts
Alternatively	01.025	Polirex for internal use	25 parts	30 parts

Carefully mix until an even colour and consistency are obtained. Dilute with our polyurethane thinner 07.013 at 15-20% 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 1,4-1,7 mm diameter and 3-5 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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PRODUCT TYPE: Two pack product.

FILM APPEARANCE (ASTM D 523): Semimatt, 35 ± 5 gloss

COLOURS: By request (the binder 68.3.K2 has to be used in a ratio 70/30 with the tinters of the solvent base tinting system).

SPECIFIC WEIGHT (ISO 2811): 1,22 ± 0,05 kg/l, (component A only)

SPECIFIC WEIGHT (ISO 2811): 1,20 ± 0,05 kg/l, (A+B)

SUPPLY VISCOSITY (DIN 53211): 25" Ford 8 a 20° C (± 3")

SOLID ON VOLUME: 50±3% ready to use

SOLIDS CONTENT: 60 ± 2% (A+B)

DRYING AT 20°C

- Dust dry: 15-20 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: 8-10 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.

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

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

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.

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Ammonia solut. 30%	vote	5	7 days
Sodium hydroxide solut. 10%	vote	5-4	7 days
Acetone	vote	1	2 days
Cyclohexanone	vote	1	2 days
Solvento 100	vote	3	7 days
Ethyl acetate	vote	1	2 days
Ethanol	vote	3	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: Within 12 hours. After completely hardening we recommend sanding the surface to overpaint.

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