

TECHNICAL DATA SHEET

Date of issue: 18/09/2003

Last updating: n°7 10/03/2023



Name:	SIROLACK GLOSS	Category:	One-pack high performance A/I enamel
Definition:	Industrial fast-drying synthetic enamel	V.O.C. ready to use:	490 g/l
		V.O.C. limit:	500 g/l
Code:	72.1	Product according to	2004/42/CE

NATURE OF THE PRODUCT

Gloss topcoat based on alkyd air-drying resins. It has good coverage and weathering resistance, specific for applications in industrial environments.

GENERAL USES

Steel structural works, steel products, agricultural machinery, silos, machine tools.

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.

- Ferrous surfaces. Carefully remove any traces of rust, calamine, grease and humidity from the surface by SA2 1/2 grade sandblasting. Alternatively, perfect mechanical cleaning of the support by sanding and subsequent degreasing with aqueous solutions of surfactants or with organic solvents. Apply a primer coat like our **SIRNOX N 79.2 or 79.4** series. When completely dry, apply the **SIROLACK** topcoat. The product can also be applied with direct adhesion on iron.
- Galvanized sheet. Careful sanding with coarse-grained scotch brite followed by degreasing with solvents. Recommended primers: **ACRYDUR 69.3** series, **EPOFIX 29.3** series, **BASIC 2 69.4** series.
- Aluminium. Chromate or phosphocromatising treatment or in alternative delicate sanding procedure followed by degreasing using organic solvents. Recommended primers: **ACRYDUR 69.3** series, **EPOFIX 29.3** series, **BASIC 2 69.4** series.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. Dilute at 5% with our **SYNTHETIC THINNER**, code **07.005**, or **ANTIFOG NITRO THINNER**, code **07.001**, obtaining a viscosity of 20-24" Ford 4 at 20°C.

APPLICATION

Spray gun:	nozzles of 1.4-1.7 mm diameter and 3-5 atm pressure.
Airless.	nozzle 0.09 inches, 180-240 bar (no dilution)
Brush/roller	Only for large surfaces ¹

TECHNICAL DATA

PRODUCT TYPE:	One-pack
APPEARANCE (ASTM D 523):	Gloss (85±3 gloss).

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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COLOURS:	By request (by using the binder 72.1.K7 in a binder/tinters ratio 80/20 with the tinters of the solvent based tinting system)		
SPECIFIC WEIGHT (ISO 2811):	1,21 ± 0,05 kg/l		
SUPPLY VISCOSITY (DIN 53211):	30 - 40" Ford 8 a 25°C (± 3")		
SOLID ON VOLUME:	53 ± 3%		
SOLIDS CONTENT:	62 ± 2%		
DRYING AT 20°C	- Dust dry:	20-30 minutes	
	- Touch dry:	6-8 hours	
	- Total hardening:	24-36 hours	
	- Forced drying:	30 minutes at 60°C	
	- Maximum chemical resistance:	After 7 days	
RECOMMENDED COATS:	One or two crossed coats		
RECOMMENDED THICKNESS:	40-60 µm		
THEORETIC YIELD:	6-8 m²/kg		
SALT SPRAY TEST (ASTM B 117):	> 500 hours with cycle SIRNOX N (79.2) and SIROLACK (72.1) for a final dry thickness of 150 µm		
ADHESION (ASTM D 3359):	B= 5, excellent on surfaces treated like above reported.		
IMPACT TEST (ASTM D 2794):	36 kg direct, 10 kg reverse		
YELLOWING (ASTM D 4587):	ΔE<5 after 500 hours (it becomes slightly matt)		

CHEM. RESIST .² (UNI EN ISO 12720):

Hydrochloric acid solut. 10%	vote	4	7	days
Nitric acid solut. 10%	vote	1	7	days
Sulfuric acid solut. 10%	vote	4	7	days
Acetic acid solut. 10%	vote	4-3	7	days
Mix of Sodium chloride 10%, Lactic acid 5%	vote	4	7	days
Synthetic sweat	vote	5	7	days
Hydroger peroxide 35%	vote	1	7	days
Ammonia solut. 30%	vote	4	7	days
Sodium hydroxide solut. 10%	vote	1	7	days
Acetone	vote	4-3	7	days
Cyclohexanone	vote	1	7	days
Solvesso 100	vote	5-4	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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Ethyl acetate	vote	4	7	days
Ethanol	vote	4-3	7	days
Synthetic oil	vote	4	7	days
Idraulic oil	vote	5	7	days
Transmission oil SAE 30	vote	5-4	7	days
Cutting oil	vote	5	7	days

REPAINTING: Within 4 hours wet on wet or after a complete hardening of 4 weeks.

STORAGE STABILITY: Eighteen months, stored in closed packs, in a cool, dry place, away from any sources of heat.