

TECHNICAL DATA SHEET

Date of issue: 13/12/2004

Last updating: n° 4 26/04/2021



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

Name:	SIROLACK SEMIGLOSSY	Category:	Topcoat
Definition:	Industrial synthetic enamel	V.O.C. ready to use:	555 g/l
Code:	72.2	Product outside the uses referred to 2004/42/CE	

NATURE OF THE PRODUCT

Top coat based on fast air drying alkyd resins.

GENERAL USES

Steel structural works, steel products, agricultural machines, containers, etc.

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 on the support of substances such as oil, grease and dirt (and of course, for other reasons, rust and calamine) is absolutely not allowed.

- Ferrous surfaces: remove carefully all traces of rust, calamine, grease and humidity, by very careful mechanical cleaning, followed by degreasing using thinners, or with sandblasting process SA 2_{1/2}. Apply a primer coat like our Sirnox N series 79.2 or 79.4. When the primer is completely dry (2-3 hours minimum), apply the Sirolack topcoat. The product can also be applied with direct adhesion on steel.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. For airless application no dilution is needed. For standard applications dilute at 10-20% with our synthetic thinner 07.005 or nitro 07.001 until a viscosity of 25-30" Ford 4 is reached 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 pressure

Roller or brush: Only for large surfaces¹

TECHNICAL DATA

PRODUCT TYPE:	One-pack
FILM APPEARANCE (ASTM D 523):	Semiglossy, 65±5 gloss
COLOURS:	By request (using the binder 72.2.K7 in a ratio of 80/20 with tinters of solvent base tinting system)
SPECIFIC WEIGHT (ISO 2811):	1,15 g/cm ³ ±0,08
SUPPLY VISCOSITY (DIN 53211):	18 ± 5" Ford 8
SOLID ON VOLUME:	52% (± 2%)
SOLIDS CONTENT:	65% (± 3%).

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

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DRYING AT 20°C

- Dust dry: 15-30 minutes
- Touch dry: 6-7 hours
- Total hardening : 24-36 hours
- Forced drying: 30 minutes at 80°C
- Maximum chemical resistance: After 10 days

RECOMMENDED COATS: One crossed coat

RECOMMENDED THICKNESS: 60-80 µm

THEORETIC YIELD: 6-8 m²/kg

SALT SPRAY TEST (ASTM B 117): On direct adhesion with 80µm of dry film thickness: 100 hours. On cycle with primer 79.2 and a final film thickness of 100µm, it resists 500 hours.

IMPACT TEST (ASTM D 2794): 36kg direct on sanded iron

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

REPAINTING: Wet on wet within 4 hours or after complete hardening of the film with a previous light scratch.

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