

TECHNICAL DATA SHEET

Date of issue: 02.02.2011

Last updating: n°5 10.03.2023



SIRO S.r.l.

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Name:	SIROLACK SEMIMATT	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:	72.3	Product according to	2004/42/CE

NATURE OF THE PRODUCT

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

GENERAL USES

Aimed at the treatment of metal surfaces, steel structural works, bridge cranes, iron products, agricultural machinery, silos.

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 substrate of substances, such as grease, oils and dirt (and obviously, for other reasons, rust and calamine) is absolutely not tolerated.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical cleaning by sanding to remove rust and calamine, followed by degreasing with aqueous solutions of surfactants or organic solvents. Then proceed by applying a primer coat of our **79.2 or 79.4** series. When completely dry, apply the topcoat **SIROLACK SEMIMATT**.
- Galvanized sheet. accurate sanding by using scotch brite coarse grain, then degreasing with solvents. Otherwise, accurate degreasing with solvents. Then proceed by applying a primer coat: **ACRYDUR 69.3** series, **EPOFIX 29.3** series, **BASIC 2 69.4** series. When completely dry, apply the topcoat **SIROLACK SEMIMATT**.
- 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. When completely dry, apply the topcoat **SIROLACK SEMIMATT**.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. For airless application no dilution is required. For standard airmix applications, dilute at maximum 10% with our **SYNTHETIC THINNER**, code **07.005**, or **ANTIFOG NITRO THINNER**, code **07.001**, to get a viscosity of 10-20" Ford 8.

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 surfaces ¹

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

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TECHNICAL DATA

PRODUCT TYPE:	One-pack
FILM APPEARANCE (ASTM D 523):	Semimatt, 35±5 gloss
COLOURS:	By request (by using the binder .72.3.K7 in a binder/tinters ratio 80/20 with the tinters of the solvent based tinting system)
SPECIFIC WEIGHT (ISO 2811):	1,17 ± 0,05 kg/l
SUPPLY VISCOSITY (DIN 53211):	25" ±3" Ford 8
SOLID ON VOLUME:	54 ± 2%
SOLIDS CONTENT:	63 ± 3%
DRYING AT 20°C	- Dust dry: 40-50 minutes - Touch dry: 2-3 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
RECOMMENDED THICKNESS:	60-80 µm
THEORETIC YIELD:	6-8 m²/kg
SALT SPRAY TEST (ASTM B 117):	250 hours with 80µm dry film thickness. > 500 hours with cycle primer 79.2 and topcoat 72.3 with a final thickness of 150µm.
ADHESION (ASTM D 3359):	B=5, optimal on surfaces prepared like above specified
IMPACT TEST (ASTM D 2794):	36kg direct on sanded iron
REPAINTING:	Within 4 hours from application or after complete hardening of the film with a previous light sanding.
STORAGE STABILITY:	Eighteen months, stored in closed packs, in a cool, dry place, away from any sources of heat.