

TECHNICAL DATA SHEET

Date of issue: 20.06.2001

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Name:	EMBOSSED POLILAC	Category:	top coat
Definition:	Industrial polyurethane enamel	V.O.C. ready to use:	435 g/l
Code:	63.6	V.O.C. limit:	500 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Top coat based on alkyd resins and isocyanate adducts able to give an orange peel or embossed effect

GENERAL USES

Machines tools, metallic structural work, furniture, industrial vehicles, earthmoving vehicles, agricultural machinery, 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.

The product shows direct adhesion on metals¹ without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before.

Eventual suggested primers for this product are: Acrydur series 69.3, Epofix series 29.3, Basic 2 series 69.4, Epofix WB extra 29W5.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.
- Galvanized sheet. Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Componente A	63.6	Polilac	100 parts	100 parts
Componente B	01.013	Polyrex MI	20 parts	28 parts
alternative	01.014 ²	Polirex NI for external	33 parts	40 parts

Mixing accurately the mixture before the application. Dilute with our polyurethane thinner 07.013 (for a temperature of more than 25°C use 07.030 thinner) in a percent of 10-20% until a viscosity of 18-25" Ford 4 at 20° C to have a final smooth surface; not dilute or maximum dilute 5% for embossed or orange peel effect. We suggest to apply a first smooth coat and then, after 2 hours, the embossed-orange peel coat.

APPLICATION

Spray gun: nozzles of 1,2-1,4 mm. diameter and 3-4 atm. pressure.

Roller or brush³: Only for small surfaces

Airless. nozzle 0,09 inches, 120-150 bar

¹ If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

² 01.012 Slow hardener for external at 33% in weight. If necessary dilute with slow PU thinner 07.030 in place of 07.013.

³ 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: Two pack

FILM APPEARANCE (ASTM D 523): Semimatt or matt depending on the dilution

COLOURS: By request (the binder .63.6.K2 has to be used in a ratio 80/20 with the tintometric system tinters)

SPECIFIC WEIGHT (ISO 2811): 1,33 kg/l. ($\pm 0,10$)

SUPPLY VISCOSITY: 200 Ps ± 20 at 20°C

SOLID ON VOLUME: A+B 54 $\pm$ 3%

SOLIDS CONTENT: A + B 66% ($\pm$ 3%)

DRYING AT 20°C

- Dust dry:	20-30'	- Touch dry:	4-6 hours
- Total hardening :	24 hours	- Forced drying	30' at 60°C

- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One crossed coat diluted 10-20% plus a crossed coat not diluted for embossed effect after minimum 30'

THICKNESS ⁴: 60-90 μ m

THEORETIC YIELD ⁵: 6 m²/kg.

POT-LIFE AT 20°C: 3 hours at temperature of 20°C. 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 120 μ m, 400 hours

IMPACT TEST (ASTM D 2794): 15 kg direct

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

YELLOWING (ASTM D 4587): DE< 8 after 500 hours

REPAINTING: Within minimum 12 hours. After it is better a light sanding before over-coating.

STORAGE STABILITY: One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.

⁴ Considering a dry film.

⁵ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.