TECHNICAL DATA SHEET

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Date of issue: *01.01.2001*

Last updating: *n° 5* *19.07.2019*

Name:	**GLOSSY POLILAC**	**Category:**	**top coat**
Definition:	**Industrial polyurethane enamel**	**V.O.C. ready to use:**	**600 g/l**
Code:	**63.1**	**Product outside the uses referred to 2004/42/CE**	

NATURE OF THE PRODUCT

Top coat based on alkyd resins and isocyanic adducts.

GENERAL USES

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

APPLICATION METHOD

PREPARATION OF SURFACES

The product shows direct adhesion only on iron. On other metals a primer coat is required, like our epoxy series 29.3 or 29W3, or our polyacryurethane or polyurethane series 69.3, 69.4 or 69W4.

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. SA2 1/2 sandblasting or very careful mechanical abrasion by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or thinners. Then proceed either with the direct application of the product or, for more guarantees of protection of the product over time, of the primer chosen and subsequently of the top coat.
- Galvanized sheet. Accurate sanding (with scotch brite paper coarse grain) followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.
- Aluminium. Mechanical cleaning of the substrate by sanding, 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
A component	63.1	Polilac	100 parts	100 parts
B component	01.014	Polirex not yellowing for external use	40 parts	42 parts

Carefully mix until an even colour and consistency are obtained. For standard applications with spray gun dilute with our thinner 07.013 at 0-5% in order to get a viscosity of 18-20" Ford 4 at 20° C (for temperatures higher than 25°C use thinner 07.030).

APPLICATION

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

Roller or brush[1]: only for large surfaces

TECHNICAL DATA

PRODUCT TYPE: Two pack

FILM APPEARANCE (ASTM D 523): Glossy, 90±5 gloss

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

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COLOURS:	By request (by using the binder 63.1.K2 mixed in a ratio 75/25 with our tinting system tinters)	
SPECIFIC WEIGHT (ISO 2811):	1,00 kg/l. (± 0,10)	
SUPPLY VISCOSITY (DIN 53211):	10" Ford 8 at 20°C (± 2")	
SOLID ON VOLUME:	40% (±2%)	
SOLIDS CONTENT:	A + B 43% (±3%)	
DRYING AT 20°C	- Dust dry:	20-30 minutes
	- Touch dry:	4-6 hours
	- Total hardening :	24 hours
	- Forced drying	30 minutes at 60°C
	- Maximum chemical resistance:	After 7 days
RECOMMENDED COATS:	One crossed coat	
THICKNESS [2]:	40-50 μm	
THEORETIC YIELD [3]:	10 m^2/kg.	
POT-LIFE AT 20° C:	4 hours at 20°C. At higher temperatures, pot-life decreases	
SALT SPRAY TEST (ASTM B 117):	400 hours if applied on a cycle with primer and topcoat with a final dried film thickness of 120 μm	
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	

CHEM. RESIST .[4] (UNI EN ISO 12720):

HCl solut. 10%	vote	5-4	7 days
HNO_3 solut. 10%	vote	3-2	7 days
H_2SO_4 solut. 10%	vote	5	7 days
Acetic acid solut. 10%	vote	3	7 days
Mix of NaCl 10%, Lactic acid 5%	vote	5	7 days
Synthetic sweat	vote	5	7 days
H_2O_2 35%	vote	5	7 days
NH_3 solut. 30%	vote	5	7 days
NaOH solut. 10%	vote	4	7 days
Acetone	vote	4	7 days
Cycloexanone	vote	1	7 days
Solvesso 100	vote	4	7 days

[2] Considering a dry film.

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

[4] 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	5-4	7 days
	Ethanol	vote	5	7 days
	Synthetic oil	vote	5-4	7 days
	Hydraulic oil	vote	5	7 days
	Transmission oil SAE 30	vote	5	7 days
	Engine oil 15W40	vote	5	7 days
	Unleaded gasoline	vote	4	7 days

REPAINTING: After minimum 12 hours. After the complete hardening of the film, 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.