

TECHNICAL DATA SHEET

Date of issue: 18.04.2005
Last updating: n.3 31.03.2021



Name:	SIROFLEX FM	Category:	high performances one-pack paint
Definition:	One-pack micaceous top coat	V.O.C. ready to use:	500 g/l
		V.O.C limit:	500 g/l
Code:	78.8.OFM	Product according to	2004/42/CE

NATURE OF THE PRODUCT

Topcoat based on micaceous iron oxide, vinyl copolymers and suitable plasticizers with high weathering resistance. Applicable directly on galvanized sheet.

GENERAL USES

Protection of iron products, steel structural works, galvanized iron, aluminium.

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 of grease, oils, dirty, rust and calamine on the surfaces is absolutely not allowed.

- 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. The product can also be applied to direct adhesion. Possible recommended primers: our Sirnox N series 79.2 or 79.4.
- Galvanised sheet: accurate sanding by using scotch brite coarse grain, then degreasing with solvents. The product can also be applied to direct adhesion. Possible recommended primers: Acrydur series 69.3, Epofix series 29.3, Basic 2 series 69.4, Monodour series 49.9.
- Aluminum: Chromate conversion coating or phosphochromatising. Alternatively, light sanding followed by degreasing with organic solvents. The product can also be applied to direct adhesion. Possible recommended primers: Acrydur series 69.3, Epofix series 29.3, Basic 2 series 69.4, Monodour series 49.9.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. Dilute with our synthetic thinner 07.005 or nitro thinner 07.001 at 5-10% obtaining the correct viscosity according to the application procedure.

APPLICATION:

Spray gun: use nozzles of 1.4-1.7 mm. diameter and 3-5 atm pressure

Roller or brush. Only for large surfaces¹

TECHNICAL DATA

PRODUCT TYPE:	One pack product
FILM APPEARANCE (ASTM D 523):	Semi-gloss (50±10 gloss)
COLOURS:	Those from the micaceous iron card (using the 78.8.OFM binder in a 95/5 ratio with the tinters of the solvent tinting system).
SPECIFIC WEIGHT (ISO 2811):	1,25 ± 0,08 g/cm ³
SUPPLY VISCOSITY (DIN 53211):	18" F8 (±3")

This information is based on our present knowledge and are given to let you know better our products and their application. We absolutely do not intend to give warranties for specific applications of products and fitness for specific applications. We give a general warranty on global quality of our products in the standard range of our sales.

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SOLID ON VOLUME:	44±3%
SOLIDS CONTENT:	55±2%
DRYING AT 20°C:	- Dust dry: 20-30 minutes - Touch dry: 2-3 hours - Total hardening: 24 hours - Forced drying: 30 minutes at 60°C - Maximum chemical resistance: after 14 days
RECOMMENDED COATS:	One crossed coat.
THICKNESS:	40-50 µm
THEORETIC YIELD:	6-8 m ² /kg.
SALT SPRAY TEST (ASTM B 117):	500 hours if applied the primer 79.2 and the topcoat 78.8 for a final dry thickness of 100 µm
ADHESION (ASTM D 3359):	B=5, optimal of surfaces prepared like above specified
IMPACT TEST (ASTM D 2794):	36 kg direct, 10 kg inverse
REPAINTING:	Whithin 4 hours wet on wet or after complete hardening of 2 hours.
STORAGE STABILITY:	Two years in closed packs, in a cool, dry place, away from any sources of heat.

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