

TECHNICAL DATA SHEET

Date of issue: 03/09/2013

Last updating:



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Name:	Thermodur Matt	Category:	Top Coat
Definition:	Transparent stoving enamel	V.O.C. ready to use:	650 g/l
Code:	11.4.00002	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Matt thermosetting top coat based on alkyd and high solid amino compounds resins with high elasticity and with excellent surface adhesion.

GENERAL USES

Stoving enamel, specific for metal protection of light alloys, as copper, brass, nickel, 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 presence of grease and oils on the surfaces, is absolutely not allowed.

- Ferrous surfaces. 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 direct application of the product or, if preferred, with the application of a primer and then the top coat.
- Galvanized sheet. Delicate sanding (with scotch brite paper) 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.

PREPARATION OF THE PRODUCT

Carefully mix until an even consistency is obtained. For standard airmix application dilute with stoving synthetic thinner 07.010 or 07.003 in a percent of 10-15% to obtain a viscosity of 15-18" Ford 4 .

APPLICATION

Spray gun: nozzles of 1,4-1,6 mm. diameter and 3-5 atm. pressure.

TECHNICAL DATA

PRODUCT TYPE: Monocomponent

APPEARANCE (ASTM D 523): Matt (5±2 gloss).

COLOURS: transparent

SPECIFIC WEIGHT (ISO 2811): 0,98 kg/L (± 0,03).

SUPPLY VISCOSITY(DIN 53211): 17" Ford 4 a 25°C. (± 2").

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SOLID ON VOLUME: 46% (± 2%)

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SOLIDS CONTENT: 45% ($\pm 2\%$)

DRYING AT 20°C - - Flash period: 20-30' - baking: 30-40' a 120-130°C or 20' at 140°C

RECOMMENDED COATS: One

THICKNESS¹: 30-35 μm

THEORETIC YIELD²: 15 m^2/kg

IMPACT TEST (ASTM D 2794): B=35 kg direct, 20 kg reverse.

ADHESION (ASTM D 3359): B=5 on surfaces treated like above reported.

YELLOWING (ASTM D 4587): $\Delta E < 5$ after 500 hours

CHEM. RESIST . duoble passages with wad of cotton soaked with the substance indicated:

acetone	50 duoble passages	ok
Ethylic alchool	50 duoble passages	ok

REPAINTING: Wet on wet after the flash period, or dry on dry after light sanding.

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

¹ Considering a dry film.

² The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces for product ready to be used.