

TECHNICAL DATA SHEET

Date of issue: 20/06/2001

Last updating: n°3 22/10/2015



Name:	THERMODUR CLEAR EXTRA	Category:	Topcoat
Definition:	Gloss stoving enamel	V.O.C. ready to use:	680 g/l
Code:	11.1.00006	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Colorless topcoat based on alkyd resins and thermosetting amine resins with high elasticity and excellent adhesion characteristics.

GENERAL USES

Transparent stoving enamel, specific for the protection of metals, light alloys, such as copper, brass, 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.

Carefully remove any traces of rust, grease and humidity by mechanical cleaning and subsequent washing with solvent. Alternatively, phosphodegreasing or phosphating processes are recommended.

- Ferrous surfaces. SA2 grade sandblasting. Alternatively, perfect mechanical cleaning of the support by sanding with elimination of rust, calamine and subsequent cleaning by degreasing with aqueous solutions of surfactants or solvents. Alternatively, phosphodegreasing or phosphating processes are recommended. Then apply our Thermofix stoving primer series 19.2. After drying¹ or hardening of the primer, apply a crossed coat of Thermodur. The product can also be applied with direct adhesion on a perfectly clean surface.
- Galvanized sheet. Sanding followed by degreasing with organic solvents followed by application of a coat of Sirodour primer 49.9 or epoxy primer series 29.3.
- Aluminium. Sanding followed by degreasing with organic solvents followed by application of a coat of Sirodour primer 49.9 or epoxy primer series 29.3.

PREPARATION OF THE PRODUCT

Dilute at 20-30% with stoving synthetic thinner 07.010 or 07.003 in order to obtain a viscosity of 12±5" Ford 4.

APPLICATION

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

Electrostatic gun: The product is suitable for this application

TECHNICAL DATA

PRODUCT TYPE:	One-pack
APPEARANCE (ASTM D 523):	Gloss (90±2 gloss).
COLOURS:	transparent

¹ For wet-on-wet application, carry out a 20-30 minutes flash-off at 20°C between the primer coat and the topcoat.

TECHNICAL DATA SHEET

Date of issue: 20/06/2001

Last updating: n°3 22/10/2015



SIRO S.r.l.

Via Meucci, 5 - Z.I. Selve
35037 Teolo - Padova
Tel. 049.990.11.22
Fax 049.990.15.36
e-mail: vendite@siropaints.com
www.siropaints.com

Name:	THERMODUR CLEAR EXTRA	Category:	Topcoat
Definition:	Gloss stoving enamel	V.O.C. ready to use:	680 g/l
Code:	11.1.00006	Product outside the uses referred to	2004/42/CE

SPECIFIC WEIGHT (ISO 2811): 0.97 ± 0.05 kg/l

SUPPLY VISCOSITY(DIN 53211) : 14" ± 2" Ford 4 at 25°C

SOLID ON VOLUME: 40 % (± 2%)

SOLIDS CONTENT: 40 % (± 2%)

DRYING AT 20°C

- flash off period: 10-15 minutes at room temperature
- baking: 30-40 minutes at 130-140°C

RECOMMENDED COATS: One

RECOMMENDED THICKNESS: 20-25 µm

THEORETIC YIELD: 15 m²/kg

IMPACT TEST (ASTM D 2794): B=35 kg direct, 10 kg reverse.

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

YELLOWING (ASTM D 4587): ΔE< 5after 500 hours of QUV panel

CHEMICAL RESISTANCES:	Acetone	50 double passages	mark	excellent
	Ethylic alcohol	50 double passages	mark	excellent

REPAINTING: Wet on wet or after hardening of the primer coat.

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