

TECHNICAL DATA SHEET

Date of issue: 06/10/2012

Last updating: no.3 30/01/2018



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 GLOSSY	Category:	industry
Definition:	Stoving enamel	V.O.C. ready to use:	710 g/l
Code:	12.1.00016	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

One-pack product with high chemical and mechanical resistance, based on modified epoxy resins.

GENERAL USES

Stoving clear fit for the protection of metals, special alloys, such as nickel, brass, etc.

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the support must be complete and represents a necessary and fundamental condition to obtain positive result of the painting cycle. This means that the presence on the support of substances such as fats, oils, grease and dirt (and of course, for other reasons, rust and calamine) is absolutely not allowed. Traces of moisture, grease, waxes and polishing pastes, fingerprints compromise both adhesion and resistance to aqueous solutions, with the possibility of bittiness, staining and scaling.

Remove any trace of oxidation, grease and moisture by mechanical cleaning followed by degreasing with organic solvents.

PREPARATION OF THE PRODUCT

Dilute at 50-60% by volume with the specific synthetic thinner 07.062 to obtain a viscosity of 13-15" Ford 4 at 20° C. Carefully mix before applying the product.

APPLICATION

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

Electrostatic gun: the product is already prepared for this type of equipment

TECHNICAL DATA

PRODUCT TYPE: One-pack

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

COLOURS: Transparent. Attention: the introduction of transparent acid pigments (such as zapons) alters the stability of the product in stock, so once it is coloured, it must be used as soon as possible.

SPECIFIC WEIGHT (ISO 2811): 0.96 g/cm³ A+B (±0,05)

SUPPLY VISCOSITY(DIN 53211) : 26" ± 5" Ford 4

SOLID ON VOLUME: A + B 33% (± 2%)

SOLIDS CONTENT: A + B 32% (± 2%)

DRYING AT 20°C

- Flash-off:	15-20 minutes at 20°C
- Forced drying:	30 minutes at 160°C or 20 minutes at 180°C

RECOMMENDED COATS: One

THICKNESS: 10-15 µm

TECHNICAL DATA SHEET

Date of issue: 06/10/2012

Last updating: no.3 30/01/2018



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 GLOSSY	Category:	industry
Definition:	Stoving enamel	V.O.C. ready to use:	710 g/l
Code:	12.1.00016	Product outside the uses referred to	2004/42/CE

THEORETIC YIELD ¹:	15 m ² /kg
IMPACT TEST (ASTM D 2794):	36 kg direct, 36 kg reverse on sanded iron.
ADHESION (ASTM D 3359):	B=5 on surfaces treated like above reported. Excellent on iron, steel, aluminium, brass, platinum alloys
CHEMICAL RESISTANCES:	It withstands 50 double passages with acetone and ethyl alcohol.
REPAINTING:	Wet on wet. After complete curing, a light sanding of the underlying film is necessary.
STORAGE STABILITY:	One year stored in closed packs, in a cool, dry place, away from any sources of heat.

¹ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces for product ready to be used.