

TECHNICAL DATA SHEET

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Name:	THERMODUR MATT	Category:	Top coat
Definition:	Stoving synthetic enamel	V.O.C. ready to use:	690 g/l
Code:	12.4.00020	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

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

GENERAL USES

Stoving clear fit for special alloys, as nickel, brass, etc.

APPLICATION METHOD

PREPARATION OF SURFACES

Cleaning of surfaces to varnish must be accurate. Traces of moisture, grease, waxes and polishing pastes, finger prints, make a difficult adhesion and lower resistance to water solutions; marking by pricks, spots and scalings may happen.

PREPARATION OF THE PRODUCT¹

Dilute with 50-60% in volume of specific synthetic thinner 07.062 or 07.010 or 07.025 until a viscosity of 13-15" Ford 4 at 20°C. Mixing accurately the mixture before the application.

APPLICATION

- Spray gun: nozzles of 1,2-1,4 mm. diameter and 3-4 atm. pressure.
- Electrostatic gun. The product is already fit for this type of equipment.

TECHNICAL DATA

PRODUCT TYPE:	Monocomponent
FILM APPEARANCE (ASTM D 523):	matt, 20 gloss $\pm$ 5
COLOURS:	transparent
SPECIFIC WEIGHT (ISO 2811):	0,96 kg./l. ($\pm$ 0,05).
SUPPLY VISCOSITY (DIN 53211):	23" Ford 4 a 25°C. ($\pm$ 5")
SOLIDS CONTENT:	32% ($\pm$ 1)
DRYING AT 20°C:	- flash off: 20-30' - total curing: 30' at 160-165° C.
RECOMMENDED COATS:	One
THICKNESS²:	10-15 microns
THEORETIC YIELD³:	15 m ² /kg.
ADHESION (ASTM D 3359):	B=5. optimum on iron, steel, aluminium, brass, platinum alloys
CHEM. RESIST.⁴ (UNI EN ISO 12720):	Acetone, 24h, vote 5 Synthetic sweat, 7 days, vote 5
REPAINTING:	Wet on wet. After total hardening a slight sanding of the film is necessary.
STORAGE STABILITY:	One year for A component in closed packs, in a cool, dry place, away from any sources of heat.

¹ If you are painting big objects or surfaces, consider that the thermal inertia is bigger. So that is better to increase the stoving time of 10-15'.

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.