

TECHNICAL DATA SHEET



Date of issue: 31/03/2016

Last updating: n°2 24/07/2017

Name: ACRYLIC 2K GLOSSY
Definition: Acryl-urethane top coat
Code: 55.1

Category: Special finish (B/e)
V.O.C. ready to use: 550
V.O.C. limit: 840
Product according to 2004/42/CE

NATURE OF THE PRODUCT

Two-pack topcoat, based on acryl-polyester resins and isocyanic adduct to mix before use.

GENERAL USES

Car refinishing, commercial vehicles, vans and trucks refinishing. Suitable for high quality finishes when maximum outdoor resistance is required.

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.

The product needs a primer coat like our epoxy series 29.3, acrylic seires 69.3 or 69.4, or WB epoxy series 29W5.

- Ferrous surfaces. SA2 1/2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents. Then proceed with the application of a primer and then the top coat.
- Galvanized sheet. Accurate sanding (with scotch brite paper coarse grain) followed by degreasing using thinners. Then proceed with the application of a primer and then the top coat.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative light sanding procedure followed by degreasing using organic thinners. Then proceed with the application of a primer and then the top coat.

PREPARATION OF THE PRODUCT

	Code	Name	By weight	By volume
Comp. A	55.1	Acrylic 2K glossy	100 parts	100 parts
Comp. B	01.014	Polirex	50 parts	50 parts
Alternatively	01.H2	Acryrex MS	50 parts	50 parts

Carefully mix until an even colour and consistency are obtained. Usually dilution is not requested. Once hardened the product is ready to be used since it has a viscosity of 19"-22" Ford 4. If necessary, dilute at 5-10% with our thinner 07.093 or 07.055.

With temperature over 25°C we suggest using the slow hardener 01.012 and thinner 07.094 or 07.075 with the same ratio as the standard versions.

If it is necessary to accelerate the system, dilute with 1-5% of 03.034.

APPLICATION

Spray gun: nozzles of 1,2-1,4 mm. diameter and 2-4 atm. pressure.

Roller or brush ¹: Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: Two pack

FILM APPEARANCE (ASTM D 523): Glossy (>90 gloss)

COLOURS : By request. For white colours we start from our 55.1.90130 basic white and mixed with our tinting system tinters. For other colours the binder 55.1.K1 is mixed in a ratio 70/30 with our tinting system tinters.

SPECIFIC WEIGHT (ISO 2811): (A+B) 1,16±0,08 g/cm³ (for white colors)

SUPPLY VISCOSITY (DIN 53211): 18" ±3" cup Ford 8

SOLID ON VOLUME: 44±2% (A+B) (for white colours)

SOLIDS CONTENT: 52±2% (A+B) (for white colours)

DRYING AT 20°C

- Dust free: 20-30 minutes
- Touch free: 3 hours
- Total hardening: 24 ore
- Forced hardening: 45' a 60°C
- Maximum chemical resistance: after 7 days

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

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RECOMMENDED COATS: One crossed coat, followed after 5-10' by one coat

THICKNESS ²: 50-60 μm

THEORETIC YIELD ³: 8-10 m^2/kg

POT-LIFE AT 20° C 3 hours at temperature of 20° C. At higher temperatures, pot-life decreases.

SALT SPRAY TEST (ASTM B 117): 500 hours if applied on a cycle with primer and topcoat with a final dried film thickness of 160 μm

ADHESION (ASTM D 3359): B=5, optimal on iron, aluminum and galvanized sheet prepared like above specified.

IMPACT TEST (ASTM D 2794): 36 kg direct 10 kg reverse

YELLOWING (ASTM D 4587): after 1000 hours, $\Delta E < 4$

REPAINTING: After 1-2 hours minimum as wet on wet. Over 8-12 hours it is better a light sanding before overcoating.

STORAGE STABILITY: One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.

² Considering a dry film.

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.