colorificio sammarinese

Scheda tecnica
Technical data sheet

SERIES 5220.0000 INFRAROT 120° - SYNTHETIC STOVING ENAMEL

Uses

Kiln synthetic enamel which is employed in the very wide field of industrial painting where the paint hardening is granted in very short periods through the employ of a kiln. Thus to paint metal furniture, shelves, bicycles and motorbikes, metal playthings, metal trinkets, etc.
It may also be applied electrostatically by diluting it with the 9350.0027.

General data

- excellent cohesion on metal
- glossy appearance
- high elasticity
- compactness and toughness of the film
- good hiding power

Technical data (data gathered at the temperature of 20°C)

Viscosity Ford Cup 8	sec.	14 ± 2
Specific gravity	kg/l	1,160 ± 0,030
Solids	%	63 ± 1
Optimal application thickness	micron	30
Theoretical spreading rate	mq/l	9 - 10 (at the above mentioned thickness)
Adhesion (Cross Test)	%	100
Hardness (Bucholz system))		90
Cupping (Erichsen)	mm	9,5
Impact test	cm	higher than 80
Appearance of the film	gloss	85 (glossy)
Thinner	Code	9130.0005
Withering (pre-cooking)	minutes	10 - 15 at environmental temperature
Cooking	Minutes	30 at 120°C or 20 at 140°C.

Application modalities

By spray gun	To dilute with	9130.0005 at 15-20% till VxCF/4 = 25"
Spray gun	Nozzle size Pressure	mm 1,8 Atm 3 - 4

Recommended painting cycles

On sheet previously treated with Synthetic Coat for kiln series 5120.0000 cooked for 30' at 120° C.
It may be applied straightly on properly prepared sheet, but this will cause a little loss of cohesion.

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