



## Product Description

Alkyd-Amine Flat Stoving Finishing is an one component alkyd amine which has excellent adhesion hardness, flexibility, color retention and excellent resistance to impact.

## Recommended Use

This coating is used to paint exterior surfaces of electronic parts, desk, chair ,water heater, stoving , spare parts of car and other steel pieces.

## Surface Preparation

- 1: All surface to be coated clean, dry and free from contamination prior to paint application .Oil or grease should be removed in accordance SSPC-SP1 solvent cleaning.
- 2: Phosphate, chromate or use of wash primer for surface preparation is recommended.

## Product Description

|                                   |                             |
|-----------------------------------|-----------------------------|
| Percentage of Vehicle:            | 45%-55%                     |
| Percentage of Pigment & extender: | 40%-45%                     |
| Percentage of Volume solids:      | 47%-50%                     |
| Dry film thickness:               | 15-25 μ                     |
| Wet film thickness:               | 30-55 μ                     |
| Theoretical spreading rate:       | 11-12 m <sup>2</sup> /kg    |
| Thinner:                          | Alkyd-Amine Stoving Thinner |
| Shelf life:                       | 12 months                   |
| Glossy:                           | Flat                        |
| Specific gravity :                | 1.4-1.5 Kg/Lit              |
| Viscosity:                        | 110-120 k                   |

## Environmental Conditions

To prevent moisture condensation during application surface temperature must be at least 3 °C above the dew point .In hot climate, material temperature should be 20 to 25°C.For satisfactory cure air and surface temperature must be above 10°C.Never apply coatings under reverse environmental condition .Paint shall not be applied when wind speed is in excess of 7 m/s.

## Application Details

|               |   |
|---------------|---|
| Airless spray | Tip range: 0.018-0.021 inch<br>Total out put pressure at spray tip not less than 141 bar. |
| Air spray     | Nozzle orifice:1.8-2 mm<br>Nozzle pressure:2-4 bar  |





## Application Procedure

- 1: Flush all equipment with recommended cleaner before use.
- 2: Stir the product with a power mixer.
- 3: For air spray, thin with no more than 10-15% of recommend thinner for workability for airless spray 5-10% of thinner is normally sufficient.
- 4: For immersion procedure, 20% of thinner is recommended.
- 5: Apply wet coat by parallel passes overlap each pass 50% to avoid bare areas.
- 6: Double coat all welds, rough spots, sharp edges, rivets, bolts, etc. to ensure proper thickness.
- 7: Clean all equipment with recommend cleaner immediately after use.

## Safety

This product is flammable keep away from heat and open flame operator (accordance MSDS of this product) must use special mask and safety gloves and operation should be performed in environments which is equipped with suitable air conditions.

## Storage Conditions

Store in closed container and away from direct sunlight at temperature of 5-35 °C.

## Baking Condition

Induction time (before baking): 5-8 minutes

Temperature: 120-150°C

Baking time: 20-30 minutes

Note: For continuous system, length of transmitter tape should be is least 3 meters with least rate after exit from oven.

Note: execute can change time of baking if the temperature of oven is not stable.

