
Product Name: Low Temperature Stoving Finishes; PG6/23 Compliant

Product Number: 38-xxxx Range

Product Description: Low temperature stoving finishes for general metal finishing. Give excellent hardness and flexibility, allied to adhesion across a range of metals. Suitable for direct to metal application on degreased steels; can be applied over 38-xxxx series primer on rough or textured metal surfaces. Ideal for use on metal furniture, domestic & commercial heaters, automotive & aerospace components, including in-fill on badges.

VOC's less than 60% of solids content: PG6/23 Compliant

Performance: **Hardness:** 2000gm scratch with no penetration to substrate to ISO 1518 (BS.3900 E.2) on degreased mild steel. **Adhesion:** 1mm cross hatch to ISO2409; rating "0" (no removal) on degreased mild steel. **Packing/Banding Test:** Test components banded together immediately after curing/cooling: no sticking or printing.

Components: Base: 38-xxxx range single component coating
Thinner: SE-Thin if/as required

Application:

Surface Preparation: Ensure surfaces are clean and free from dust/dirt etc. Degrease using proprietary solvent or alkali degreaser. Coating can be applied as soon as surface is dry.

Paint Preparation: Stir thoroughly before use. Coating is supplied ready for use.

Application Method:

Spray: Conventional, HVLP or latest generation HD guns. use as supplied; can be thinned if/as required with 5-10% SE-Thin.

Airless/ Air Assisted Airless: use as supplied.

Electrostatic: Use as supplied; check with our technical team to suitability with specific electrostatic guns.

Product can be brushed on small areas; use as supplied.

Typical film weights: 85-100µ wet to give 55-65µ dry

Drying Curing:

Flash off: 10-20 minutes

Cure: 30 minutes @ 120°C (250°F) metal temperature.

20 minutes @ 150°C (302°F) metal temperature

Technical Properties:

Supply Viscosity: 50-60 seconds/ISO6 cup/23±0.5°C

Supply Solids: 64±2% W/W typical

VOC Content: 444gms/litre typical

Density: 1200-1250 gm/litre typical

Flash Point: >25°C

Colour Range: 38-2004-1 Pure Orange RAL 2004 semi-gloss
38-2011-1 Deep Orange RAL 2011 semi-gloss
38-5010-1 Gentian Blue RAL 5010 semi-gloss
38-9000-3 Black low sheen
Other colours available; please consult our sales office.

Pack Size: 5 ltr and 20ltr containers

Thinner: SE-Thin

Solvent/Clean Up: 40006 gunwash or Se-Thin

Theoretical Coverage: 9m²/litre @ 55µ DFT

Storage:

Flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

Disclaimer:

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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