

FAST DRY GLOSSY

Series 0320

Glossy, quick air drying, water-spotting resistant synthetic enamel



TECHNICAL FEATURES

Glossy, quick air drying synthetic enamel, formulated with special modified alkyd resins; the enamel is water-spotting resistant already after 24-48 hours depending on the applied thicknesses and the conditions of application. The product is fast drying and hardening even in deep coats. Furthermore, it is characterized by good filling properties, resistance to atmospheric agents, excellent gloss and body effect.

APPLICATION FIELD

Glossy synthetic enamel ideal for carpentry, industrial, agricultural and earth-moving machinery, when rapid handling of the product and durability over time are required.

GENERAL INFORMATION

System: One pack - 1K

Nature: Solvent-based

Packages: 1 kg - 4 kg - 5 kg/l - 20 kg/l

Tinting Service: Tinting service with solvent-based colorants Series 0615

Color fans and color cards: Ral 841 GL, Ral Design, Ncs 1950, ColoradoMix 1040, Colorado Box 2.0

SUBSTRATE PREPARATION

As this is a finishing product, in case of outdoor application or where anticorrosive protection is required, it is necessary to first apply a suitable primer. The preparation of the substrate must be carried out with reference to what is indicated in the specific technical data sheet of the appropriate primer. In order to investigate and select the ideal coating system, it is advisable to consult the technical assistance service or the commercial support in order to obtain the precise indication of the suitable primers to be used according to the type of product and the support to be painted. Finally, it is essential to respect the overcoating times of the primer.

APPLICATION

Application conditions

The application of the coating product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), geometry and laboriousness of the products to be painted, surface profiles and thicknesses to be applied. The application system to be used is of particular importance as, depending on the type of system, various parameters may vary including the transfer efficiency of the coating product, the overspray, the aesthetic appearance obtained, the sagging stability of the product and the ease or complexity of application. For these reasons, prior to applications on systems and lines of considerable scope, it is advisable to contact the technical assistance service in order to carry out the inspection and the necessary surveys for a consultancy activity relating to the application methods and the definition of ad hoc technical details on the plant in question.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	25" - 45" Ford Cup 4	1,4 - 1,6 mm	3,5 - 4 bar	-
AIRMIX	Depending on application parameters	9 - 11	60 - 100 bar	-
ELECTROSTATIC	-	-	-	Contact technical assistance to decide the suitable antistatic additive

ENVIRONMENTAL CONDITIONS



ENVIRONMENT
TEMPERATURE

5°C - 35°C



SUBSTRATE
TEMPERATURE

5°C - 35°C



RELATIVE
HUMIDITY

60 %



SHELF LIFE

Store 2 years in original sealed packaging at +5/+35°C.

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TECHNICAL DATA



THEORETICAL AVERAGE SPREADING RATE	APPLICATION	DILUTION	GLOSS	WET FILM THICKNESS EACH COAT	DRY FILM THICKNESS EACH COAT	N° OF COATS	TOTAL DRY FILM THICKNESS	THEORETICAL AVERAGE CONSUMPTION
7,6 m²/kg each coat at the dry film thickness of 50 µ	Spray	10-15% with Synthetic Thinner 90 Series 0955 o Anti-blooming Nitro Thinner Series 0970	85 - 95 gloss	130 µ	50 µ	1 or 2 coats to achieve the total desired thickness	80 µ	131 g/m²

DRYING



OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
4 - 8 hours	20°C	30 - 40 minutes	2 - 3 hours	24 - 36 hours	7 days	-	-	80°C

WARNINGS AND RECOMMENDATIONS

- As this is a finishing product, it has no anticorrosive properties, therefore in case of outdoor application or where anticorrosive protection is required, it is necessary to apply a suitable anticorrosive primer.
- It is recommended not to exceed the thickness applied in order not to run into problems of slow drying and less water resistance, thanks to the fact that the product is an oxidative system.
- Since the product is based on drying oils, its residues, tools, dust and overspray deposits, exhausted filters, paper and cloths soaked in the product, can cause self-combustion phenomena: it is therefore necessary to wet them with water and store them in airtight containers before disposal. Periodically check the rear of the booth, the exhaust channels and the fans and clean them from any overspray deposits that can cause self-combustion phenomena.
- After having colored the product with the suitable colorants, mix it in a short time.
- In order not to incur financial penalties, after having colored a product with tinting machine, send the MSDS and apply the appropriate legal labelling printable using the Databook P&C tinting software.
- For slightly matt colored products (yellow, orange, red) it is recommended to use a suitable white primer.
- The drying can be accelerated with catalysis by weight at 5-10% with Quick Air Drying Activator Series 0926.
- Once dried, the product cannot be over-coated with itself. Over-coating is allowed only at least 30 days after the application and only if the product has been applied in compliance with the thicknesses indicated in the technical data sheet.
- The product is water spotting resistant 48 hours after the application at the thicknesses and drying temperatures indicated in the technical data sheet.
- The color match is evaluated after the application and drying of the product. It is recommended to carry out practical tests, such as spreading or applying the colored product on small surfaces made of suitable material, before proceeding with the product painting.

SUPPLY TECHNICAL DATA

Composition: Modified alkyd
Reference color: White
% solid content by weight: 61 ± 2%
% solid content by volume: 46 ± 2%
VOC: 467 ± 2 g/l
VOS: 38.5 ± 2%

PARAMETER	DATA	TEST METHOD
GLOSS	85 - 95 gloss 60°	ISCOL 6
SPECIFIC WEIGHT	1 - 1.2 g/ml	ISCOL 2
VISCOSITY	1000 - 1500 mPa.s (20°C) Rod 3 Speed 20	ISCOL 1

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TINTING SERVICE

BASE	BASE PACKAGING	COLORED PACKAGING	% MIXING RATIO
BINDER	0,8 kg 3,2 kg 16 kg/L	1 kg 4 kg 20 kg/L	80 - 20
WHITE BASE	4,8 kg/L 19,2 kg/L	5 kg/L 20 kg/L	96 - 4

NOTES

Cleaning tools: At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

Sanitary labelling: Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

Additional notes:

- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.
- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, other than those mentioned or not manufactured by Franchi&Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi&Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- All times indicated in the drying section are to be intended at the temperature of 20°C, unless otherwise specified.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website www.franchi-kim.com in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

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