

CHASSIS PAINT DTM

Series 0333

DTM, semi-glossy, fast-drying, anti-oil final coat for chassis



TECHNICAL FEATURES

DTM, semi-glossy, fast-drying finishing-primer for chassis with good resistance to industrial oil, over-sprayable with itself, nitro, polyurethane and acrylic enamels. The product is characterized by good adhesion and it is based on passivating pigments that make the enamel suitable for direct application on metal with anticorrosive function.

APPLICATION FIELD

Suitable as finishing-primer for chassis of agricultural wagons and industrial vehicles, as well as for metal structures, machine tools, agricultural machinery, carpentry, cranes and lifting systems.

GENERAL INFORMATION

System: One pack - 1K

Nature: Solvent-based

Packages: 5 kg - 24 kg/l

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

Suitable Substrates: Iron, Cast iron, Sandblasted Iron -

Sandblasting Sa 1-2, Sandblasted Iron - Sandblasting Sa 2,5-3

Overcoatable with: Fast drying, nitro and polyurethane enamels

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

SUBSTRATE PREPARATION

The surface pre-treatment process, to be carried out prior to the application of the coating product, is of considerable importance in order to obtain and guarantee optimal and long-lasting results and performance over time. The substrate must be perfectly clean, dry, degreased and free from rust and/or calamine. It is also advisable to make sure that the substrate is free from particles and other paints that are not perfectly adherent or incompatible with the coating of paint that will be applied. For the purpose of a correct and complete preparation, it is recommended to consult, where necessary, the explanatory notes attached to the technical data sheet, the painting manual and the technical assistance service of the Research & Development Laboratory. The explanatory notes, specifically, depending on the type of surface and the result to be obtained, indicate different pre-treatment methods such as degreasing, manual and mechanical cleaning using special equipment, mechanical preparations (scraping, sanding, tapping, brushing), light or accurate sandblasting, shot blasting, shot peening and wet sandblasting (or hydro sandblasting).

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.

By virtue of the 1K, synthetic nature of the product, there may be phenomena of embrittlement of the film after overcoating with 2K products (acrylic or polyurethane), thus leading to a greater sensitivity of the film to mechanical stress. In cases where this characteristic is essential, it is necessary to opt for a 2K epoxy primer.

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

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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.

TECHNICAL DATA



THEORETICAL
AVERAGE
SPREADING RATE

7,5 m²/kg
each coat at the
dry film thickness
of 50 µ



APPLICATION

Spray



DILUTION

10% with
Synthetic Thinner
90 Series 0955
o Anti-blooming
Nitro Thinner
Series 0970



GLOSS

25 - 35 gloss



WET FILM
THICKNESS
EACH COAT

90 µ



DRY FILM
THICKNESS
EACH COAT

50 µ



N° OF COATS

1 or 2 coats to
achieve the total
desired thickness



TOTAL DRY FILM
THICKNESS

80 µ



THEORETICAL
AVERAGE
CONSUMPTION

133 g/m²

DRYING



OVERCOATING
INTERVAL

2 hours



AIR DRYING

20°C



DUST-FREE
DRYING

15 - 20 minutes



DRY TO TOUCH

1 - 3 hours



DRY THROUGH

24 - 36 hours



FULL CURE

7 days



FLASH OFF

-



STOVING DRYING

-



RESISTANCE TO
TEMPERATURE

80°C continuous
exposure

WARNINGS AND RECOMMENDATIONS

- 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.
- The product can be applied directly, without the aid of a primer, only in the presence of not extremely shiny and new galvanized steel.
- To obtain a homogeneous satin/matt effect, the product must be applied in light coats, trying to maintain regular and homogeneous thicknesses.
- 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.
- 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.
- 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 DTM, one coat, low opacity colored products (yellow, orange, red), to check the shade, apply two coats of 100 µ w.f.t. of the product.
- By virtue of the particularity of the product, it is specified that the gloss range indicated in the parameters and supply technical data may undergo in excess variations because of the application.

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DTM

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SUPPLY TECHNICAL DATA

Composition: Modified alkyd
Reference color: White
% solid content by weight: $73 \pm 2\%$
% solid content by volume: $54 \pm 2\%$
VOC: 392 ± 2 g/l
VOS: $27.3 \pm 2\%$

PARAMETER	DATA	TEST METHOD
VISCOSITY	1250 - 1750 mPa.s (20°C) Rod 4 Speed 20	ISCOL 1
GLOSS	25 - 35 gloss 60°	ISCOL 6
SPECIFIC WEIGHT	1.25 - 1.4 g/ml	ISCOL 2

TINTING SERVICE

BASE	BASE PACKAGING	COLORED PACKAGING	% MIXING RATIO
BINDER	4 kg 19,2 kg/L	5 kg 24 kg/L	80 - 20

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 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 gloss indicated and tested may change during the application phase because it can be influenced by the following factors: realized color, thickness, number of coats, environmental conditions, thinner and hardener used if different from those established in the technical data sheet.
- 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 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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