NITROSYNT

Series 0632

Glossy, nitro synthetic enamel for industrial use

TECHNICAL FEATURES

Nitro-synthetic enamel based on nitrocellulose and alkyd resins, with very fast drying and excellent high building.

APPLICATION FIELD

Nitrosynthetic enamel ideal for industrial and agricultural machinery, shelving, carpentry structural works and metal products. The product is ideal for the re-coatings of cylinders and small tanks.

GENERAL INFORMATION

System: *One pack - 1K*
Nature: *Solvent-based*
Packages: *19 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 - 1,7 mm	3,5 - 4 bar	-

ENVIRONMENTAL CONDITIONS

ENVIRONMENT TEMPERATURE	SUBSTRATE TEMPERATURE	RELATIVE HUMIDITY	SHELF LIFE
5°C - 35°C	5°C - 35°C	60 %	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
7,7 m²/kg each coat at the dry film thickness of 40 µ	Spray	20-30% with Nitro Thinner NT 88 Series 0975	80 - 95 gloss	120 µ	40 µ	1 or 2 coats to achieve the total desired thickness	60 µ	128.7 g/m²

DRYING

OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
6 - 24 hours Without particular critical times	20°C	5 - 10 minutes	1 - 2 hours	24 - 36 hours	6 days	-	-	80°C continuous exposure

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.*
- *In the presence of high concentrations of humidity in the air it is possible that during the drying phase the film tends to opacify. To overcome this drawback it is necessary to use small percentages (3-5%) of 0996 Series Anti-Whitening Additive.*
- *For the realization of tinting system colors containing in the formulations the colorants Series 0615 color 380 Yellow, 422 Orange and 506 Red, phenomena of solubilization and therefore extraction of the underlying color in cases of repainting may occur, thus highlighting the so-called phenomenon of "bleeding".*
- *The color match is evaluated after the application and drying of the product.*
- *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.*
- *After having colored the product with suitable colorants, mix the product immediately to avoid crystallization and relative pitting of the applied product.*

SUPPLY TECHNICAL DATA

Composition: *Nitro-alkyd*
Reference color: *White*
% solid content by weight: *44 ± 2%*
% solid content by volume: *33 ± 2%*
VOC: *585 ± 2 g/l*
VOS: *55.5 ± 2%*

PARAMETER	DATA	TEST METHOD
VISCOSITY	800 - 1000 mPa.s (20°C) Rod 3 Speed 20	ISCOL 1
SPECIFIC WEIGHT	0.95 - 1.03 g/ml	ISCOL 2
RESISTIVITY	30 - 50 M-ohm.cm	ISCOL 8
GLOSS	80 - 95 gloss 60°	ISCOL 6

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TINTING SERVICE

BASE	BASE PACKAGING	COLORED PACKAGING	% MIXING RATIO
BINDER	15,2 kg/L	19 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 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.*

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