

ACRIBRASS

Series 3250

High resistance, acryl-urethane, stoving and air drying, matt clearcoat for brass and alloys



TECHNICAL FEATURES

Matt protective clearcoat based on acrylic resins and aliphatic isocyanic hardeners for metals such as brass, copper and light alloys, silver and zamak where a high surface hardness, resistance to yellowing and whitening are required.

APPLICATION FIELD

The product is suitable as matt topcoat in coating systems with matt bases in the industrial sector or as a single coat direct on brass, light alloys and silver.

GENERAL INFORMATION

System: Two pack - 2K

Nature: Solvent-based

Packages: 4 l

SUBSTRATE PREPARATION

As this is a clear coat, a suitable primer and intermediate (colored base coat) must first be applied. The preparation of the substrate must therefore be carried out with reference to what is indicated in the specific technical data sheet of the selected 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 and the intermediate.

Should the support be made of polished brass, verify that the surface does not have any polishing paste residue. Subsequent ultrasonic immersion pickling operation is requested.

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.

Spray application with HVLP/LVLP gravity gun with 1.3 - 1.5 mm nozzle is recommended.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	18" - 22 " Ford Cup 4	1,3 - 1,5 mm	3,5 - 4 bar	-

CATALYSIS

SERIES	HARDENER	CATALYSIS	USE	POT LIFE AT 20°C	PACKAGE
1383	STANDARD HS HARDENER	25% by volume (4:1)	Standard	6 hours	1 l

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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

5,4 m²/l
each coat at the
dry film thickness
of 50 µ



APPLICATION

Spray



DILUTION

10% with
Unithinner
Series 0934



GLOSS

2 - 4 gloss



WET FILM
THICKNESS
EACH COAT

185 µ



DRY FILM
THICKNESS
EACH COAT

50 µ



N° OF COATS

2 coats to
achieve the
total requested
thickness: 1st light
and closed coat
2nd normal coat



TOTAL DRY FILM
THICKNESS

60 µ



THEORETICAL
AVERAGE
CONSUMPTION

185 g/m²

DRYING



OVERCOATING
INTERVAL

-



AIR DRYING

20°C



DUST-FREE
DRYING

45 minutes



DRY TO TOUCH

5 - 6 hours



DRY THROUGH

24 - 48 hours



FULL CURE

7 days



FLASH OFF

10 minutes at
20°C



STOVING DRYING

30 minutes at
60°C



RESISTANCE TO
TEMPERATURE

80°C continuous
exposure

WARNINGS AND RECOMMENDATIONS

- Being a finishing product, it has no anticorrosive properties.
- The use of nitro thinners for the application of polyurethane coating systems can create pitting phenomena on the surface of the dried film. Furthermore, the presence of partially reactive solvents can give rise to undesired reactions, reducing the aesthetic and mechanical features of the system. The choice of unsuitable regenerated thinners can create problems of color change, product sedimentation and less effectiveness in reducing viscosity.
- To obtain a homogeneous satin/matt effect, the product must be applied in light coats, trying to maintain regular and homogeneous thicknesses.
- The product is limitedly resistant to solvents generally intended as temporary contact and limited in time.
- Shelf Life Component B: the shelf life of the hardener used with Component A is 12 months.
- The product is not suitable as final coat for cars if a specific finish is required.
- In case of particularly low temperatures and/or if it not possible to use hot air drying booths, the Accelerating Additive Series 3555 can be used in the following ratio by volume: 4 parts of Acribrass Series 3250 + 1 part of Standard HS Hardener Series 1383 + 0.15 parts of Accelerating Additive Series 3555 (100 + 25 + 7,5 Accelerating Additive).
- In order to accelerate the drying, as an alternative to the Standard HS Hardener Series 1383, the HS Fast Hardener Series 1389 can also be used in the same way.
- Differently from glossy finish, the scratch and polish resistance are lower.

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SUPPLY TECHNICAL DATA

Composition: Modified acrylic
Reference color: Transparent
% solid content by weight: $31,8 \pm 2\%$
% solid content by volume: $25,5 \pm 2\%$
VOC: 658 ± 2 g/l
VOS: $68 \pm 2\%$

PARAMETER	DATA	TEST METHOD
VISCOSITY	20 - 25 seconds Ford Cup 4	ISCOL 4
SPECIFIC WEIGHT	0,95 - 1,05 g/ml	ISCOL 2
GLOSS	2 - 4 gloss 60°	ISCOL 6

MIXING RATIO A+B

Specific weight after catalysis (A+B): $0,97 \pm 0,05$ g/ml
% solid content by weight (A+B): $33 \pm 2\%$
% solid content by volume (A+B): $27 \pm 2\%$
VOC (A+B): 646 ± 2 g/l
VOS (A+B): $66,6 \pm 2\%$

METHOD	1383
A+B BY WEIGHT	100 + 25
A+B BY VOLUME	100 + 25

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, different from those suggested 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.
- The times related to pot life and drying intervals refer to a standard temperature of 20°C, except when it is expressly indicated.
- 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 listed in the technical data sheet.
- The data relating to section mixing ratio A+B are to be considered referring only to the first recommended catalyst.
- 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.
- Pot Life times have been defined at the temperature of 20°C, therefore higher or lower temperatures, hardeners, environmental conditions and humidity different from the standard can influence in defect or in excess the duration of the Pot Life.

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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