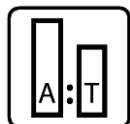


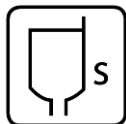
Technical Data Sheet

434.IC444

SINTOFAST OPACO GRIGIO IC 444



1000 g+
100-200 g



20"-24" FORD 4
at 20°C



Ø 1.4 - 1.8 mm
4-5 atm



At 20°C: 24-36 hours
At 60°C: 60-70 minutes

PRODUCT DESCRIPTION:

Synthetic finish based on resins with a fast drying time, such as alkyd resins.

FIELDS OF APPLICATION:

For varnishing all types of structures or machinery intended for outdoor use, such as chassis, agricultural machinery in general and construction machinery (tractors, farm trailers, cranes, bulldozers, machine tools, etc.).

SURFACE PREPARATION:

- Ferrous surfaces:** Thoroughly remove all traces of rust, scale, grease and moisture by means of thorough mechanical cleaning followed by degreasing. Apply one coat of our undercoat-primer **SINTOFLEX - 494** or **490 series**. After 6-12 hours, apply the fast-drying enamel.
- Aluminium:** Sanding, followed by degreasing with organic solvents. Apply one coat of **Epoxy Primer 193** or **190**, or **Acrylic 793**.
- Zinc plated steel sheets:** Light sanding or wire brushing followed by degreasing with solvents. Apply one coat of **193** or **190 series Epoxy undercoat-primer**, or **994 series Monoflex undercoat-primer**.

PRODUCT PREPARATION:

Comp. A:	434.IC444	100 parts by weight
Thinner (*):	D.434 / D.525	10-20 parts by weight

(*) For ambient temperatures ≥ 25 °C, we recommend using only synthetic thinner D.434.

PRODUCT SPECIFICATIONS:

PRODUCT TYPE	: 1K synthetic finish	
FILM APPEARANCE	: Matt 15 gloss (± 5)	
COLOURS	: Grey IC 444	
SPECIFIC GRAVITY	: 1.40 kg/l (± 0.05)	
SUPPLY VISCOSITY	: 10" (± 2) DIN 8 at 25°C	
VOLUME SOLIDS	: 43% (± 2)	
SOLIDS BY WEIGHT	: 61% (± 2)	
Drying time at 20°C	: - Dust-free	: 20–25 mins
	: - Touch dry	: 4–5 hours
	: - Fully cured	: 24–36 hours
	: - Forced drying	: 30–40 minutes at 60°C
RECOMMENDED LAYERS	: 1 (cross-coating)	
RECOMMENDED THICKNESS	: 50–60 μm ⁽²⁾	
THEORETICAL COVERAGE	: 8.7 m^2/l or 6.7 m^2/kg at 50 μm dry	
RECOATABILITY	: Wet on wet or within 2–3 hours at 20°C	

⁽²⁾ Do not exceed the recommended film thicknesses to avoid compromising the proper hardening of the film.
Opacity may vary depending on the applied thickness and dilution.

SAFETY PRECAUTIONS:

Strictly adhere to the instructions on the label and in the safety data sheet.

STORAGE CONDITIONS:

The storage area must be dry and maintained at a temperature between +10 °C and +35 °C.

The data and information contained in this data sheet are based on our experience and on thorough laboratory tests. However, as the varnishing process involves a series of operations beyond our control, this information does not in any way constitute a guarantee of the final performance of the process itself.

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