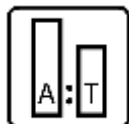


*Data sheet*

**803.14063**

**140 °C BAKED-ON SEMI-MATTE CLEARCOAT**



1000 gr +  
200 - 300 gr



15 - 17" ASTM 4  
at 20°C



Ø 1.1 - 1.3 mm  
3.5 Atm  
N° of coats 2



At 140 °C: 30'  
At 150 °C: 25'

**NATURE OF PRODUCT:**

Clear semi-matte protective paint for metal substrates, based on special alkyd resins and thermosetting resins. The resulting film has excellent adhesion, hardness, elasticity, resistance to salt spray and artificial sweat.

**FIELD OF APPLICATION:**

Especially suitable for painting brass, copper, galvanic substrates such as gold-plated brass, nickel, and black nickel.

**PREPARATION OF THE SUBSTRATE:**

The substrate should be free of any kind of surface contaminants, (grease, traces of oxidation, residues of waxes or polishing pastes, residues of substances from galvanic baths, etc.) so it should be treated with appropriate cleaning methods.

**PREPARATION OF THE PRODUCT:**

Comp. A	: 803.14063	100 parts by weight
Diluent	: D.850/D.880	20 - 30 parts by weight

In special cases, to eliminate distension defects, peel, bubble formation, replace part of the thinner (5%) with retardant **10304R**.

Various dilutions are possible, depending on the working temperature, but especially depending on the application system (manual or electrostatic).

## PRODUCT SPECIFICATIONS:

<b>TYPE OF PRODUCT</b>	: Single-component.
<b>APPEARANCE OF THE FILM</b>	: Semi-matte
<b>COLORS</b>	: Clear
<b>SPECIFIC WEIGHT</b>	: 0,97 Kg/Lt ( $\pm 2$ )
<b>SUPPLY VISCOSITY</b>	: 21" $\pm 2$ at 20 °C ASTM 4
<b>DRY RESIDUE</b>	: 33% ( $\pm 2$ )
<b>DRYING AT 20 °C.</b>	: - <i>Dry dust-free</i> : 15' - <i>Forced drying</i> : 30' at 140 °C - <i>Or</i> : 25' at 150 °C
<b>RECOMMENDED LAYERS</b>	: A cross coat
<b>RECOMMENDED THICKNES</b>	: 15 - 20 Micron dry
<b>OPACITY</b>	: 35 Gloss ( $\pm 2$ )
<b>RECOATING:</b>	: Wet-on-wet or after complete baking, after sanding

## NOTE:

If necessary, the paint can be colored with our **50100M** series color concentrates at the rate of 1-3% referred to 100 parts of undiluted paint.

Larger additions are also possible, however, we recommend preliminary testing of the suitability of the complete cycle before moving to industrial-scale production.

Possible application with preheater (40 °C); in this case we recommend the use of D.880 thinner in the amount of 8 - 12%

**Recommended baking times and temperatures refer to the temperature of the metal to be painted.**

## SAFETY REGULATIONS:

Strictly follow the instructions on the labeling and in the safety data sheet.

## STORAGE CONDITIONS:

In unopened and sealed packages, kept at a temperature of +5 to +30 °C.

*The data and information contained in this sheet are the result of our experience and accurate laboratory tests. However, since the painting process represents a set of operations that are beyond our control, they do not therefore guarantee, in any way, the final performance of the cycle.*

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