

Data sheet

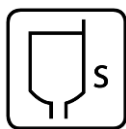
Series 411

K.411

EXTRA-GLOSSY SINTOCAR VARNISH R.E.



1000 gr +
150 - 200 gr



20" - 22" FORD 4
at 20 °C



Ø 1.4 - 1.8 mm
4 - 5 Atm
N° of coats 2



Drying 20' at 20 °C
Baking 30' at 60 °C

NATURE OF PRODUCT:

Fast-drying synthetic finish based on alkyds, characterized by good gloss.
Very good resistance to weathering, oils, gasoline and fuels in general.

FIELD OF APPLICATION:

Industrial bodywork, agricultural machinery, carpentry, etc.

PREPARATION OF THE SUBSTRATE:

Iron surfaces: Remove any traces of rust, grease, calamine and humidity by means of thorough mechanical cleaning, followed by degreasing. Apply one coat of our **Sintoflex 494 or 490 series** primer. After 6- 12 hours apply Fast **Drying Enamel**.

Aluminum: Sanding followed by degreasing with organic solvents. Apply one coat of **Epoxy Primer 193 or 190, or Monoflex Primer 994 series**.

Galvanized sheet: Light sanding or buffing followed by degreasing with solvents. Apply one coat of **Epoxy Primer Series 193 or 190, or Monoflex Primer Series 994**.

PREPARATION OF THE PRODUCT:

Comp. A:	K.411 + Coloring Pastes	100 parts by weight
Diluent ⁽¹⁾ :	D.434 or D.525	15 - 20 parts by weight

Mix until the color and consistency are uniform.

Dilute to the desired viscosity.

⁽¹⁾ For ambient temperatures \geq of 25 °C, only synthetic thinner D.434 should be used.

To improve overall strengths, hardness and speed of curing, it is possible to catalyze the enamel with our CZ.265 at 10% max. In this case, however, we recommend using only D.535 thinner or D.219.

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: Single-component.
APPEARANCE OF THE FILM	: Glossy
COLORS	: By choice
DENSITY	: 0,99 Kg/l ($\pm 0,05$)
SUPPLY VISCOSITY	: 110" (± 3) DIN 8 at 25 °C
SOLID CONTENT	: 51% ($\pm 2\%$)
DRYING AT 20 °C	: - <i>Dry dust-free</i> : 20' - 30' : - <i>Print-free</i> : 4 - 5 hours : - <i>Forced Drying</i> : 30' at 60 °C
RECOMMENDED LAYERS	: A cross coat
RECOMMENDED THICKNESS	: 40 - 50 μm ⁽²⁾
THEORETICAL YIELD ⁽³⁾	: 9,6 m ² /Lt or 8,5 m ² /Kg at 50 μm dry
RECOATING:	: Wet-on-wet or max within 2/3 hours at 20 °C

⁽²⁾ Do not exceed the recommended thicknesses to avoid compromising the regular curing of the film.

⁽³⁾ In 75/25 ratio with **P.900**.

SAFETY REGULATIONS:

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

STORAGE CONDITIONS:

The storage room must be dry and with a temperature between +10 °C and +35 °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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