

Technical data sheet

Series 411

K.411

SINTOCAR EXTRA GLOSS



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:

High-quality, fast-drying synthetic gloss finish based on alkyd resins.

Properties:

- High gloss appearance
- High drying speed
- Good resistance to weathering, oils, petrols and fuels
- Easy applicability

FIELD OF APPLICATION:

Industrial bodywork, agricultural machinery, carpentry, various types of metalwork.

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 ≥ 25 °C, we recommend the use of synthetic thinner D.434 only

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	: Fast-drying Synthetic Finishes 1K
APPEARANCE	: Glossy
COLORS	: By choice
DENSITY	: 0,94 Kg/l ($\pm 0,05$)
SUPPLY VISCOSITY	: 16" (± 2) DIN 8 at 25 °C
SOLID % - VOLUME	: 49% ($\pm 2\%$)
SOLID % - WEIGHT	: 51% ($\pm 2\%$)
DRYING AT 20 °C	: - Dry dust-free : 20' - 30'
	: - Touch-free : 4 - 5 hours
	: - Forced Drying : 30' at 60 °C
RECOMMENDED LAYERS	: 1 (cross layer)
RECOMMENDED-DFT	: 40 - 50 μm ⁽²⁾
THEORETICAL YIELD ⁽³⁾	: 10,2 m ² /Lt or 9,5 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.

APPLICATION INSTRUCTIONS:

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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.