

*Technical data sheet*

**Series 421**

**K.421**

**SINTOLUX STANDARD 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:**

Fast-drying Synthetic Gloss Finish based on Alkyd Resins

**Properties:**

- Glossy aesthetic appearance
- Excellent drying time
- Good resistance to atmospheric agents, oils, petrols and fuels in general.
- Easy applicability

**FIELD OF APPLICATION:**

Fast-drying gloss finish for painting carpentry, metalwork of various kinds, machine tools, agricultural machinery in general and operating machines (tractors, agricultural wagons, cranes, bulldozers).

**RECOMMENDED PRIMERS:**

See in substrate preparation

**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.421 + Coloring Pastes** 100 parts by weight

Diluent <sup>(1)</sup>: **D.434 or D.525** 15 - 20 parts by weight

Mix until the color and consistency are uniform.

Dilute to the desired viscosity.

<sup>(1)</sup> For ambient temperatures  $\geq 25\text{ }^{\circ}\text{C}$ , 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 glaze with our CZ.265 at 10% max. In this case, however, we recommend using only D.535 thinner or D.219.

## PRODUCT SPECIFICATIONS:

<b>TYPE OF PRODUCT</b>	: Fast-drying Synthetic Finishes 1K	
<b>APPEARANCE</b>	: Glossy	
<b>COLORS</b>	: By choice	
<b>DENSITY</b>	: 0,983 Kg/l ( $\pm 0,05$ )	
<b>SUPPLY VISCOSITY</b>	: 12" Ford 8 at 25 °C	
<b>SOLID % - VOLUME</b>	: 48 % ( $\pm 2\%$ )	
<b>SOLID % - WEIGHT</b>	: 51% ( $\pm 2\%$ )	
<b>DRYING AT 20°C</b>	: - Dry dust-free	: 20' - 30'
	: - Touch-free	: 5 - 6 hours
	: - Forced Drying	: 30' at 60 °C
<b>RECOMMENDED LAYERS</b>	: 1 (cross layer)	
<b>RECOMMENDED-DFT</b>	: 40 - 50 $\mu\text{m}$ <sup>(2)</sup>	
<b>THEORETICAL YIELD</b> <sup>(3)</sup>	: 9,9 m <sup>2</sup> /Lt or 9,1 m <sup>2</sup> /Kg at 50 $\mu\text{m}$ dry	
<b>RECOATING:</b>	: Wet-on- wet or max within 2/3 hours at 20 °C	

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

<sup>(3)</sup> 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.*

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