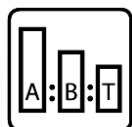


Data sheet

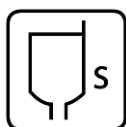
Series 714

K.714

PLASTIKGRIP - ACRYLIC X PLASTICS



1000 gr +
150 gr +
200 - 300 gr



18" - 22" FORD 4
at 20 °C



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



Drying 15' at 20 °C
At 80 °C: 30' - 40'

NATURE OF PRODUCT:

Two-component matte enamel based on acrylic and polyurethane resins, to be cross-linked with aliphatic isocyanates (non-yellowing).

FIELD OF APPLICATION:

High-quality top coat, especially suitable for direct coating of plastic substrates (ABS, ABS+PC, PUR. PU, PF). Suitable for both products that remain indoors and those that are exposed to weather. Compatible with electrostatic application systems.

Possibility of direct painting on metals (steel, galvanized steel, brass and zamak) as well, after appropriate pretreatment of the metals. For application to metal, preliminary testing is recommended before moving on to large-scale production.

PREPARATION OF THE SUBSTRATE:

The substrate should be free of any form of surface contaminants (grease, traces of oxidation, waxes, release agents, etc.), so it should be treated with appropriate cleaning methods.

For plastic substrates such as ABS and PVC and rigid PVR, the product can be applied directly to the workpiece. In case of painting other plastics, contact Vernici Caldart Laboratory.

Suitable for application on properly prepared PP (flaming and possibly **PP603** primer).

PREPARATION OF THE PRODUCT:

Mix Component A thoroughly until uniform in color and consistency, then proceed to mix it with Comp. B in the ratio shown below:

Comp. A:	K.714 + Coloring Pastes	100 parts by weight
Comp. B:	CZ.711	15 parts by weight
Or:	CZ.265	17 parts by weight
Diluent:	D.737	20 - 30 parts by weight ⁽¹⁾

⁽¹⁾ Dilute the perfectly blended mixture to a viscosity of 18-20" ASTM 4 at 20 °C.

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: Two-component;	
APPEARANCE OF THE FILM	: Matte.	
COLORS	: By choice	
DENSITY Comp. (A)	: 1,41 kg/lt ($\pm 0,05$)	
SUPPLY VISCOSITY	: 21" (± 2 ") DIN 8 at 25 °C	
SOLID CONTENT	: 69% ($\pm 2\%$)	
DRYING	: - <i>Dry dust-free</i>	: 10' at 15 °C - 25 °C
	: - <i>Print-free</i>	: 2.5 - 3 hours
	: - <i>Forced Drying</i> ⁽²⁾	: 30' - 40' at 60 °C - 80 °C
RECOMMENDED LAYERS	: Two coats	
OPACITY ⁽⁴⁾	: 13 (± 3) Gloss depending on color	
THEORETICAL YIELD ⁽³⁾	: 10,1 m ² /lt or 7,2 m ² /kg at 50 µm dry	
RECOMMENDED THICKNESS	: 40 - 50 µm dry	
POT-LIFE AT 20 °C	: 2 hours. The pot-life decreases at higher temperatures	

⁽²⁾ the product also dries at room temperature, however, to achieve the best possible chemical and adhesion strengths, we recommend (when the substrate allows it) baking in an oven at 80 °C for 30 minutes minimum.

⁽³⁾ in 80/20 ratio with P.900

⁽⁴⁾ the final opacity may vary depending on the color and thickness applied. Any furnace drying, especially with short drying, could result in a film with less opacity than a process based on room temperature drying.

RECOATING:

Wet-on-wet or following complete curing, after light sanding of the film to ensure good adhesion of the finishing coat.

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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