

Technical data sheet

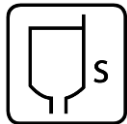
## Series 854

## K.854

# MATT SILICONE-BASED BINDER



1000 gr +  
250 - 300 gr



20"- 22" FORD 4  
at 20 °C



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



Drying: 15' at 20 °C  
Baking: 30' at 150 - 180 °C

### NATURE OF PRODUCT:

Heat-resistant matte finish based on special modified silicone resins.

Properties:

- Good direct adhesion
- Good hardness
- Good chemical resistance and low thermoplasticity
- Matt appearance

### FIELD OF APPLICATION:

Suitable for Opaque direct protection and decoration of metal and glass parts, with thermal stability up to 200-300 °C with peaks up to 350 °C, depending on the final enamel color <sup>(1)</sup>.

Suitable for painting small household appliances (toasters, fryers, etc.) and/or iron, aluminum or glass parts used in lighting.

<sup>(1)</sup> For more information regarding the heat stability of each individual **P.color** or paste, contact **Vernici Caldart R&D Laboratory**.

### PREPARATION OF THE SUBSTRATE:

**Iron surfaces:** Thoroughly and completely remove any traces of oxidation, grease, oils or moisture to the substrate, through appropriate treatments chosen in relation to the type of contaminant to be removed, the type of product from the performance required by the painting cycle, as well as the composition of the cycle itself.

**Aluminum:** Carefully scour the surface to be painted and degrease it thoroughly.

**Glass:** Sandblasting or acid-etching.  
Alternatively, thorough cleaning possibly by flaming.

### PREPARATION OF THE PRODUCT:

Comp. A:	<b>K.854 + Coloring pastes</b>	100 parts by weight
Diluent:	<b>D.219</b>	25 - 30 parts by weight
Additive (for glass):	<b>Z.209</b>	1 - 2 parts by weight

## PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: 1K Heat Resistant Finish
APPEARANCE OF THE FILM	: Matt
COLORS	: By choice
SPECIFIC WEIGHT	: 1,20 Kg/lit ( $\pm 0,05$ )
SUPPLY VISCOSITY	: 9" ( $\pm 1$ ) FORD 8 at 25 °C
SOLID % - VOLUME	: 40% ( $\pm 2$ )
SOLID % - WEIGHT	: 59% ( $\pm 2$ )
DRYING AT 20°C <sup>(2)</sup>	: - Dry dust-free : 10' - 15' : - Forced drying : 30' at 160 °C : - Forced drying : 15' at 250 °C
RECOMMENDED LAYERS	: 1 (cross coat)
RECOMMENDED – DFT <sup>(3)</sup>	: 20 - 25 $\mu$ m
THEORETICAL YIELD	: 13,4 m <sup>2</sup> /lt or 10,3 m <sup>2</sup> /kg at 30 $\mu$ m

<sup>(2)</sup> In the case of large mass parts, the time required for the part to reach the recommended curing temperature should be factored into the baking cycle.

<sup>(3)</sup> Do not exceed the recommended thickness as problems with film release may occur.

## APPLICATION INSTRUCTIONS:

View pictograms Page 1.

## 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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