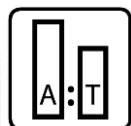


Data sheet

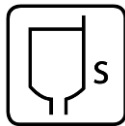
Series 854

K.854

MATTE SILICONE CONVERTER



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:

Baked varnish based on special modified silicone resins.

FIELD OF APPLICATION:

Suitable for 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 ⁽¹⁾.

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

The resulting film is characterized by good adhesion, hardness, low thermoplasticity and excellent chemical resistance.

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

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: Single-component.	
APPEARANCE OF THE FILM	: Matte	
COLORS	: By choice	
SPECIFIC WEIGHT	: 1,20 Kg/lit ($\pm 0,05$)	
SUPPLY VISCOSITY	: 9" (± 1) FORD 8 at 25 °C	
DRY RESIDUE	: 54% (± 2)	
DRYING ⁽²⁾	: - <i>Dry dust-free</i>	: 10' - 15'
	: - <i>Forced drying</i>	: 30' at 160 °C
	: - <i>Forced drying</i>	: 15' at 250 °C
RECOMMENDED LAYERS	: A cross coat	
RECOMMENDED THICKNESS	: 20 - 25 μ m	

⁽²⁾ 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.

⁽³⁾ **Do not exceed the recommended thickness as problems with film release may occur.**

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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