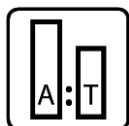


Data sheet

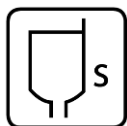
Series 922

K.922

CONVERTER 2C FOR ALUMINUM ENAMELS



1000 gr +
350 gr



13" - 15" ASTM 4
at 25 °C.



Ø 1.1 - 1.3 mm
3.5 Atm
N° of coats 2



Drying: 10' - 15' at 20 °C
Baking: 30' at 115 - 120 °C

NATURE OF PRODUCT:

Two-component, acid-catalyzed, oven-forced drying enamel.

FIELD OF APPLICATION:

Particularly suitable for making metallic and/or pearl tints, the 922 series is ideal for decorating metal and especially zamak and aluminum (handles, medals, gifts, etc.).

Characterized by fast drying, surface hardness and adhesion to the substrate.

PREPARATION OF THE SUBSTRATE:

The substrate should be free of any kind of surface contaminants (grease, traces of oxidation, residues of waxes or polishing pastes, residues of substances from galvanic baths, etc.), so it should be treated with appropriate cleaning methods (sanding, padding, phosphodegreasing, tumbling, etc.).

PREPARATION OF THE PRODUCT:

Comp. A: **K.922 + Coloring pastes** 100 parts by weight

Diluent: **D.945** 35 parts by weight

Compatible with electrostatic application systems.

In special cases, to eliminate effects of distension, peel, bubble formation, add in the amount of 3 to 5% retardant **10063**.

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: Two-component;	
APPEARANCE OF THE FILM	: Semigloss	
COLORS	: By choice	
SUPPLY VISCOSITY	: 33" (± 5) ASTM 4 at 20 °C	
DENSITY	: 0,93 Kg/lt ($\pm 0,05$)	
SOLID CONTENT	: 22% (± 2)	
DRYING	: - <i>Dry dust-free</i>	: 10' - 15' at 20 °C
	: - <i>Forced drying</i> ⁽¹⁾	: 30' at 115 - 120 °C
	: - <i>Maximum resistance</i>	: After 10 days
RECOMMENDED LAYERS	: Two coats	
RECOMMENDED THICKNESS	: 10 - 15 μ m	

⁽¹⁾ The product also dries at room temperature, however, to achieve the best possible chemical and adhesion strengths, we recommend baking in an oven at 115 °C for 30' minimum

To achieve an increase in hardness and chemical resistance, if the substrate permits, it is also possible to work at 130 to 140 °C after checking the adhesion.

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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