

DATA SHEET

Physical data⁽¹⁾

Foods contact: yes

Base: water based

The usage temperature allowed: under 260°C

Product code

Color	black (primer)	black silver (top)
Density	1.15-1.25	1.20-1.30
Solid, weight percent	32.0~36.0%	38.0~42.0%
Coverage degree ⁽²⁾ (m ² /KG)	13.5 (AT 10 μm)	19.6 (AT 10 μm)
Viscosity (cps) (sec) ⁽³⁾	19~24	16~20

(1) Physical data only means average data and can not be regarded as product's technical data, It varies within 5% of the average data

(2) The required DFT application efficiency is 100%

Iwata cup, 25°C

Application

Substrate	aluminum/stainless steel
Surface treatment	degreasing and sand blast (3-5 μm Ra)
Filter	80-150 meshes, stainless steel or nylon net
Application	spraying
Primer coating	DFT 15~20 μm, drying at 120~150°C (oven temperature) x10 minutes
Top coating	DFT 8-12 μm,
Curing	400-420°C x 10 minutes (body temperature)
Cleaning	Distilled water
Thinner	Distilled water (suggested dilute to 5%, if low viscosity required)

Film character

Adhesion	100% no peel off of coating with 100/100 grid
Hardness	1-2H room temperature, Mitsubishi pencil
Solvent resistance	without hurting for 100 times with MEK applying
Non sticking	no stick with fried egg for 5 times in 140-180°C

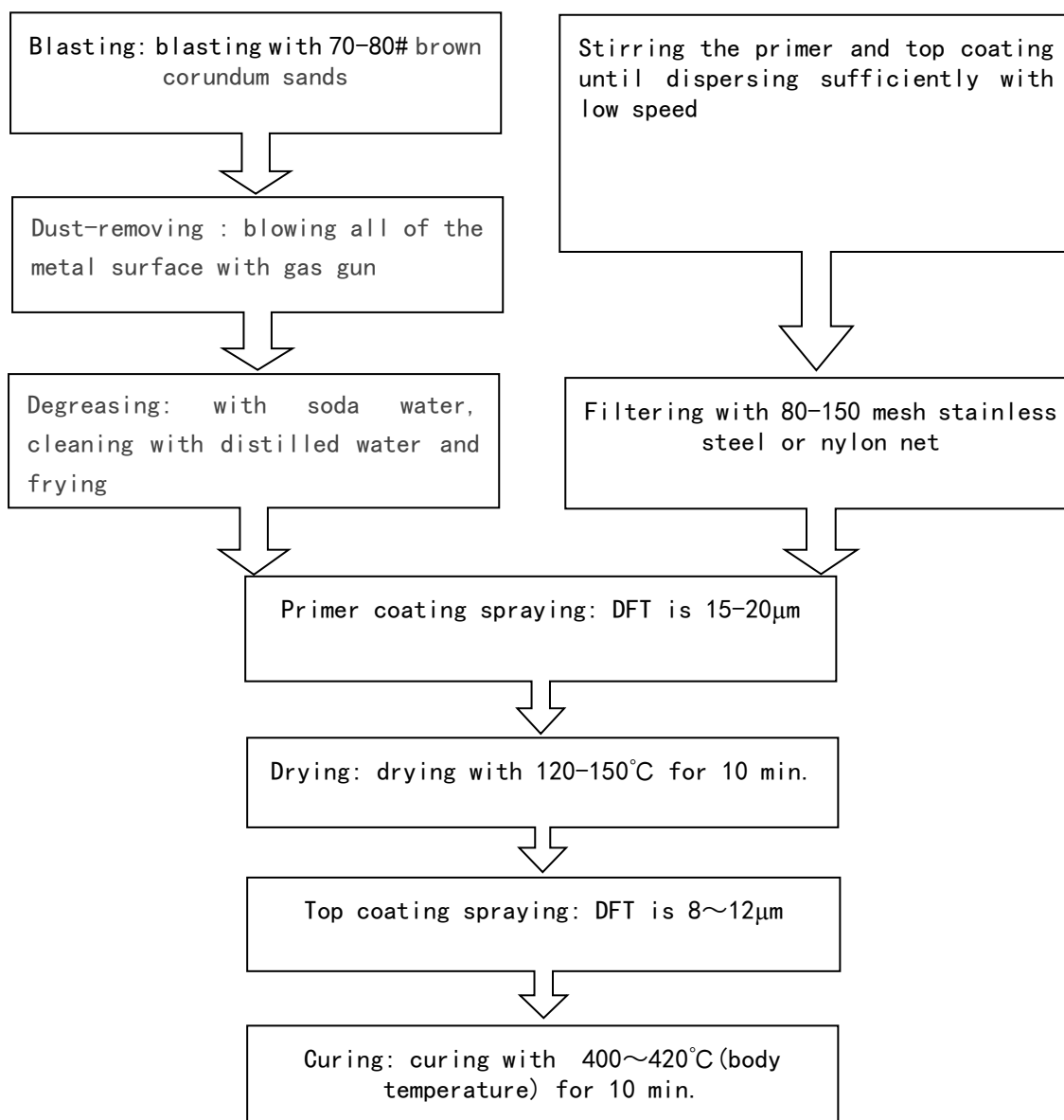
Maintenance & storage

- 1) To shake it before application (rolling with 30-60rpm for 30 minutes)
- 2) To shake or stir it per month (rolling with 30-60rpm for 15 minutes)
- 3) To avoid freezing as it is water based product

Attention

- 1) The storage temperature is suggested to be 18°C~25°C and the expire date is 6 months from the manufacturing date.
- 2) The coating must be stirred enough to well-distributed before its application.

OPERATING PROCESS



Remark

Use the low shear force dispersion to stir with low speed which is avoid strong shear force dispersion stirring with high speed.