

PRODUCT DATA

PRODUCT NAME: AK 642 / AK 645

PRODUCT DESCRIPTION: A Single pack air drying cum stoving / full Stoving Enamel

RECOMMENDED USE: Recommended to use on mild steel, wood and original equipments.

PHYSICAL DATA

COLOUR : Assorted

FINISH : Glossy/Semi glossy/Matt

SOLIDS BY VOLUME : 48±3%

THEORITICAL COVERAGE: 12 sq. mtr / ltr at recommended DFT of 40µ

FLASH POINT: Base: 23Degree C; Hardener: 23degree C; Mixed: 23degree C

DRYING CHARACTERISTICS: Surface dry: 20-30 Minutes; Hard dry: 24 Hours; Full cure: 7 Days for AK 642 (At 30 degree Celsius and 65% Relative humidity)

Baking Schedule : 120 degree C for 30 minutes for AK 645 and 110 degree C for 30 minutes for AK 642.

SHELF LIFE: One Year in sealed container.

APPLICATION DATA

APPLICATION By Brush / By Air spray / By Airless spray

THINNER: AK - 672

RECOMMENDED DFT : 40microns

OVERCOATING INTERVAL: MIN: 8 hours; MAX: 24 hours

If exceeds, the surface should be roughened by emery scuffing.

COMPATIBILITY : Can be applied over any synthetic metal primer AK-701, AK-606, AK-609 and AK-612.

RESISTANCE GUIDE

Weather ability: Normal

Flexibility: Normal

SURFACE PREPARATION

Remove grease, oil and other contaminants preferably using degreasing solvent. Blast clean to a minimum of Sa 2 1/2 Swedish Standard SIS 05 5900 with a surface profile not exceeding 65 microns. If Blasting is not possible, make full use of mechanical devices along with manual chipping and wire Brushing to remove loose rust and scale to St. 2 Swedish Standard SIS 05 5900. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces.

HEALTH & SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant National Health, Safety & Environmental standards and regulations. Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Proper ventilation and protective measures must be provided during applying and drying to keep solvent vapor concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (i.e. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment. This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes.

APPLICATION METHOD

1. Stir the paint, Add AK – 672 thinner into it , if required, depending on application method, and stir thoroughly for few minutes.
2. The temperature of the substrate should be minimum 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate.
3. Good ventilation is usually required in confined areas to ensure correct drying.
4. All equipments used for above should be properly cleaned.
5. Do not allow material to remain in hoses, gun or spray equipment.
6. Thoroughly flush all equipment with recommended thinner.

Application: By Brush/By Air Spray/By Airless Spray

For Brush application, a maximum of 5% thinner, if required, is to be added. Apply uniformly in criss-cross manner and ensure there are no misses. Use quality brushes for paint application.

Recommended Thinner : AK-672

For Air spray application: 10-15%

For Airless spray application: Max 5%

Nozzle Orifice: 1.2 -1.4 mm for air spray and Nozzle Orifice: 0.28 mm for airless spray.

Nozzle Pressure: 40-70 p.s.i for air spray and Nozzle Pressure: 1400-1800 psi for airless spray.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet contact us.

NOTES

1. Do not apply paint when temperature falls below 10°C or rises above 50°C and when Relative Humidity is above 85%, Do not apply during rain, fog, or mist.
2. Brushes and spray equipment should be cleaned with recommended thinner otherwise equipment is liable to damage.
3. DFT variation can be obtained by change in application method/thinning ratio. Contact us for further assistance.
4. Shelf life indicated is minimum for this Product and it is subjected to re-inspection thereafter.

DISCLAIMER

The information contained within this data sheet is based on information believed to be reliable at the time of its preparation. The company will not be liable for loss or damage howsoever caused including liability for negligence which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.