



SMALTOSISTEM

Data Sheet NS 337.0

Date: 08/01/01

**GLOSSY POLYACRYLIC
TOPCOAT WITH HIGH ADHESION**

5820/

URACRIL

Colours: all SMALTOSISTEM shades

A glossy polyacrylic one-coat with direct adhesion on: iron, aluminium, galvanised metal sheet, brass.

SUBSTRATES

Ferrous metal sheet – galvanised metal sheet – suitably treated aluminium.

Epoxy first coats 5203/ and 5204/.

Polyacrylic first coat 5823/

PRODUCT PREPARATION

HARDENER MIXING RATIO: for 100 parts of component A

BY WEIGHT	BY VOLUME	HARDENER
20	20	9906 / 0699
40	40	9909 / 0699

THINNING: for 100 parts of component A

– 30% with polyurethane thinner **9051/** or **9055/**.

POT LIFE:

POT LIFE	HARDENER TYPE
3 hours	9906/0699 and 9909 / 0699

APPLICATION METHOD

- Spraying: cup gun, electrostatic, airmix, air-mixed

Recommended film thickness 50 – 60 dry microns.

DRYING (ALCEA METHOD - ME 81)

AIR DRYING:

Dust free time	10 minutes
Dry to touch	4 hours
In depth	18 hours
Overcoating time	18 hours at 20°C

ACCELERATED OVEN DRYING:

– 30 minutes at 50-60°C after flash-off of 15-20 minutes in air.

TECHNICAL DATA *

	AS SUPPLIED	HARDENED	U.M.	METHOD
Specific gravity	0.986 – 1.145	0.980 – 1.114	Kg/l	ALCEA - ME14
Ford Visc. 8/20°C	10 – 15"	//	s	ALCEA - ME 16
Dry by weight	53.2 – 61.4%	56.3 – 62.9%	Kg/kg	ALCEA - ME 15
Dry in volume	43.6 – 49.6%	44.2 – 51.1%	l/kg	ALCEA - ME 15
Dry by volume	48.1 – 50.6%	50 – 52.8%	L/l	ALCEA - ME 15
Gloss on 60 degree meter	90 – 100		//	ALCEA - ME 60
Theor. spreading at 30 dry microns	14 – 17		sq.m./kg	ALCEA - ME 82

NOTES

During summer season or with temperatures higher than 25°C and relative humidity greater than 60%, it is at least necessary to double the percentage of thinner in order to avoid that the film may dry too fast in surface trapping solvent vapours and showing small bubbles having appearance of pinheads.

WARNING: Using 5820/ as a glossy clear with direct adhesion on steel, brass, aluminium, galvanised metal sheet, you have to work in the following way:
you have to harden 5820/CONV with 9906/0699 at 30% or with 9909/0699 at 60% by weight, or volume and dilute 35 – 45% with polyurethane thinner 9051 or 9055.

STOCKING

Warning: The product shall be stored in its original containers, protected from heat sources and within a + 5°C to + 35°C temperature range.

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* Since values refer to products made up using a colour mixing system, the values marked with an asterisk are indicative and refer to our product formulas only.

The information contained herein is the result of numerous experiments and provides an excellent guide. However, since application methods and processing techniques differ widely, we cannot guarantee results every time.

This updated fact sheet supersedes all previous editions

N.B.: For further information you have to consult the t.d.s. FERRO NF 290