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## PRODUCT DATA SHEET

**PRODUCT:** **SMALTO A FORNO MC TEFLONATO**  
**Heat-curing enamel**

**CODE:** **COMP. A 652 SMALTO A FORNO MC TEFLONATO**  
**COMP. B -**

**PRODUCT DESCRIPTION:** Thermosetting gloss finish, based on alkyd-melamine resins, characterized by excellent mechanical strength, excellent adhesion to metal, high weather resistance even in the absence of anticorrosive primers. Particularly suitable in industrial painting cycles with short processing times. Specifically for the coating of household appliances, metal furniture, machine tools, cycles and motorcycles. Usable with electrostatic painting plants.

**SURFACE PREPARATION:** The product must be applied strictly on dry surfaces, clean, perfectly free of oil, grease, dust, moisture or other contaminants.

**APPLICATION METHODS:** Spray, brush or roll. Avoid placing thicknesses higher than recommended.

| <b>APPLICATION INSTRUCTIONS:</b> | <b>CONVENTIONAL SPRAY<br/>LOW PRESSURE PUMP</b> |                        | <b>AIRLESS<br/>AIRMIX</b> |             |
|----------------------------------|---|------------------------|---------------------------|-------------|
|                                  | Nozzle diameter (mm)                            | <b>1,8÷2,0</b>         | Pressure ratio            | <b>28:1</b> |
| Product pressure (Atm)           | <b>1,0÷1,7</b>                                  | Nozzle diameter (inch) | <b>0,015÷0,019</b>        |             |
| Air pressure                     | <b>3,5÷5,0</b>                                  | Product pressure (Atm) | <b>130,0÷170,0</b>        |             |



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## TECHNICAL DATA:

|  |  |
|--|--|
| Mechanism of hardening   | <b>Chemical reaction and heat curing</b> |
| Specific weight (kg / l) *   | <b>1,17 (±8%)</b>                        |
| Volume solids (%) *  | <b>55,1 (±1%)</b>                        |
| Medium dry film thickness (microns)  | <b>30</b>                                |
| Correspondence wet film thickness (microns)                                  | <b>55</b>                                |
| Yield to the average or recommended thickness (m <sup>2</sup> / kg) *        | <b>15,8</b>                              |
| Consumption at the average or recommended thickness (Kg / m <sup>2</sup> ) * | <b>0,064</b>                             |
| Passivation time at 25 ° C (min)   | <b>15-20</b>                             |
| Hard dry at 170 ° C (minutes)  | <b>20</b>                                |
| Thinner  | <b>6060020</b>                           |
| Aspect of the film   | <b>glossy</b>                            |
| Color  | <b>On request</b>                        |
| Storage in suitable conditions (months)                                      | <b>12</b>                                |

N.B.

\* Data referred to colour grey. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are only indicative, in fact vary greatly depending condition of substrate, dilution, absorption, porosity, surface irregularities and application method.



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#### ADDITIONAL INFORMATION:

This is a one-component product. Vigorously mix the product for a few minutes with appropriate instruments and characterized by sufficient size, in order to ensure the complete homogeneity. Where possible it is preferable to use a mechanical stirrer. Before cooking in the oven at 170° C for 20 minutes, wait 15-20 minute (passivation) in order to avoid the formation of bubbles. It is recommended to implement all necessary measures (development of equipment for painting, using any thinner retardant-wetting thinner, position yourself upwind, proper progression of the surfaces to be painted) to prevent the accumulation of dust coating, which if not removed causes inhomogeneity of the film.

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#### IMPORTANT NOTE

All information contained in this form are the result of laboratory tests carried out under controlled conditions and well-defined and / or correspond to our most advanced and current technical and practical knowledge. this does not exempt the customer, given the variability of environmental conditions and personal systems of application, from carrying out their own investigations and to make their own eligibility checks. Mondial Color assumes no responsibility for any damage caused by improper use of the product. This sheet supersedes the previous editions.

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