



TECHNICAL DATA SHEET

STOVING ENAMEL

PRODUCT DESCRIPTION

This product is an alkyd melamine based stoving enamel suitable for the protection and beautification of primed and unprimed steel. Once baked it produces a paint film, which has excellent adhesion, mar and chemical resistance.

PRODUCT AND ADDITIVES

- Concept Stoving Enamel
- Concept Enamel Thinner


SUITABLE SUBSTRATES

- Mild Steel
- Aluminium surfaces primed with Concept 1K Etch Primer.

MIXING RATIO




- Up to 30% by volume with Concept Enamel Thinner.

SPRAY GUN AND PRESSURE

SPRAY GUN & PRESSURE:	<ul style="list-style-type: none">• 1.5 – 2.00 mm through a suction feed.• Pressure at 350 – 450 kPa (Gravity feed is slightly higher pressure).	
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APPLICATION

- All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept Light Rust & Metal Conditioner.
- Apply one to two even coats to obtain a Dry Film Thickness of 40 – 50 Microns. Flash off before baking.

SPRAYING VISCOSITY:	<ul style="list-style-type: none"> • 19 – 21 seconds B4 cup at 25°C. 	 19-21 SECONDS
FLASH-OFF TIME:	<ul style="list-style-type: none"> • 5 – 10 minutes between coats at 25°C. • 10 – 15 minutes before baking at 25°C. 	
BAKING:	<ul style="list-style-type: none"> • 30 minutes at 120°C or • 15 minutes at 140°C 	

TECHNICAL INFORMATION

COLOUR:	White, Black, Silver and Mixed Colours
COVERAGE:	7 m ² /L @ 50 Micron Dry Film Thickness.
GLOSS:	Full, Low Sheen and Matt
VOC:	Black: 423 g/L, Silver: 566 g/L
PACKAGING:	20LT, (Mixed Colours >100LT)
ITEM CODE:	A06C/SE
SHELF LIFE:	12 months

The above information is reliable and accurate to the best of our knowledge at the time of preparation. Any recommendations or suggestions made are without warranty or guarantee. Users assume all responsibility since the conditions of use are beyond our control.

REVISED: 11 September 2013

REPLACES ISSUE: 28 November 2012