

## DATA SHEET

Physical data<sup>(1)</sup>

			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 $(m^2/KG)$	13.5 (AT 10μm)	19.6 (AT 10μm)			
Viscosity (cps)	19~24	16~20			
(sec) <sup>(3)</sup>					

(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%

lwata cup, 25°C

## Application

Substrate	aluminum/stainless steel			
Surface treatment	degreasing and sand blast (3-5 $\mu$ m Ra)			
Filter	80-150 meshes, stainless steel or nylon net			
Application	spraying			
Primer coating	DFT 15 $\sim$ 20 $\mu$ m, drying at 120~150 °C (oven temperature) x10 minutes			
Top coating	DFT 8-12μm,			
Curing	400-420°C x 10 minutes(body temperature)			
Cleaning	Dstilled water			
Thinner	Distilled water(suggested dilute to 5%, if low viscosity required)			
<u>Film character</u>				
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 $^\circ\!\mathrm{C}$			
<u>Maintenance &amp; storage</u>				

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  $18^{\circ}C\sim 25^{\circ}C$  and the expire date is 6 months from the manufacturing date.
- 2) The coating must be stirred enough to well-distributed before its application.



# Blasting: blasting with 70-80# brown Stirring the primer and top coating corundum sands until dispersing sufficiently with low speed Dust-removing : blowing all of the metal surface with gas gun Degreasing: with soda water, Filtering with 80-150 mesh stainless cleaning with distilled water and steel or nylon net frying Primer coating spraying: DFT is 15-20µm Drying: drying with 120-150°C for 10 min. Top coating spraying: DFT is $8{\sim}12\mu\text{m}$ Curing: curing with $400 \sim 420^{\circ}$ C (body temperature) for 10 min.

## 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.