



PRODUCT DATA SHEET

KOSACRYLIC FINISH AUF-Series

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Acrylic-Melamine Baking Finish

PRODUCT DESCRIPTION

An excellent exterior finishing low bake paint formulated to give excellent durability, impact resistance, gloss and colour retention. Based on modified Acrylic-melamine resin incorporating high performance pigments to provides outstanding anticorrosive and decorative properties when applied to properly cleaned steel surfaces. It also provides excellent adhesion on steel, galvanized and aluminium substrates. This product is especially recommended for used on OEM metal parts, compressors, filters, and etc.

PHYSICAL PROPERTIES

Colour	: Wide colour range.
Texture	: Glossy
Specific Gravity	: 1.00 ~1.20 gm/cm ³
Supply Viscosity	: 85 ± 5 Second (Din Cup No.4 at 25°C.
Solids Weight	: 50 ± 5%
Gloss	: 20 ~ 85° on 60° gloss meter.
Pencil Hardness	: H ~ 2H
Flash Point	: >23°C

SURFACE PREPARATION

Surface to be painted should be free from oil, grease, wax, rust and other contaminants. To achieved maximum coating performance type and quality of pre-treatment is essential. Typical pretreatment processes for the most frequently used substrates are :

Steel	: Zinc Phosphating.
Aluminium	: Chromate conversion treatment.
Zinc coated steel	: Zinc Phosphating or chromate conversion.
Final rinse (deionized)	: The last running water from the object should be tested at 20°C



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The readings obtained should measure below 30 micron siemens/cm.

MIXING / APPLICATION DATA

- Guiding data Airless Spray : Pressure at nozzle : 120-150 bar. Nozzle size : 0.38-0.53mm.
Spray angle 40-80 degrees.
Volume of thinner required : approx. 4 parts of paint to 1 part of thinner.
- Application by Air Spray (Conventional Spray) : Pressure at nozzle : 3-4 bar. Nozzle size : 1.2-2.0mm
Volume of thinner required : approx. 4 parts of paint to 1 part of thinner.
- Application by Brush / Roller : Not recommended only for touch-up purposes.
- Thinner / Cleaner : Kossan Special thinner 6.01
- Spray Viscosity : 25 ± 2 seconds.
- Recommended wft : 78 μm
- Recommended wft : 35 μm
- No. of coat required : 1 coat

CURING SCHEDULE

- Baking Temperature : 150°C (PMT) = 20 minutes
180°C (PMT) = 15 minutes

CONDITIONS

- Humidity : below 90% R.H.
- Temperature of the paint before application : min.10°C, max. 40°C.
- Substrate temperature min. 5°C, max. 45°C. The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperature and relative humidity should be measured in the vicinity of the substrate.



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THEORITICAL COVERAGE & PACKING SIZE

Coverage	: 12.86 m ² /litre
Packing Size	: 5 Litre & 20 Litre

STORAGE

KOSACRYLIC FINISH AUF-Series have a minimum self-life of 9 months at cool and dry place. Containers must be kept tightly closed.

HEALTY & SAFETY

Avoid skin and eyes contact by wearing suitable overalls, gloves, goggles, etc. Spillage on the skin should immediately be removed by thorough washing with water and soap. Eyes should be well flushed with water and medical attention sought immediately.

DISCLAIMER

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factor affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product data without notice.