

PRODUCT DESCRIPTION

Subalic Stoving is a single component, a carboxyl-hydroxyl-functional acrylic resin designed to cross-link with melamine resins in baking systems.

INTENDED USE

Suitable for more types of substrates, easy application, providing excellent adhesion, including office equipments, appliance, light fittings, metal shelvings, furniture parts and gas cylinder.

GENERAL PROPERTIES

Colour	: Colours as per colour cards
Gloss Level	: Gloss, Semi gloss, Matt
Volume Solids, %	: 35 ± 2 %
Specific Gravity	: 1.05 ± 0.15 kg/l
Flash point	: 27°C
VOC	: 550 g/l (by calculation)

SURFACE PREPARATION

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, patch primer prior to the application of Subalic Stoving Top Coat.

Subalic Stoving Top Coat should always be applied over a recommended anti-corrosive coating scheme for metal surface. The primer surface should be dry and free from oil and other contaminations. It must be applied within the overcoating intervals specified (refer to application section for details).

Other Surfaces

The coating may be used on other substrates. Please contact your local Tsubasa Paint office for more information.

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C or above 45°C and relative humidity is over 85%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air.

APPLICATION GUIDED

Mixing Ratio : Dilute with thinner from 55-65% by weight.
Should be mixed thoroughly before use

Theoretical Coverage : 11.67 m²/liter at 30 µm DFT

Thinner : Subalic Stoving Thinner.

APPLICATION METHOD

Brush and roll is suitable for stripe coating and very small areas. For best result, use air spray. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Air Spray : Tip Size : 0.8 - 1.5 mm
Pressure at nozzle : 0.24 - 0.29 Mpa

Typical Thickness : 25 - 35 µm, dry film
71 - 100 µm, wet film

Curing condition : Substrate Temperature : 25°C 35°C
Flash - off : 10-15 mins
Baking condition : 150°C/20 mins

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

RECOMMENDED PAINTING SYSTEM

The following Primer are recommended for Subalic Stoving Topcoat:

Primer

- Subaxy Shop Primer

For the choice of coating system for different application, refer to the product brochure or contact Tsubasa Paint for professional recommendation.

PACKAGING

Unit	Volume	Container Size
4.5L	4.5L	5L
18L	18L	20L

STORAGE

Shelf life : 6 months (25°C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin.

Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.

HEALTH AND SAFETY

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, refer to the Material Safety Data Sheet

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements. If there is any inconsistency in the text the English (UK) version will prevail.