

Chemcolor corrosion protection system

# Alkidkolor aqua 120°C

**Water-thinnable, oven-drying topcoat**

## Intended use

ALKIDKOLOR AQUA 120°C is a water-thinnable, one-component, oven-drying topcoat based on an epoxy-modified alkyd melamine binder. It is used as a single-coat finish or topcoat for industrial coating of metal components, metal furniture, gas cylinders, compressors and similar products where both aesthetic and good mechanical properties are required.

## Properties Areas of application

- water-thinnable
- good adhesion to metal substrates
- good mechanical properties
- single-coat finish or topcoat for industrial coating of metal components

## Technical data\*

|                            |            |                                                  |
|----------------------------|------------|--------------------------------------------------|
| Packaging                  |            | 5, 10, 25 kg                                     |
| Application temperature    |            | 3°C above the dew point                          |
| Application humidity       |            | minimum 30 and maximum 75% relative air humidity |
| Thinning                   |            | water                                            |
| Accelerated drying         | Flash-off  | 10 minutes                                       |
|                            | Conditions | approx. 120°C – 150°C : 10 – 30 minutes          |
| Recommended film thickness | Wet        | approx. 75 microns                               |
|                            | Dry        | 30 microns                                       |
| Theoretical coverage       | 30 µm dft  | 14.0 m <sup>2</sup> /L 15.4 m <sup>2</sup> /kg   |
| Shades                     |            | to RAL colour chart                              |
| Gloss                      |            | Gloss                                            |
| Solids content             | By weight  | 55 ± 2%                                          |
|                            | By volume  | 40 ± 2%                                          |
| Density                    |            | 1,10 - 1,30 g/ml                                 |
| Viscosity                  |            | 60 - 100 s F4 (20°C)                             |
| Adhesion                   |            | ISO: 0 / ASTM: 5B                                |

(\*All technical data stated in this technical data sheet are based on laboratory tests. Actual data may vary depending on application conditions beyond our control. dft-dry film thickness)

## Surface preparation

### Good practice

The surface must be dry, clean and free of dirt, grease, rust, slag residues, salts, or other contaminants that could prevent good adhesion. Welds, repaired areas, joints and surface damage identified during surface preparation must be properly cleaned and treated before painting.

Surfaces that have oxidized after preparation and before painting must be treated in accordance with the appropriate standard. Consult the specified standards. For further advice, contact Chemcolor technical service.

### Metals

Before preparing the surface for coating, solvent-clean it to remove contaminants such as oil, grease, salts, dirt and markings. Use hand cleaning to ISO 8501-1 St 2 or power-tool cleaning to St 3 to remove corrosion and prepare the surface to the standard. Highly exposed surfaces or surfaces intended for immersion must be prepared using the ISO 8504-2 method or blast-cleaned to ISO 8501-1 Sa 2.5. After cleaning, the surface must be clean with a roughness of 25-50 microns. Phosphating is recommended for preparing pickled sheet metal.

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## Application conditions

The substrate temperature must be at least 3°C above the dew point during application.

Temperature: 8° - 30°C

This temperature applies to the air, surface and material. The surface must be visibly dry.

Relative humidity: 30% - 75%

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## Material preparation and application

Alkidkolor aqua 120°C can be applied by airless or conventional air spray and dipping. Stir thoroughly before application.

### Airless

Pressure: 12.0 – 15.0 Mpa

Nozzle: 1.3 – 1.5 mm

Thinning: up to 10% by volume

Dipping

Thinning: up to 25% by volume

### Air spray

Air pressure: 0.30 – 0.50 Mpa

Air cap: 1.3 – 1.5 mm

Thinning: up to 15% by volume

The percentage of water added depends on the temperature of the coating. The given data refers to a coating temperature of 20°C.

### Cleaning

Water.

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## Cleaning tools and surfaces

Tools and work equipment are cleaned immediately after finishing with water and appropriate cleaners.

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## Storage

The shelf life of the product in well-sealed, undamaged original packaging, stored in a dry place at a temperature between +5°C and +35°C, is 12 months from the date of manufacture.

WARNING! Do not allow the paint to freeze!



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## Notes

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Chemcolor's liability for any claim, including negligence or strict liability for loss or damage arising from work performed, related to or resulting from the use of the products, shall in no case exceed the purchase price of the products or the portion of the products giving rise to the claim. Chemcolor shall in no case be liable for consequential or incidental damage.

### Protective measures:

- Forced ventilation must be provided when applying the product in enclosed, unventilated spaces. The material must not be applied near open flames or welding operations.
- Wear protective equipment during work, including gloves, safety glasses and other necessary protection.
- Before eating and after work, change contaminated clothing and wash your hands.
- Observe the safety warnings on the packaging label.

### Important warnings:

- Dispose of uncured or unbound material in accordance with applicable regulations. Fully cured material may be disposed of at municipal landfills in accordance with applicable regulations.
- Detailed safety precautions and physical, toxicological and ecological information for the product are provided in the safety data sheet, available from the Chemcolor sales department or at [www.chemcolor.si](http://www.chemcolor.si).

This information is based on our experience to date and careful research. Site conditions and knowledge of the work influence the quality of application. Successful work depends on professional assessment of the substrate at handover and practical experience in selecting the appropriate product. Please also follow the manufacturer's recommendations and the safety data sheet for this product.