



## TECHNICAL DATA SHEET

### **AMBER STOVING ENAMEL**

<b>PRODUCT DESCRIPTION</b>	A high quality alkyd melamine formaldehyde resin based industrial stoving enamel topcoat with uniform spreading, excellent opacity and covering capacity. It gives a tough and flexible film with superior gloss, good adhesion and weather resistance. It has very good hardness and abrasion resistances with anticorrosive property and impact resistance.
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<b>RECOMMENDED USES</b>	For application on metal surfaces, an equipments, domestic appliances, automotive and industrial equipments, machineries, metal furniture's frame etc. It is suitable for internal/external applications.
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### **TECHNICAL DATA**

<b>COLOUR, DRY FILM</b>	As per Amber shade card
<b>FINISH, DRY FILM</b>	Smooth/Glossy/Semi glossy/Matt
<b>VOLUME SOLIDS (ASTM D2697)</b>	51 ± 2%
<b>SPECIFIC GRAVITY</b>	1.27 ± 0.05
<b>THEORETICAL SPREADING</b>	17 – 12.7 M <sup>2</sup> /LTR
<b>RECOMMENDED DFT (DRY FILM)</b>	30 – 40 Microns/Coat
<b>RECOMMENDED WFT (WET FILM)</b>	59 – 78 Microns/Coat
<b>FLASH POINT</b>	32°C
<b>FLEXIBILITY</b>	Good

### **DRYING TIME**

Drying time @ 30°C (Temperature, humidity, air movement, film thickness and number of coats all affect the drying time).	
<b>STOVING SCHEDULE</b>	120°C for 30 minutes (OR)
	150°C for 10 minutes
<b>FLASH OFF TIME</b>	10 – 15 minutes



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### ADVANTAGES

<b>AMBER STOVING ENAMEL</b>	Uniform spreading, excellent opacity and covering capacity. Gives a tough and flexible film with superior gloss, good adhesion and weather resistance, very good hardness and abrasion resistances, anticorrosive properties.
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### APPLICATION INSTRUCTION

<b>SURFACE PREPARATION</b>	It can be applied directly over intermediate coat or primed substrate. Galvanized steel, aluminium and other light metal alloys should be etched or wash-primed before primer and undercoat application.
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### APPLICATION DATA

<b>APPLICATION METHOD</b>	Conventional spray
<b>CLEANING/THINNING</b>	Amber Stoving Thinner
<b>THINNER (VOLUME)</b>	5 – 10%
<b>CONV. SPRAY REQUIREMENTS</b>	Atomizing Pressure : 50 psi
<b>AIRLESS SPRAY REQUIREMENTS</b>	Not applicable
<b>NOZZLE SIZE</b>	Not applicable
<b>MIXING RATIO (BY VOLUME)</b>	Not applicable
<b>POT LIFE @ 30°c (100 ml)</b>	Not applicable

### SYSTEM

<b>RECOMMENDED SYSTEM</b>	No. of Coats x DFT (Microns)	
	Amber Stoving Primer	1 x 50
	Amber Stoving Enamel	1 x 40
To be applied on prepared surface.		



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### ADDITIONAL DATA

<b>SHELF LIFE @ 30°C</b>	6 months, in original sealed container, with proper storage conditions.
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### HEALTH & SAFETY

<b>SAFETY PRECAUTIONS</b>	As a general rule, avoid skin and eye contact by wearing overalls, gloves, goggles, and airmask etc. Spillage on skin should immediately be removed by thorough washing with water and soap or suitable cleaner. Eye should be flushed with fresh water. Avoid inhalation of vapours and paint mist by wearing suitable airmask. In the event of ingestion and eye contact, seek medical attention immediately. Painting must be carried out in well-ventilated area. This as industrial product, contains flammable materials and should be kept away from the sparks and open flames, smoking in the area should not be permitted. Local safety regulations should be followed.
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### STORAGE & HANDLING

<b>STORAGE</b>	Store the paint in proper storage conditions as per the local regulations. Keep the paint container in sealed condition under shed, away from direct sunlight and extreme temperatures. Do not stock paint material near to any ignition sources. Do not put back the half or unused material back in original container, containing the supplied paint, to avoid contamination. Handle with care. Stir well before use.
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