



**NATIONAL STOVING ENAMEL
PROTECTIVE COATINGS**

TECHNICAL DATA SHEET

NATIONAL STOVING ENAMEL

PRODUCT DESCRIPTION	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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RECOMMENDED USES	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

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

DRYING TIME

Stoving schedule may affect the drying time as well as the dry film properties.	
STOVING SCHEDULE	120°C for 30 minutes (OR)
	150°C for 10 minutes
FLASH OFF TIME	10 – 15 minutes

ADVANTAGES

NATIONAL STOVING ENAMEL	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

SURFACE PREPARATION	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

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

SYSTEM

RECOMMENDED SYSTEM To be applied on prepared surface.	No. of Coats x DFT (Microns)	
	National Stoving Primer	: 1 x 50
	National Stoving Enamel	: 1 x 40

ADDITIONAL DATA

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

SAFETY PRECAUTIONS	<p>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.</p> <p>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.</p>
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STORAGE & HANDLING

STORAGE	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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NOTE: We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests. We reserve the right to change data without prior notice. For surface preparation, safety details refer specifier and safety data.

This data sheet supersedes all previous issued.
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