

## Technical Data Sheet

### SYNTHAL DIVERSIT EFFECT PAINT

Series 5415

Synthal Diversit Effect Paint of series 5415 based on high-quality acrylic and PVC polymer resin especially designed as single-coat paint for iron, steel and zinc coated steel. This paint is characterized by good adhesion and quick drying process. It is suitable for inside and outside.

#### **Areas of application:**

Wrought iron products, fences, railing, balustrades, stairs

Binding agent	Acrylate and PVC polymer
Substrate / Underground	Iron, steel, stainless steel, and non-iron like copper, aluminium, zinc coated surfaces
Colour shades	Metallics, day-light colours
Density, DIN EN ISO 2811	1.05 – 1.40 g/cm <sup>3</sup>
Solid content, DIN EN ISO 3251	approx. 65% by weight (depending on colour )
Viscosity (+20 °C), DIN EN ISO 2431	Thix not applicable
Sheen level/surface	Mat to silk gloss (depending on colour )
Storage stability	12 months in closed containers Do not store below +5 °C or above +30 °C
Application	Spraying (airless, electrostatic, pneumatic) and Aerosol spray
Film thickness and spreading rate	approx. 5,0 – 6,2 m <sup>2</sup> /kg at 50 µm dry film thickness (125 µm wet film thickness)
Application temperature	Do not apply below +8 °C, observe dew point
Drying times (at +20 °C, 65% rel. air humidity)	<b>Air drying:</b> dust dry: after approx. 10 min. touch dry: after approx. 30 min. fully dry: after approx. 24 hours
Thinner	The paint is ready to use for spraying. The spraying viscosity can be adjusted by adding max. 10% of PVC Thinner 9341-00000-0

## Surface preparation:

Surfaces must be free of dust, rust, scale, oil, grease and old paint residues. It is recommended to clean surfaces with Cellax Thinner 9300-00000-0 (flash point <23 °C) or Synthal Degreasing Agent 9155-00000-0 (flash point >23 °C).

Freshly zinc-coated steel can be overcoated immediately. Should saponification or white rust occur on the surface, it is necessary to remove these layers thoroughly.

To this use an ammoniac soap solution. 10 liter water will mixed with 0,5 liter ammonia water (25 %ig ammonium in water. Can be obtained in pharmacy.) and some drops of washing-up liquid.

Be aware of the safty and health regulations by usage of ammonia water! Use safty goggles and safty gloves!

Dip a scouring pad in this ammoniac soap solution and clean the zinc plated surface until a grey foam will be generated.

Let the grey foam react on the surface for 15 minutes. Following rinse with clear water. It can be coated after completly drying of the surface.

Be aware that water drops on corners or cavities maybe remain and will disturb the following overcoating and reduce the coating qualities (like adhesion, resistances, color, gloss and so on.) Therefore a dry zinc coated surface is absolute necessary to achieve best coating results.

Aluminium has to be sanded and cleaned again, before it will be coated.

## Application:

Attention: Observe dew point!

"Cold" parts must be preheated in the building prior to the application (condensation water). Stress resistant not before 72 hours after the application in case of high air humidity.

The correct dry film thickness is 50 – 80 µm (125 – 200 µm wet film thickness) in order to ensure adequate protection, adhesion and surface. Achieving the correct film thickness it may be necessary to apply several coats depending on the application viscosity.

## Important note:

You must wait for 72 hours before exposing the film to stress in case of unfavourable application conditions, e.g. rain, high air humidity, low temperatures (+ 8 °C).

### Note:

The data given above is of recommending nature only. Every care is taken to ensure that the technical information provided is correct and up to date according to the present state of technical knowledge. None of the data given is legally binding. Furthermore, our terms of business are applicable. Safety data sheets according to Annex II of EU Directive 1907/2006 are available on request.