GAS01 ACRYMIX 2K ONE COAT

GENERAL CHARACTERISTICS AND USE

Binder for preparing acrylic two-pack coatings that directly adhere to metal and plastic backing materials. Optimum bond on steel, stainless steel, galvanized steel, aluminium and its alloys, bronze, brass, zamak alloy, ABS (acrylonitrile/butadiene/styrene), PA (polyamide), PU (polyurethane), PVC (polyvinylchloride), PF (phenolic), UF (ureic), UP (unsaturated polyesters), PRVF (fiberglass reinforced plastic), glass and ceramic. Good chemical resistance. Optimum ability to withstand UV rays and weather conditions, optimum surface hardness and visual aspect. Easy application. Quick drying. Suitable for single coat application in industrial coating cycles on metal and plastic.
Note: users are strongly advised to conduct preliminary coating tests as the composition of each individual constituent may vary.

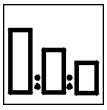
SURFACE PREPARATION




Metals: steel, stainless steel, galvanized steel, aluminium and its alloys, brass and zamak alloy – it is normally sufficient to degrease using a suitable antisilicone solvent followed by surfacing with Scotch Brite. In the case of continuous processes where it is impossible to sand the surfaces or if the products are polluted on the surface by rolling lubricants (oils, stearates, soaps), the items must be washed using an industrial multiple stages cleaning process.

Plastic materials: PF, UF, PUR and PRVF are normally degreased with antisilicone solvent and then surfaced with Scotch Brite. ABS and PA should be degreased with a suitable detergent. Similarly to metals, the workpieces should be washed by means of multiple stage methods in the case of continuous processes or if there are release agents or lubricants on the surfaces.

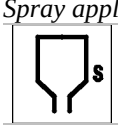
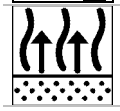
PRODUCT PREPARATION



	weight	volume	weight	volume	Pot life a 20°C
GAS01 Acrymix+ pigmented bases	1000	1000	1.000	1.000	4 h (with CP003 and CP012)
Hardeners: CP003/CP004/CP006	300	300			
Hardeners: CP012/CP013/CP014	-		500	500	
Thinners: DP001/DP002/DP003/DUN01	200-400	150-350	50-200	50-150	

COATING APPLICATION

Spray application

	Application viscosity at 20°C TF 4	20-25 s
	Nozzle diameter	1.3-1.4 mm normal; 1.2-1.4 mm HVLP
	Air pressure	4 bar normal; 2-2.5 bar HVLP
	Flash-off at 20°C	15-30 min

Recommended final thickness (2 coats)	50-60 µm
Theoretic yield at 30 µm	15 m^2/l - 14 m^2/kg
Non-volatile content	60,3%

DRYING (with CP004 e CP012)

In air at 20°C



Touch dry	8-10 h
Through dry	2-3 days

Stove dried at 60°C



Stove drying at 60°C	40-60 min

The technical information and suggestions given are the result of our experience and tests. We ensure that our products provide fade-free quality. However, we assume no responsibility for the results obtained as the conditions in which the product is used are beyond our control. You are therefore advised to conduct tests in the real coating and use conditions prior to actual production.


Consult the safety brief: GAS01