# GAS02 ACRYMIX 2K ONE COAT MATT



## GENERAL CHARACTERISTICS AND USE

Binder for preparing acrylic two-pack mat coating products that directly adhere to metal and plastic 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 resistance to UV rays and bad weather conditions. Optimum surface hardness and as regards application. Quick drying. Optimum visual aspect and evenly mat. Optimum as regards application.
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 Zn+Al-Mg 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 in a several stages plant with suitable cleansers.

**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 systems in the case of continuous processes or if there are separator products on the surfaces.

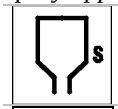
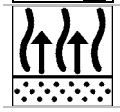
## PRODUCT PREPARATION



| | **weight** | **volume** | **weight** | **volume** | **Pot life a 20°C** |
|---|---|---|---|---|---|
| GAS02 Acrymix Matt + pigmented bases | 1000 | 1000 | 1.000 | 1.000 | 4 h (with CP003 |
| Hardener: CP003/CP004/CP006 | 250 | 300 | | | and CP012) |
| Hardener: CP012/CP013/CP014 | - | | 400 | 500 | |
| Thinner: DP001/DP002/DP003/DUN01 | 350-500 | 350-500 | 200-350 | 200-300 | |

## COATING APPLICATION

*Spray application*

| | | |
|---|---|---|
|  | Application viscosity at 20°C TF 4 | 20-23 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 | 16 $m^2/l$ – 14 $m^2/kg$ |
| 60° opacity | 20 ± 5 gloss |
| Non-volatile content | 67,8% |

The gloss can be increased by using GAS01 instead of GAS02. Substitution of 10% increases the gloss by about 20 gloss, thus bringing the value to about 40 gloss.

Thicker layers than those recommended below give finishes that are more glossy and vice versa.
Stove drying produces finishes that are more glossy by about 15 gloss, reaching approximately 35 gloss.
In relation to the equivalent glossy product, the shades of any mat product tend to appear more whitish: this is perfectly normal.

**DRYING (with CP004 e CP012)**

In air at 20°C



| | |
|---|---|
| Touch dry | 6-8 h |
| Through dry | 1-2 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: GAS02