

PROTEGAPAQ PE90-W

DESCRIPTION Compliant high quality water borne stoving polyester enamel.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Suitable for high quality coating of drums and general industrial finishing.
- ◆ Excellent adhesion to clean steel.
- ◆ Compliant to below 290gm/lt (less water) as a stoving enamel.

TECHNICAL DATA

Volume solids 25 - 40% (ISO 3233) depending on colour.

Weight solids 30 - 60% depending on colour.

Viscosity 60 – 70 seconds DIN 4 Cup 25 deg C.

Specific gravity 1.0 – 1.4 depending on colour.

pH 7.5 – 8.0

Product code 3883 and 3895 series.

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
10 µm	29 µm	34.5 m ² /l
30 µm	86 µm	11.5 m ² /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying time

DFT 25 µm	+ 23 °C
Flash off	5 – 15 min
Cure	6 min @ 205 - 210°C 10 min @ 160°C

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish Gloss

Colours White, Black and other colours to customers specification.

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APPLICATION DETAILS

Surface preparation	<p>Preliminary cleaning: remove oil grease with a suitable detergent. Remove salt and other contaminants by fresh water cleaning and allow to dry (ISO 12944-4). Pre-treatment improves adhesion and reduces corrosion under the paint film. The type of pre-treatment depends on the requirements for corrosion protection e.g.</p> <ol style="list-style-type: none">1. Zinc phosphate with Cr-VI passivation.2. Iron phosphate with demineralised water rinsing (insufficient rinsing can lead to the osmotic formation of bubbles).3. Alkaline or neutral degreasing.4. Clean steel.
Application conditions	<p>Only apply in conditions of good ventilation, which must be maintained during curing. Do not apply when rain, mist, sleet, or snow are imminent. During application and drying time of the paint coating, the surface must be dry and the ambient temperature should be a minimum of 10°C with the relative humidity below 85% during application and curing. The surface temperature of steel should remain at least 3°C above the dew point.</p>
Mixing	<p>Must be mixed thoroughly before use. Use a mechanical agitator for mixing.</p>
Application	<p>Spray application viscosity 25-30 seconds DIN 4 cup depending on spray equipment. Suitable for spraying by conventional air spray, electrostatic spray, high speed disc or bells and hot airless spray.</p>
Thinner	<p>De-mineralised or potable water.</p>
Cleaning of equipment	<p>Remove remaining paint from equipment, flush thoroughly with water. Repeat if necessary and rinse with cleaner for water based paints reference cleaner solution ProtegaClean 1921 or if paint is dried and very stubborn to remove, use Thinner 1723.</p>
FLASH POINT	<p>Above 55°C</p>
STORAGE	<p>Store in dry, cool conditions and protect from frost.</p>
VOC	<p>Varies considerably with colour, please consult Protega Coatings.</p>
HEALTH AND SAFETY	<p>Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.</p>