

PROTEGATHERM HS

DESCRIPTION

High solids, one coat, compliant stoving finish.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ High quality external stoving finish for general industry.
- ◆ Excellent one coat coverage in a wide range of colours.
- ◆ Excellent application properties on high speed disc, bell plants and airless equipment.
- ◆ Meets the specification requirements of all the major manufacturers in the office furniture, storage and related industries.
- ◆ EPA compliant as a stoving enamel (below 350 gm/lt).

TECHNICAL DATA

Volume solids

66 ± 5% (ISO 3233) depending on colour.

Weight solids

77 ± 5% depending on colour.

Viscosity

60 - 105 seconds BSB 4 @ 25°C depending on colour.

Specific gravity

1.1 – 1.5 depending on colour.

Product code

Existing shades - 3594 and 3743 series
New shades – 3551 (HS20), 3552 (HS50), 3553 (HS90) series.

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
15 µm	24 µm	43.3 m ² /l
25 µm	40 µm	26.0 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 20 µm	+ 23 °C
Flash off	10 – 15 mins
Force dry	10 minutes @ 150°C metal temperature

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

Finish

Low gloss (HS20), semi-gloss (HS50) and high gloss (HS90).

Colours

Black, White, Grey and full range of colours to customer specifications.

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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.5. Zintec and other non ferrous metals when suitably treated or primed.
Application conditions	<p>Only apply in conditions of good ventilation which should be maintained during drying. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature 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>Electrostatic high speed bells or disc equipment at viscosity supplied. Airless or air assisted airless and all other electrostatic equipment. Suitable for spraying by HVLP or conventional air spray when thinned to 30 – 45 seconds BSB4 @ 25°C (non compliant).</p>
Thinner	<p>950 Thinner</p>
Cleaning of equipment	<p>Remove remaining paint from equipment, flush thoroughly with 950 Thinner until solvent appears uncontaminated.</p>
FLASH POINT	<p>21° to 32°C.</p>
STORAGE	<p>Store in dry, cool conditions and protect from frost.</p>
VOC	<p>Below 350 gm/ltr, varies considerably with colour, please consult Protega Coatings for specific advice.</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>