

*Data sheet*

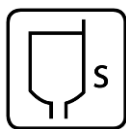
**Series 431**

**K.431**

**INDUSTRIAL GLOSSY SINTOFAST  
ENAMEL R.E.**



1000 g +  
150 - 200 g



20" - 22" FORD 4  
at 20°C



Ø 1.4 - 1.8 mm  
4 - 5 Atm  
No. of coats 2



Drying 20' at 20 °C  
Baking 30' at 60 °C

**NATURE OF PRODUCT:**

Fast-drying synthetic finish made of alkyds.

**FIELDS OF APPLICATION:**

Industrial carpentry, steel products, agricultural machinery, silos, etc.

**PREPARATION OF THE SUBSTRATE:**

**Iron surfaces:** Remove any traces of rust, grease, calamine and humidity by means of thorough mechanical cleaning, followed by degreasing. Apply a coat of our **SINTOFLEX - 494** or **490** series. After 6-12 hours apply fast drying enamel.

**Aluminum:** Sanding followed by degreasing with organic solvents. Apply a coat of **epoxy primer 193** or **190**, or **acrylic 793**.

**Galvanized sheet:** Sand lightly or scour, degrease with solvent, and then apply a coat of **193** epoxy primer, or **793** acrylic.

**PREPARATION OF THE PRODUCT:**

Comp. A: **K.431 + Colouring Tinters** 100 parts by weight

Thinner <sup>(1)</sup>: **D.434** or **D.525** 15 - 20 parts by weight

Mix until the colour and consistency are uniform.

Dilute to the desired viscosity.

<sup>(1)</sup> For ambient temperatures  $\geq$  of 25 °C, only synthetic thinner **D.434** should be used.

**PRODUCT SPECIFICATIONS:**

<b>TYPE OF PRODUCT</b>	: Single-component.
<b>APPEARANCE OF THE FILM</b>	: Glossy
<b>COLOURS</b>	: By choice
<b>DENSITY</b>	: 1,25 Kg/l (± 0,05)
<b>SUPPLY VISCOSITY</b>	: 14" (± 3) DIN 8 at 25 °C
<b>DRY RESIDUE</b>	: 63% (± 3%)
<b>CURING AT 20°C</b>	: - <i>Dry dust-free</i> : 20' – 30' : - <i>Touch dry</i> : 4 – 5 hours : - <i>Forced Drying</i> : 30' at 60 °C
<b>RECOMMENDED COATS</b>	: One crossed coat
<b>RECOMMENDED THICKNESS</b>	: 40 - 50 µm <sup>(2)</sup>
<b>THEORETICAL YIELD <sup>(3)</sup></b>	: 9,7 m <sup>2</sup> /Lt or 7,7 m <sup>2</sup> /kg at 50 µm dry
<b>RECOATING:</b>	: Wet-on-wet or max within 2 hours at 20 °C

<sup>(2)</sup> Do not exceed the recommended thicknesses to avoid compromising the regular curing of the film.

<sup>(3)</sup> In 75/25 ratio with **P.900**.

**SAFETY REGULATIONS:**

Strictly follow the instructions on the labeling and in the safety data sheet.

**STORAGE CONDITIONS:**

The storage room must be dry and with a temperature between +10 °C and +35 °C.

*The data and information contained in this sheet are the result of our experience and accurate laboratory tests. However, since the painting process represents a set of operations that are beyond our control, they do not therefore guarantee, in any way, the final performance of the cycle.*

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