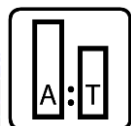


Data sheet

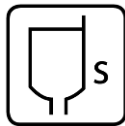
**Series 644**

**K.644**

## BRUSH-ON SINGLE-COMPONENT MICALUX



1000 gr +  
30 - 150 gr



20" - 30" FORD 4  
at 20 °C.  
Application by spray



Application  
by roller



Application  
by brush  
N° of coats 2



Drying: 1 - 2 hours  
Curing: 24 - 36 hours

### NATURE OF PRODUCT:

Brush-on high-strength synthetic micaceous enamel. Can be applied to iron after careful selection of the most suitable primer. The applied film remains elastic and adherent even after prolonged outdoor exposure.

### FIELD OF APPLICATION:

Decorative enamel for furniture, fixtures, metalwork, etc.

### PREPARATION OF THE SUBSTRATE:

**Iron surfaces:** Thoroughly remove all traces of rust, calamine, grease and moisture. Old paints with poor adhesion should be removed by sanding. Apply 1 or 2 coats of single-component primer (see our **490** or **494** series). After about 24 hours, apply the enamel finish by brush.

**Galvanized and aluminum surfaces:** Degrease and scour with scotch brite and then apply a suitable primer such as our **MONOFLEX 994**, or **2K EPOXY PRIMER 190** or **193**.

**Wood surfaces:** On new wood, apply one or two coats of polyurethane primer or other suitable primer. After the primer dries, sand thoroughly with sandpaper and then apply one or two coats of finishing enamel.

### PREPARATION OF THE PRODUCT:

Comp. A:	<b>K.644 + Coloring pastes</b>	100 parts by weight
Diluent:	<b>D.434</b> or <b>D.636</b>	3 - 15 parts by weight

### APPLICATION:

By brush, by roller by spray.

**PRODUCT SPECIFICATIONS:**

<b>TYPE OF PRODUCT</b>	: Single-component.	
<b>APPEARANCE OF THE FILM</b>	: Micaceous matte	
<b>COLORS</b>	: On request	
<b>DENSITY</b>	: 1,40 Kg/lit (± 0,05)	
<b>SUPPLY VISCOSITY</b>	: 25" (± 4) DIN 8 at 25 °C	
<b>SOLID CONTENT</b>	: 73% (± 2%)	
<b>DRYING</b>	: - <i>Dry dust-free</i>	: 1h – 2h
	: - <i>Print-free</i>	: 7h – 8h
	: - <i>Complete Curing</i>	: 24h – 36h
<b>RECOMMENDED LAYERS</b>	: 1 - 2 coats	
<b>RECOMMENDED THICKNESS</b>	: 50 - 60 µm	
<b>THEORETICAL YIELD</b>	: 10,6 m <sup>2</sup> /lit or 7,6 m <sup>2</sup> /kg at 50 µm dry	

**RECOATING:**

After 24 hours minimum. For product obtained by industrial dyeing, repaint wet-on-wet or within 4 to 6 hours, or 1/2 weeks after the first coat.

**Use white spirit-based thinners or those low in aromatic solvents.**

**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.*

**Rev.: 03/22**