

METALAC 2060

TECHNICAL DATA SHEET

Product Description

METALAC is a final paint based on alkyd resins used for painting shiny metal surfaces.

Recommended uses

It is recommended as a coating system with primer PRIMOCOT, for light or heavy metal surfaces, exposed to external conditions and in need of good anticorrosive protection.

Technical characteristics

Density: 1,11±0,05 g/ml	(EN ISO 2811.01-11, 20°C)
Production viscosity: 105±25 sec	(DIN 53211-70, 4mm, 20°C)
Solids by weight: 57,0±2,0 %	(EN ISO 3251-08)
Solids by volume: 40,0±3,0 %	(ISO 3233-98)
Flash point: 35±3°C	(EN ISO 1523-02)

Shade

White. Gloss.

Standard coating system and recommended dry film thickness

Layer 1: PRIMOCOT 43 40-50 µm – for anticorrosive protection
Layer 2: METALAC 2060 35-45 µm – ensures the necessary visual opacity with sufficient anticorrosive protection.

Spreading rate

Recommended dry film thickness: 40±5 µm
Spreading rate: 9,6±0,6 m²/Lt for the above thickness coating

Application instructions

Substrate: Steel, DKP.

Substrate Preparation: After carefully cleaning the surface, primer PRIMOCOT is applied (see TDS of this product).

Application method: Air spray, dip coating (or/and brush-roller). Stirring of paint before and during application.

Diluent: For application with spray gun and dipping, solvent X-1100.

Dilution rate:

	10°C	20°C	30°C
Desired application viscosity for spray gun: 25 sec (DIN 53211-70 No 4)	21%	16%	10%

Spray Gun Settings

Nozzle size (beck): 1,5-1,8 mm

Air pressure at the nozzle: 2-3 bar

Cleaning: Painting tools are cleaned with solvent X-1100.

Drying time

Drying time measurements were made in DKP specimens, after thinning with solvent X-1100 (or HARDADO 25% v/v) for dry film thickness 40±5 µm, at 23°C and a relative humidity of 50%.

	Solvent X-1100	HARDADO	
Set to touch:	30±10 min	20±5 min	(ASTM D-1640-03)
Dry through:	7±1 h	3±0,5 h	(ASTM D-1640-03)

Recoating time: 16±2 h (The 2nd coat can be applied after 4 hours with a small loss in adhesion and longer drying times of the 2nd coat).

Drying time may be prolonged under conditions of low temperature or high relative humidity.

Qualitative characteristics

Qualitative characteristics measurements were made 7 days after painting in DKP specimens drying at 23±2°C with 50±5% RH (dry film thickness 40±5 µm or 80±10 µm).

Whiteness Index WI: ≥ 68 (ASTM E 313-05)

Yellowness Index YI: ≤ 8,0 (ASTM E 313-05)

Adhesion (Cross Cut): (EN ISO 2409-13)

Total dry film thickness 40±5 µm: 0-2

Total dry film thickness 80±10 µm: 0-2

Impact Test: (ASTM D 2794-04)

Total dry film thickness 40±5 µm: 14±8/0-4 inch/pounds

Total dry film thickness 80±10 µm: 18±10/0-4 inch/pounds

Scratch test: (EN ISO 1518-00)

Total dry film thickness 40±5 µm: 7±2 N

Total dry film thickness 80±10 µm: 9±2 N

Bend test (Mandrel): 5±2 mm OK (ISO 1519-02)

Gloss (20°/60°): 80±7 / 90±5 % (EN ISO 2813-99)

Accelerated aging test with UV-B radiation: 500 h OK (EN ISO 16474-3-13)

Resistance to liquids (water-oil-petrol): OK (EN ISO 2812.01-95)

Hardness (König): 60±10 sec, after 7 days (EN ISO 1522-00)

Hardness with 25% HARDADO (König): 120±20 sec, in 7 days (EN ISO 1522-00)

Resistance to salt spray: (EN ISO 9227-06)

Total dry film thickness 40±5 µm: 150 h OK

Total dry film thickness 80±10 µm: 300 h OK

One layer PRIMOCOT 40±5 µm and one layer METALAC 40±5 µm: 600 h OK

Packaging

In containers holding 19 Lt

Storage

12 months under normal conditions of storage.

Health and safety

Please refer to the labeling on the container. If further information is required please refer to the Material Safety Data Sheet.

Notes

- Avoid application at temperatures below 10°C and greater than 37°C and humidity greater than 80%.
- The temperature of the surface to be painted, under normal conditions of humidity 40-50%, should not be less than 8-10°C of that of the environment. Under conditions of 60% humidity this difference should not exceed 5°C.
- For application with spray gun, HARDADO in up to 25% v/v instead of solvent may be added, and a film of higher gloss, hardness and mechanical resistance will be achieved (in scratching, solvents, washing etc). The mixture has to be used within 8 hours or else it becomes hard and unserviceable.
- For faster drying during winter, for painting with spray gun, solvent C-1400 in up to 14% v/v can be used, but a film of lower gloss and increased yellowing will be formed.

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This issue replaces all previous ones