



INDUSTRIAL PAINT MIX SYSTEM

Technical Data Sheet No 614

A one component fast drying acryl based mix system

High endurance and gloss

Available in various shades including silver

General Technical Description



Mix 20-25% with 750 SYNT THINNER or 767 ECO THINN NITRO THINNER (for faster drying properties)

Mix well and filter through paper filter.



Ready to spray:
17-20 s
DIN 4 / 20°C (68°F)



10 - 12h / 23°C (73°F)

Surface

On Body Primed surfaces

On metallic surfaces

Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

Product Application: 2 coats. Apply one coat, and after 15 min flash off time apply the second coat



20-25% mix with 750 SYNT THINNER or 767 ECO THINN NITRO THINNER for faster drying properties
Pot life: N/A



Flash off time
15 - 20 min / 23°C (73°F)

Flash Point:
28°C / 82°F

Specific Gravity:
0.9-1.12 g/cm³ **

Solid Content (No thinner):
40-55% Weight

VOC (2004/42/EC)

This product is recommended for industrial use only

Theoretical Coverage:
8 - 9 m² / l at 50 micron (2 mil) dry film thickness

Cleaning of equipment:
Clean after final use with 767 ECO THINN NITRO THINNER

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well.
- Optimum operating range 10°C - 25°C (50°F - 77°F).

Storage shelf life:

- Store in a cool place +5°C - +25°C (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers

** Specific weight values lie within a range and depend on the color shade.



No use of extra thinner



10 - 12h / 23°C (73°F)



Always wear protective equipment



Ready to spray:
17-20 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.2 - 1.4 mm
2-3 bar (29 - 44 psi) inlet pressure
2x coats = 50 - 60 micron (2 - 2.4 mil)



Follow the application instructions mentioned in this TDS



HVLP 1.2 - 1.4mm
2 bar (29 psi) inlet pressure
2x coats = 50 - 60 micron (2 - 2.4 mil)

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