

ROSALEE SUPER SYNTHETIC STOVING ENAMEL

➤ **Scope**

Almost, all enamels can be stoved or force dried with hot air/oven. But, invariably the shade will appear off coloured and hardness of the dry film will be poor. Besides, corrosion resistance will not be upto mark. Therefore, all costlier items, needing long lasting finish, must be coated with super stoving enamel. Here an alkyd resin is mixed with melamine resin, in correct proportion, so that when the film is stoved at 120°c for 30 minutes, it should not cause any variation in shade and superb gloss should be obtained along with hardness.

➤ **Areas of Application**

All metallic items, which need expensive but long lasting finish, with full gloss. Even vehicle manufacturers use super stoving enamel for the final finishing of their products.

➤ **Surface Preparation**

The surface must be primed, puttied and sanded to accept the finishing coat. Surface thus prepared may still have minor patches of oil and grease (which come during handling.) Therefore, not to take any chance, it should be solvent wiped before commencing final painting.

➤ **Technical Data**

- APPEARANCE : Free flowing liquid with appropriate shade.
- VISCOSITY AT 30°C ON FC4 : 60 – 70 sec. At 30°c
- WEIGHT PER LITRE AT 30°C : 1.02 to 1.10 kg. / ltr.
- SPRAYING VISCOSITY : 25 to 30 sec.
- THINNER TO BE USED : Thinner 044
- SCRATCH HARDNESS : Passes load of 1500 gms.
- CROSS HATCH TEST : Passes the test
- IMPACT TEST : Passes
- FLEXIBILITY : Passes the bending mandrel of 1/4"
- OIL RESISTANCE : No effect for 24 hours
- PETROL RESISTANCE : No spotting when petrol overflows.
- GLOSS 60° GEOMETRY : Minimum 90%
- SALT SPRAY RESISTANCE : No effect for 500 hours on a primed surface.
- COVERING CAPACITY : 11 to 12 sq. Mtrs. Per coat
- PERFORMANCE IN Q-PANEL WEATHER-0-METER : 200 hrs. - no effect
300 hrs. - gloss diminishes by 10%
- OUTDOOR EXPOSURE : 18 months – no effect if the painted surface is
Polished once a fortnight.

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➤ **Directions for Use**

Thin down the paint to correct viscosity for application. (super stoving enamels do not air dry.) Strain the mix using a muslin-lint free cloth and start application. Give 10-15 minutes for flash off time and then stove at 120°C for 30 minutes or at 150°C for 15 minutes. Ensure, the oven has good temperature control as well as proper ventilation. The oven should not have “foul” atmosphere, which can result into patches on the stoved surface.

➤ **Notes**

The amino resins present in the super stoving enamels, are “reactive” even without stoving. Therefore, they are best used before six months from the date of manufacture.

Also ensure that the air from compressor is free from moisture and oil. When compressor air is released, lot of moisture is created. It is taken care of by air regulator and moisture separator. The water gets accumulated in the tank for compressed air. Such water should be removed from time to time.

➤ **Disclaimer**

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