



Manufacturer of Industrial,
Protective, Marine Traffic, Automotive
& Decorative Paints



Stoving Alkyd Melamine Varnish

KRS-640



Description & Recommended Use

Stoving alkyd varnish is a one component coating. This varnish base on alkyd resin and melanin formaldehyde resin. It provides reasonable heat resistance abrasion & scratching resistance as well as resistance against chemical spillages. It can be used for metal & steel surfaces such as bikes and motorcycles, refrigerator, washing machine, boiler and cars.

Surface Preparation

The surface should be free from any rust, moisture, mill scale, oil & grease
Mechanical & chemical surface preparation methods should be performed depending on the type of contamination, the coating system environ mental condition & the service life
Apply the paint immediately followed by surface preparation

Data Sheet / Technical Data at 25 ° C

Binder	alkyd –melamine
Components	one
Colour	colourless
Finish	gloss
Density (gr/cm ³) (A+B)	0/97±0.05
Sold Contents (by weight) (A+B)	40%±2
Solid Contents (by volume) (A+B)	33%±3
Dry film thickness(μ)	30±40 μ
Theoretical coverage at 50μ	11 m ² /lit
Flash point	21 ° C
Storage condition	Store in dry & cool

Technical Application Details at 25 ° C

Curing mechanism	oxidation & solvent release
Mixing ratio (by weight) (A/B)	----
Mixing ratio (by volume) (A/B)	----
Pot life	----
Thinner	355
Stoving condition	20-30min. at 150 ° C ± 10 ° C
Min. flash – off	15 min
Min. time to overcoat	----
Max. time to overcoat	----
Shelf life (Standard condition)	9 Month

Description

Application Equipment

Conventional Spray
Airless Spray
Brush
Pump ratio: 28:1



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Tip: 0.38 mm-0.53 mm

Nozzle pressure: 150 bar/ 2200 psi

Code

Environmental Conditions

Air temperature: 10°C – 40°C

Surface temperature: 10°C – 40°C

To prevent moisture condensation

During application surface temperature must be at 3 °C above the dew point

Application procedure

Flush equipment with cleaner before use

Stir two components with a power mixer. Notice pot life time and mixing ratio

Use Shakiba`s thinner for adjusting the viscosity

The thinner should be added gradually

The consumption depends on temperature and type of equipment and thickness paint

Clean all equipment with Shakiba`s thinner

Safety

This product is flammable it must be kept away from heat, flash & flame

keep container closed use with adequate ventilation & Earth

Prolonged & repeated contact with skin may be harmful

In case of eye contact flush with plenty of water and check with a medical doctor.

Note

Never apply coatings under environmental condition.

Adjusting the viscosity & pressure.

This information given 25°C temperature and changed temperature cause to change data

Don't use different thinner; otherwise, we decline all responsibilities of it.

For more information, please call to sale engineering expert.



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