



TECHNICAL SHEET



Product name:

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Date: 13.4.2016

Characteristics:	Single-pack glossy enamel for industrial applications
Description:	Single-pack water-thinnable glossy enamel, mainly for metal materials pre-treated with primer
Composition (general):	Mixture based on acrylic and alkyd resins. It contains color-fast pigments, fine extenders, coalescent agents and other ingredients enhancing paint properties. As a thinner, it contains water and a small amount of glycol-ether-based solvents; it does not contain any aromatic solvents or white spirit.
Application:	Glossy surface treatments of metal structures, products and semi-finished products in mechanical engineering and other branches of the metal industry. The product is suitable mainly for applications at stable temperatures in paint shops and for application with heat curing of the products. The application should always be discussed with the manufacturer.
Colors:	It is made according to RAL, EUROTREND, NCS, ČSN color charts or in agreed color shades.
Properties:	Paint:
Density (g/cm³):	1.1 - 1.3
Volume solids ONL (%):	35 - 45
Weight solids (%):	35 - 55
KU viscosity:	70 - 120
Flow time by use of flow cups F6 (s):	20 - 280
pH (at 20 °C):	8 - 10
VOC (volatile organic compounds) (kg/kg):	0.005 - 0.09
0.006 TOC (total organic carbon content) (kg/kg):	0.003 - 0.05
Maximum permissible value of VOC content (g/l):	140
Max. VOC content in the product in the ready-to-use condition (g/l):	120
Water-thinnable paint category:	A/i single-pack paints with a special function.
Appearance/color:	Liquid
Gloss value (at 60°):	70 - 90
Pendulum hardness (2H/80 °C):	min. 30%
Miscibility:	Miscible with water.
Adhesion by the grid-cutting method:	Degree 0 (cut edges are completely smooth and free of any defects)
Drying, degree 1 (surface dry):	1 hr
Drying time, degree 2 (dry to touch):	2 hrs
Drying time, degree 4 (dry-through):	4 hrs
Substrate preparation:	The substrate must be dry, free from any mechanical and greasy impurities and residues of old paint incoherent with the substrate. Recommended substrate treatments include sand blasting, blasting, degreasing or phosphatizing.
Application conditions:	It is recommended that the application method and the application conditions always be discussed with the manufacturer, who will adapt the composition of the paint to the specific conditions. The air and substrate temperatures during the application and drying of the paint shall not fall below +15 °C.
Thinning:	Water
Recommended method of application:	With a paint brush, a paint roller or by soaking or spray painting - air, pneumatic, high-pressure - Airless, Airmix



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Recommended coating system:	<p>1 - 2 layers of DENAKOR HG 56, optimum paint thickness of 80 -120 μm DFT, the re-spray interval with two layers is 24 hrs at 20 °C; if additional drying is employed at temperatures to 80 °C, the interval can be reduced by up to 2 hrs.</p> <p>1 - 2 layers of DENATOP P/AU, dispersion acrylic enamel, optimum layer thickness of 80 μm DFT, the re-spray interval between the primer and the enamel must be at least 6 hrs; the same applies to 2-layer enamel at 20 °C; if additional drying is employed to 80 °C, the interval can be reduced.</p> <p>Other anticorrosion primers of the DENAKOR series or the epoxy primer EPOXIDEN Z can also be used as primers.</p>								
Application data:	The paint can be additionally dried at a max. of 80 °C.								
Spreading capacity and recommended thickness:	<p>The recommended coat thickness is 80 DFT</p> <table border="1"><tr><td>Wet-film thickness WFT (μm)</td><td>200</td></tr><tr><td>Dry-film thickness DFT (μm)</td><td>80</td></tr><tr><td>Theoretical spreading capacity (m^2/kg)</td><td>4.20</td></tr><tr><td>Theoretical spreading rate (kg/m^2)</td><td>0.25</td></tr></table>	Wet-film thickness WFT (μm)	200	Dry-film thickness DFT (μm)	80	Theoretical spreading capacity (m^2/kg)	4.20	Theoretical spreading rate (kg/m^2)	0.25
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Packaging:	Plastic or metal containers weighing 0.8 - 200 kg.								
Storage:	<p>Store in original and well-closed containers in cool, dry and well-ventilated areas at temperature from +5 to +25 °C. Protect from freezing. Keep the mixture separated from drinks, foodstuff, feedstuff and medicine. Store away from the reach of children.</p> <p>The shelf life is a minimum of 12 months from the date of manufacture. The product must not freeze.</p>								
Disposal of packaging and waste:	Product residues and contaminated packaging shall be disposed of as hazardous waste in accordance with the applicable regulations.								
Safety and hygiene:	Observe the principles of personal hygiene. Ensure good ventilation of the workplace. During application, wear respiratory protection. If on the skin, wash the affected areas with soap and water. If in the eyes: rinse with water. If swallowed, rinse mouth with water, do not induce vomiting. In case of health difficulties, seek medical attention.								
Legislation, certificates, attestations, other tested parameters:	See the Declaration of Conformity								