



TECHNICAL SHEET



Product name:

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Characteristics:	Single-pack water-thinnable enamel
Description:	Dispersion styrene-acrylic enamel for industrial applications
Composition (general):	Mixture based on styrene-acrylic dispersion containing color-fast pigments, extenders, dispergation and soaking additives, coalescent agents and other ingredients enhancing its 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:	Top coats for metal products and semi-finished products in the metal industry. Metal structures and metal substrates must be treated with a suitable anticorrosion paint. 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 be discussed with the supplier or 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 (%):	45 - 55
KU viscosity:	60 - 100
Flow time by use of flow cups F6 (s):	14 - 220
pH (at 20 °C):	8.5 - 10
VOC (volatile organic compounds) (kg/kg):	0.04 - 0.09
0.006 TOC (total organic carbon content) (kg/kg):	0.02 - 0.05
Maximum permissible value of VOC content (g/l):	130
Max. VOC content in the product in the ready-to-use condition (g/l):	110
Water-thinnable paint category:	A/d - interior/exterior coating materials for wood, metal or plastics for furnishings and linings of buildings.
Appearance/color:	Liquid
Gloss value (at 60°):	60 - 80
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):	40 min.
Drying time, degree 2 (dry to touch):	1hr 20min
Drying time, degree 4 (dry-through):	4 hrs 15 min
Substrate preparation:	The substrate must be treated with a priming anticorrosion paint of the DENAKOR, DENAPOX Z, EPOXIDEN Z or DENAPUR Z series. The possibility of use of other types of primers must be tested in advance or discussed with the manufacturer.
Application conditions:	It is recommended that the application method and the application conditions are always 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. At lower temperatures, the enamel does not create a perfect film and the quality and durability of coatings are reduced. If multiple coatings are required, the time lag between individual coatings should be at least 4-6 hrs, depending on the drying conditions.
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 The enamel is supplied in the consistency adapted to the application method. The paint can be additionally dried at a max. of 80 °C.



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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 up to 2 hrs.</p> <p>1 - 2 layers of DENATOP P/SD/, dispersion styrene acrylic enamel, optimum layer thickness of 80 μm DFT, the re-spray interval between the primer and the enamel must be at least 4 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>												
Spreading capacity and recommended thickness:	<p>The recommended coat thickness ranges from 80 to 120 μm DFT</p> <table border="1"><tr><td>Wet-film thickness WFT (μm)</td><td>200</td><td>300</td></tr><tr><td>Dry-film thickness DFT (μm)</td><td>80</td><td>120</td></tr><tr><td>Theoretical spreading rate (m^2/kg)</td><td>4.20</td><td>2.80</td></tr><tr><td>Theoretical spreading rate (kg/m^2)</td><td>0.25</td><td>0.35</td></tr></table>	Wet-film thickness WFT (μm)	200	300	Dry-film thickness DFT (μm)	80	120	Theoretical spreading rate (m^2/kg)	4.20	2.80	Theoretical spreading rate (kg/m^2)	0.25	0.35
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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 water and soap. 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												