

PROTECTIVE COATINGS

TECHNICAL DATA SHEET

NATIONAL STOVING ENAMEL

DESCRIPTION	A high quality alkyd-melamine formaldehyde based industrial stoving enamel. It gives a tough and flexible film with excellent gloss, adhesion and weather resistance.
RECOMMENDED USE	On metallic surfaces for use on equipments, domestic appliances, automotive and industrial parts.

TECHNICAL DATA

COLOURS	As Per National Shade Card
FINISH	Gloss
VOLUME SOLIDS	51 ± 2%
SPECIFIC GRAVITY KG/L	1.27 ± 0.05
THEORETICAL SPREADING RATE	17 M ² /LTR.
RECOMMENDED (DFT) - MICRONS	30
RECOMMENDED (WFT) - MICRONS	60
DRYING TIME	Temperature, humidity, air movement, film thickness and number of coats all affect the drying time.
STOVING SCHEDULE	120°C for 30 minutes (OR) 150°C for 20 minutes
FLASH OFF TIME	10 - 15 minutes

APPLICATION DATA

APPLICATION METHOD	Air (Conv.) Spray
THINNING (VOLUME)	5 - 10%
THINNER / CLEANER	National Stoving Thinner
AIRLESS SPRAY REQUIREMENTS	Tip : NA
CONV. SPRAY REQUIREMENTS	Atomizing Pressure : 50 PSI
MIXING RATIO (BY VOLUME)	Base : Hardener : One Pack
POT LIFE @ 30°C	One Pack
RECOMMENDED SYSTEM	No. of Coats x DFT (Microns)
Apply on dry, dust free surface.	- National Stoving Primer 1 x 35
	- National Stoving Enamel 1 x 30

MISCELLANEOUS DATA

FLASH POINT	30°C
SHELF LIFE @ 30°C	6 months in original sealed containers, with proper storage conditions.

NOTE : We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests. We reserve the right to change data without prior notice. For surface preparation, safety details, refer specifier and safety data.