

PRODUCT DATA SHEET

HD STOVING ENAMEL 640



Description:	HD STOVING ENAMEL 640 is a glossy stoving alkyd amino coating, which meets stringent specification requirement of General industries. (AVAILABLE IN GLOSSY/SEMI GLOSSY VERSION)
Recommended use:	These products are premium quality finishes designed for spray application. It offers outstanding durability and excellent post-fabrication performance. Typical end users are Barrel manufacturers; shock up manufacturers and for General Industry's components.
Service temperature:	Maximum, dry exposure only: 150°C/248°F.
Availability:	Not included in Group Assortment, availability subject to special agreement.

PHYSICAL CONSTANTS:

Shade no's/Colours:	White (Shades are available on request)
Finish:	High Glossy/Semi Glossy
Volume solids, %:	45 ± 1%
Theoretical spreading rate:	15.3 m ² /l [613.5 sq.ft./US gallon] - 30 micron/1.2 mils
Flash point:	38 °C [100.4 °F]
Specific gravity:	1.16 kg/litre [9 lbs/US gallon]
Stoving Schedule :	10 mins @170°C

APPLICATION DETAILS:

Application method:	Airless spray / Air spray
Thinner (max.vol.):	As per customer application viscosity requirement
Nozzle orifice:	0.018 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HD Stoving Thinner
Indicated film thickness, dry:	30 - 50 micron [1.2 mils – 2 mils]

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Safety Data Sheets and follow all local or national safety regulations.

SURFAC PREPARATION: Properly cleaned metal surface is necessary to obtain glossy and optimum physical and resistance properties.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

This Product Data Sheet supersedes those previously issued.

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