



## Product description:

21077 is a one-component coating based on alkyd amine resin and containing aluminum leafing pigment. Among the features of this coating, excellent adhesion, good mechanical capabilities such as hardness, excellent gloss, flexibility, excellent gloss, impact ability, color stability and thermal shock tolerance can be mentioned.

## Application:

This coating is used to paint various industrial products such as external surfaces of electronic components, tables, chairs, water heaters, gas stoves, car spare parts and other metal parts.

## Technical data:

Specification	Details	EN Standard	ASTM Standard
Shade / Color	White and colored	EN ISO 11664	D2244
Solid by Volume (%)	45 ± 2	EN ISO 3233	D2697
Solid weight (%)	55 ± 2	EN ISO 3251	D2369
Density / Specific gravity g/cm <sup>3</sup>	18- 31.5 kg/lit	EN ISO 2811	D1475 (2025)
Shelf life	12 months	EN ISO 1513	D1849 / D869
Dry Film Thickness (DFT) μm	15 - 25 μ	EN ISO 2808	D1005 / D7091
Wet Film Thickness (WFT) μm	60 - 30 μ	EN ISO 2808	D4414
Theoretical coverage strength	19.2 - 34.6 m <sup>2</sup> /lit	EN ISO 3233	D2697
Flash Point	25°C	EN ISO 2719	D93 (Pensky-Martens)

## Cooking conditions:

Waiting time before the furnace	Cooking temperature,	cooking time
5-10 minutes	120-150°C	20-30 minutes

If the internal temperature of the oven is not stable, the change of cooking time is under the control of the operator. For continuous systems, the length of the conveyor after leaving the furnace should be at least three meters with a minimum speed.

## Equipment Used:

AIRLESS SPRAY : Nozzle diameter: 0.013-0.019 inches Output pressure: minimum 141 times      AIR SPRAY : Nozzle diameter: 1.8 -2.2 mm Nozzle pressure: 2-3 times  
Brush: : 20-30 μ (for staining) - Roller: : 20-30 μ (for staining)

## FURNACE PAINTS- FURNACE ALUMINUM (21077)

### Environmental Conditions:

The surface temperature should be at least 3 degrees higher than the dew point. In hot weather, the temperature of the ingredients before mixing should be 20-25°C. Otherwise, the Pot life will be very short. To ensure hardening, air and surface temperature should be above 10°C. This cover should not be implemented in areas where the weather changes or the wind speed exceeds 7 m/s.

### Surface Preparation:

- The desired surface should be well clean, dry and free from any pollution. Oil or grease should be washed according to SSPC-SP1 standard.
- In order to prepare the surface, phosphate, chromate methods or the use of wash primer is recommended.

### Method of Applying:

- All equipment should be cleaned with recommended thinner before use.
- Mix the desired coating with a strong mixer.
- Add 5% hardener and continue mixing for 3 minutes.
- For application with air spray, 10-15% thinner is recommended and for airless spray, 10-5% thinner is recommended.
- In case of painting, 20% thinner is recommended.
- Each pulse of painting should be used parallel to each other so that each pulse covers 50% of the painted surface at the right angle.
- To ensure the desired thickness, angles, sharp edges, rivets, and uneven parts should be covered again.
- Wash all equipment immediately after use.

**Safety Tips:** This coating is flammable and must be away from flame and heat, and the operator is obliged to read and comply with the MSDS of this product, use a special mask and safety gloves during use, and operate in environments with proper ventilation.

**Storage Conditions:** This product should be stored in a closed space away from direct rays at a temperature of 5-35 degrees.

**Considerations:** The drying time depends on the film thickness applied, all the data in this catalog are based on the thickness of the dry film in vitro conditions.



**LEGAL NOTES :** The information contained in this Technical Data Sheet is based on laboratory testing and practical experience. Actual performance may vary depending on substrate condition, application method, and environmental conditions. Users should test suitability before large-scale application.

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