

TECHNISPRAY PAINTS LTD.

Linton House, Catherine Street, Aston, Birmingham B6 5RS, U.K.

Tel: ++44 (0) 121 326 8020 Fax: ++44 (0) 121 327 1507

Email: enquiries@kolorbond.co.uk

[www: kolorbond.co.uk](http://www.kolorbond.co.uk)

TECHNICAL DATA SHEET

KOLORBOND®

PRODUCT DESCRIPTION

Kolorbond® has been specially developed for PVCu plastic and powder coatings that are designed primarily for use on windows, doors, claddings, and conservatories used in new and refurbishment work in the domestic and commercial sectors of the market. The coating chemically bonds with the surface. The product gives protection from the ultraviolet radiation of the sun.

CHARACTERISTICS

Gloss @ 60 degrees	Gloss: 78 % Minimum / Satin: 50 +/- 5 % / Matt: 30 +/- 5 %
Specific Gravity	0.89 +/- 0.08 @ 20°C
Weight Solids (%)	15.5 (Clear) to 20.0 (depending upon the colour)
Volume Solids (%)	15.3 (Clear) to 19.8 (depending upon the colour)
Packaged Viscosity	16.0 – 21.0 seconds @ 20° C Ford Cup No. 4
Shelf Life	One Year
Flash Point	11°C (Measured with Seta Closed Cup)
Volatile Organic Content (VOC)	757 +/- 85 grams per litre

FILM THICKNESS

Dry Film Thickness	20 - 30 microns
Wet Film Thickness	129 - 194 microns (Clear) to 100 - 150 microns (Colour)

CURE PROCESS

Flash Time (Between Coats)	10 - 15 minutes @ ambient temperature (16° C)
Oven Cure	50 minutes @ 50°C
Post Cure	24 hours @ ambient temperature (16°C)

APPLICATION EQUIPMENT

Equipment	HVLP Cup Gun (new work: interior spraying)	Suction-Feed (refurbishment exterior spraying)
Manufacturer Model (gun)	DeVilbiss JGHV 522-1	DeVilbiss
Fluid Tip	FY 1.0 mm.	1.6 mm.
Air Cap	JGHV-16-13	186
Pot Pressure	7 - 16 psi	Full

The gun tip/needle/air cap combinations can be varied to suit the volume throughput required. Feed of product is generally from pressure pots and pumps. Spray techniques vary, and the fluid flow can be adjusted considerably to obtain the best results. There are numerous variables, namely air pressure, air volume, and pot pressure. Altering any of these will affect the others, thus requiring further adjustments. A number of other spray gun suppliers are able to provide suitable alternatives. Each supplier should be evaluated in full before procuring to verify actual application results.

CLEANING OF EQUIPMENT

Clean spray equipment regularly with any proprietary gun cleaning solvent. Spray guns and pots must be cleaned as required between colours using any proprietary cleaning apparatus.

REDUCTION

No reduction necessary.

STORAGE CONDITIONS

Containers must not be exposed to direct sunlight or temperatures above 50° C. Store away from oxidizing agents. Avoid exposure to sources of heat or ignition. Static electricity may result in build-up that may cause a flash fire or an explosion. Keep containers tightly closed.

FIRST AID PRECAUTIONS

For inhalation, move the exposed person to fresh air at once. Get medical attention immediately.

For breathing difficulties, oxygen may be necessary. If rapid recovery does not follow, apply artificial respiration as necessary.

For ingestion, do not induce vomiting. Obtain medical attention immediately.

For skin contact, wash the skin immediately with soap and water. Use a moisturiser. Get medical attention if any discomfort continues.

For eye contact, flush with plenty of water for several minutes. Continue to rinse for at least 15 minutes. If irritation persists, refer for medical attention.

FURTHER INFORMATION

For further information please contact:

Technispray Paints Ltd.
Linton House
Catherine Street
Aston
Birmingham
B6 5RS
U.K.

Tel: ++44 (0) 121 326 8020
Fax: ++44 (0) 121 327 1507
Email: enquiries@kolorbond.co.uk
WWW: kolorbond.co.uk

Technical Queries: Eric Desmond