

PRODUCT CODE - 5007

MARIGOLD SUPER STOVING BARREL ENAMEL- ALKYD AMINOENAMEL

● **Description**

Almost, all enamels can be stoved or force dried with hot air/oven. But, invariably the shade will appear off coloured and hardness of the dry film will be poor. Besides, corrosion resistance will not be upto mark. Therefore, all costlier items, needing long lasting finish, must be coated with SUPER STOVING ENAMEL. Here an alkyd resin is mixed with MELAMINE resin, in correct proportion, so that when the film is stoved at 150°C for 12 minutes, it should not cause any variation in shade and superb gloss should be obtained along with hardness.

● **Areas of Application**

All metallic items, which need expensive but long lasting finish, with full gloss. Even OEM/BARREL ENAMELS vehicle manufacturers use SUPER STOVING ENAMEL for the final finishing of their products.

● **Surface Preparation**

The surface must be free from oil, moisture, dust & dirt with suitable degreasing chemicals.

● **Technical Data**

Appearance	:	Free flowing liquid with appropriate shade.
Viscosity at 30°C on FC4	:	60 – 70 sec. at 30°C
Weight per litre at 30°C	:	1.02 to 1.10 kg. / ltr.
Spraying viscosity	:	25 to 30 sec.
Thinner to be used	:	Thinner 044(STOVING THINNER)
Cross hatch test	:	Passes the test
Flexibility	:	Passes the bending mandrel of 1/4”
Oil resistance	:	No effect for 24 hours
Petrol resistance	:	No spotting when petrol overflows.
Gloss 60° geometry	:	Minimum 85%
Covering capacity	:	11 to 12 sq. mtrs. per coat

● **Directions for Use**

Thin down the paint to correct viscosity for application. Strain the mix using a muslin-lint free cloth and start application. Give 10-15 minutes for flash off time and then stove at 150°C for 12 minutes. Ensure, the oven has good temperature control as well as proper ventilation. The oven should not have “foul” atmosphere, which can result into patches on the stoved surface.

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● **Notes**

The amino resins present in the super stoving enamels, are “reactive” even without stoving. Therefore, they are BEST USED before six months from the date of manufacture.

Also ensure that the air from compressor is free from moisture and oil. When compressor air is released, lot of moisture is created. It is taken care of by AIR REGULATOR and MOISTURE separator. The water gets accumulated in the tank for compressed air. Such water should be removed from time to time.

The Product is for Industrial use only. Product data given here *is correct to the best of our knowledge but their accuracy may vary depending upon the quality of the substrate, application parameters and atmospheric conditions affecting the performance of the product. Therefore the users are advised to make their own tests to determine the suitability of products for their own purposes under present conditions. Unless agreed upon in writing, we do not accept any liability for the performance of the product. We hereby disclaim any warranties or representations, liability, including but not limited to negligence, injury, consequential losses or damages arising from the use of the Products as recommended above. Product data are subject to change without notice.*

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PRODUCT DATA SHEET

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