

Colorama MO400

STOVING MELAMINE ENAMEL

Colorama stoving melamine enamel is modified, alkyd melamine based stoving enamel containing pigments of high opacity and color retention.

Properties and Areas of Use

- Excellent color and gloss retention.
- Excellent mar resistance.
- Tough & flexible.
- Excellent adhesion to bare steel.
- Oil & petrol resistant.
- Used for the protection and decoration of machinery, light fittings, refrigerators, electrical gear, office furniture, cabinets, drums, tool boxes etc.

Technical Coating Data @ 25 °C

Finish	High Gloss
Color Range	As per RAL color card
Solids Volume	(52-58)% ± 2% depending on color
Dry Film Thickness Range	20-50 µm
Theoretical Spreading Rate	(17.3 – 19.3) m ² /L @ 30 microns DFT (loss factors will apply in practice)
Baking Time	15 min at 170°C peak metal temp.
Shelf Life	12 months (stored in a cool dry place)
VOC	490 g/L
Mixing ratio	Single pack

Film Thickness and Spreading Rate:

	Minimum	Maximum	Typical
Film thickness, dry (µm)	20	50	30
Film Thickness, wet(µm)	36	91	55
Theoretical Spreading Rate (m ² /L)	27.5	11	18.3

Suitable Surfaces

- Mild steel, galvanized and zinc coated steel, aluminium and most non-ferrous metals

Bare Steel:

Objects to be coated must be dry, clean and free from dust, oils, grease, water and any other contaminations may affect adhesion.

Objects to be coated must be chemically washed and dried before application.

Application Conditions

Substrate should be clean and free from any contamination. Hot dry air furnaces are recommended.

Application Information

Thinning should only take place after the material has been thoroughly mixed.

Conventional Air Spraying

- Thin with Thinner Colorama 901S or 921
- spray at 20-22 sec/ Ford cup 4.
- Apply air atomizing pressure of 3.5 atm.

Cleaning Thinner

Equipment should be cleaned immediately after use with Thinner Colorama 901S or 921.

Drying time:

Drying takes place in hot dry air furnaces at 170°C for 15 min.

Storage:

Keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling:

Handle with care. Stir well before use.

Packing Size:

18 L

Summary Safety Information

- Avoid inhalation of spray mist and skin contact by the use of masks, gloves and other personal protection. Eyes should be cautiously washed with water or proprietary wash, and medical attention obtained. Skin should be thoroughly washed using a cleanser and soap and water.
- Product is flammable
- No sparks or flames
- No smoking

The information given in this data sheet represents test results & practical experience obtained under controlled conditions, and are correct to the best of our knowledge. However, as products are often used under different conditions, we can only guarantee the quality of our product, and reserve the right to change data without further notice.