

PRODUCT: ARSONECO 320 NERO IMM
W320N45 -

- : S=can; F=drum; C=tank

**THE BLACK PRODUCT IS USED BY DIPPING FOR REFRIGERATOR STEEL CONDENSER.
THE BAKING CONDITION IS FORCED DRYING**

PRODUCT CHARACTERISTICS IN DELIVERY FORM

	Units	
- Binder		: Alkyd / Melamine
- Delivery viscosity(DIN Cup 4 at 25°C)	sec	: 60 - 80
- Density (at 20°C)	kg/dm ³	: 1,080 ± 0,03
- Solid content	(weight on weight)	: 35 ± 2
- Storage stability (+ 5°+ 30°C)	(months)	: 6
- pH		: 8,4 - 9,2

METHOD OF APPLICATION

Dipping

- Thinner type	(qual)	: water
- % Thinner	(%)	: about 10 - 15
- Viscosity (DIN Cup 4 at 20°C)	(sec)	: 18 - 20

The lay on conditions should be defined on the customer plant

Units

- Coverage	(micrometer)	: >10
- Recommended dry film thickness	(micrometer)	: 10 - 20
- Substrate (it must be absolutely clean, i.e. dirt, rust, grease, moisture are to be removed)	(qual)	: stainless steel ; iron
- Pre- treatment		: iron phosphate

DRYED FILM CHARACTERISTICS

- Forced drying		
. Flash off time	min at 30°C	: 30
. Curing condition (effective on substrate)	min at 140 °C	: 20
- Adhesion on steel	%	: 95 – 100
- Hardness tester Bz	Bz	: ≥100
- Gloss 60°	UG	: semi glossy
- Salt spray test 48 hours*	qual	: no blistering

OTHER CHARACTERISTICS

- Pigments	qual	:Pb and Cr Free
- Flash Point **	°C	:56

* On steel pieces phosphated with iron salts

** The combustion of this product is autolimitating (EEC 449 par 2-4-; 5)

Lainate, July 2012