

ViterPaq PE20/80/90-W Stoving Finish

Product Description	A compliant, high quality water-borne stoving polyester enamel for the coating of steel drums and general industrial finishing.			
Features & Use	<ul style="list-style-type: none"> Product names include ViterPaq PE20-W (low sheen primer), ViterPaq PE80-W and ViterPaq PE90-W Suitable for high quality coating of drums and general industrial finishing Excellent adhesion to clean steel Compliant to below 290gm/lit (less water) as a stoving enamel 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Gloss (PE80-W, PE90-W)			
Volume Solids	25-40 ± 2% depending on colour			
VOC Content	Varies considerably with colour, please consult Axalta Coating Systems			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	10 µm	29 µm	34.5 m ² /litre
	Maximum	30 µm	86 µm	11.5 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Stoving Schedule	Applied to 25 microns DFT	+23 °C		
	Flash Off	5 - 15 min		
	Cure (at peak metal temperature)	6 min @ 205 - 210°C 10 min @ 160°C		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
Colours	White, Black and other colours to customers specification (PE20-W – red oxide)			
Product Code	3883 and 3895			
SG	1.0 – 1.4 kg/lit unmixed, varies with colour			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 12 months if stored as above in unopened containers			
Flash Point	Above 60°C			

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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Pre-treatment improves adhesion and reduces corrosion under the paint film. Consult Axalta Coating Systems to check your pre-treatment process is suitable 														
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator.														
Thinner	Demineralised or potable water		Equipment Cleaner 1921 Thinner												
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the ambient temperature should be a minimum of 10°C, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="419 860 692 936">Method</th> <th data-bbox="692 860 938 936">Airless Spray</th> <th data-bbox="938 860 1185 936">Conventional Spray</th> <th data-bbox="1185 860 1339 936">Brush</th> <th data-bbox="1339 860 1495 936">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 936 692 992"></td> <td data-bbox="692 936 938 992">Yes</td> <td data-bbox="938 936 1185 992">Yes</td> <td data-bbox="1185 936 1339 992">No</td> <td data-bbox="1339 936 1495 992">No</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No
	Method	Airless Spray	Conventional Spray	Brush	Roller										
	Yes	Yes	No	No											
<ul style="list-style-type: none"> Conventional spray: thin to 25-30 seconds DIN 4 cup @25°C depending on spray equipment Also suitable for electrostatic spray, high speed disc or bells and heated airless spray (max. 40°C) 															
Product Notes	<ul style="list-style-type: none"> To remove remaining paint from equipment, flush thoroughly with water, repeatedly if necessary. If required rinse with a cleaning solution for water-based paints, such as 1921 Thinner, or if the paint has dried and is very stubborn to remove, use 1723 Thinner 														
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.														

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