

**FURNACE PAINTS- SPECIAL COATING INSIDE THE BARREL (FS-21111)****Product description:**

FS21111 is a single component coating based on phenolic and epoxy resin. Among the features of this coating, excellent adhesion, good mechanical capabilities such as hardness, excellent gloss, flexibility, excellent gloss, impact ability and color stability, and excellent resistance to various materials can be mentioned.

**Application:**

This coating is for painting the inside of the barrel and packaging cans to resist different materials.

**Technical data:**

Specification	Details	EN Standard	ASTM Standard
Shade / Color	White and colored	EN ISO 11664	D2244
Solid by Volume (%)	60 ± 2	EN ISO 3233	D2697
Solid weight (%)	75 ± 2	EN ISO 3251	D2369
Density / Specific gravity g/cm <sup>3</sup>	1.2 - 1.4kg/lit	EN ISO 2811	D1475 (2025)
Shelf life	6 months	EN ISO 1513	D1849 / D869
Dry Film Thickness (DFT) μm	15 - 25 μ	EN ISO 2808	D1005 / D7091
Wet Film Thickness (WFT) μm	30 - 60 μ	EN ISO 2808	D4414
Theoretical coverage strength	13.3 - 25m <sup>2</sup> /lit	EN ISO 3233	D2697
Flash Point	25°C	EN ISO 2719	D93 (Pensky-Martens)

**Cooking conditions:**

Waiting time before the furnace	Cooking temperature	Cooking time
10-15 minutes	200 - 220°C	30 minutes

If the internal temperature of the oven is not stable, the change of cooking time is under the control of the operator. For continuous systems, the length of the conveyor after leaving the furnace should be at least three meters with a minimum speed.

**Equipment Used:**

AIRLESS SPRAY : Nozzle diameter: 0.013-0.019 inches

Output pressure: minimum 141 times

AIR SPRAY

Nozzle diameter: 1 -1.8 mm - Nozzle pressure: 2-3 times

Brush: : 20-30 μ (for staining) - Roller: : 20-30 μ (for staining)

**Environmental Conditions:**

The surface temperature should be at least 3 degrees higher than the dew point. In hot weather, the temperature of the ingredients before mixing should be 20-25°C. Otherwise, the Pot life will be very short. To ensure hardening, air and surface temperature should be above 10°C. This cover should not be implemented in areas where the weather changes or the wind speed exceeds 7 m/s.

**Surface Preparation:**

- The desired surface should be well clean, dry and free from any pollution. Oil or grease should be washed according to SSPC-SP1 standard.
- In order to prepare the surface, phosphate, chromate methods or the use of wash primer is recommended.

**Method of Applying:**

- All equipment should be cleaned with recommended thinner before use.
- Mix the desired coating with a powerful mixer.
- For application with air spray, 10-15% thinner is recommended and for airless spray, 10-5% thinner is recommended.
- In case of painting, 20% thinner is recommended.
- Each pulse of painting should be applied parallel to each other so that each pulse covers 50% of the painted surface at the right angle.
- To ensure the desired thickness, corners, sharp edges, rivets, and uneven parts should be covered again.

**Safety Tips:**

This coating is flammable and must be away from flame and heat, and the operator is obliged to read and comply with the MSDS of this product, use a special mask and safety gloves during use, and operate in environments with proper ventilation.

**Storage Conditions:**

This product should be stored in a closed space away from direct rays at a temperature of 5-35 degrees.

**Considerations:**

The drying time depends on the film thickness applied, all the data in this catalog are based on the thickness of the dry film in vitro conditions.



**LEGAL NOTES :** The information contained in this Technical Data Sheet is based on laboratory testing and practical experience. Actual performance may vary depending on substrate condition, application method, and environmental conditions. Users should test suitability before large-scale application.

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