

**FURNACE PAINTS- FURNISHED GLOSSY COATING 120 TO 150 C° (RAL-21111)****Product description:**

21111-Ral is a one-component coating based on alkyd amine 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 can be mentioned.

Application: This coating is used to paint various industrial products such as external surfaces of electronic components, tables, chairs, water heaters, gas stoves, car spare parts and other metal parts.

Technical data:

| Specification | Details | EN Standard | ASTM Standard |
|--|-------------------------------|--------------|----------------------|
| Shade / Color | White and colored | EN ISO 11664 | D2244 |
| Solid by Volume (%) | 45 ± 2 | EN ISO 3233 | D2697 |
| Solid weight (%) | 60 ± 2 | EN ISO 3251 | D2369 |
| Density / Specific gravity g/cm ³ | 1 - 1.3 kg/lit | EN ISO 2811 | D1475 (2025) |
| Shelf life | 12 months | EN ISO 1513 | D1849 / D869 |
| Dry Film Thickness (DFT) μm | 15 - 25 μ | EN ISO 2808 | D1005 / D7091 |
| Wet Film Thickness (WFT) μm | 60 - 30 μ | EN ISO 2808 | D4414 |
| Theoretical coverage strength | 16 - 33.5 m ² /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 | 120 -150°C | 20-30 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: 0.9 -1.5 mm - Nozzle pressure: 2-3 times

Brush: : 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.

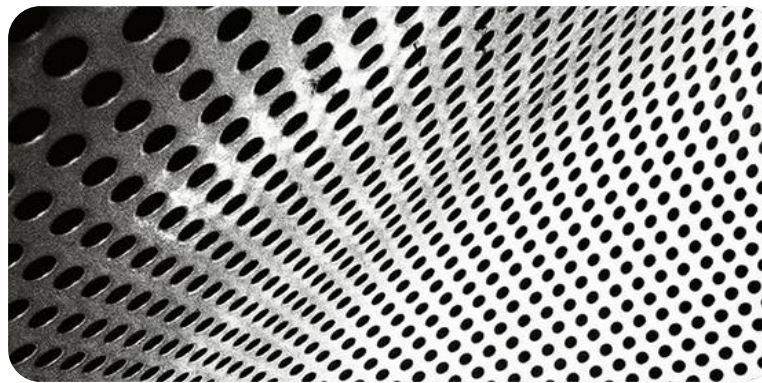
Method of Applying:

- All equipment should be cleaned with recommended thinner before use.
- Mix the desired coating with a strong 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.
- Wash all equipment immediately after use.

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.

Head Office : Building No.15 , Qasimlu Street 40, Shahidan Zargata Quarter 24, Zone 1, Sulaymaniyah 46001, Iraq

Factory : Tanjaro Industrial Area – Sulaymaniyah – Iraq