

## PRODUCT DATA SHEET

# FLAME 82

Enamel resistant to high temperatures

**CHARACTERISTIC** Paint based on silicon resins, resistant to temperatures between 200 ° C and 600 ° C.

**USE** Used for the protection of objects made of different metals (steel, galvanized steel, light alloys) temporary or ongoing exposed to heat, in the area of domestic heating (stoves, fireplaces and their accessories) and automotive (engine, brake systems). It can be applied directly on the metal support.

**PROPERTY OF THE PRODUCT**

	VALUE	METHOD
Application temperature	< +600 ° C	
Flash point	27 ° C	
Solid by volume %	34±2% (aluminum) 65±2% (black)	

**SPECIFICATION DATA**

	VALUE	METHOD
Specific weight	Aluminum: 1000-1100 g/l Black: 1200-1300 g/l;	Internal PF3

**THICKNESS AND YIELD**

	Minimum	Max	Recommended
Thickness of dry film, µm	20	40	30
Thickness of wet film, µm	50	100	75
Theoretical yield, m <sup>2</sup> /l	20	10	13.3
Theoretical yield, m <sup>2</sup> /kg (aluminum)	20	10	13.3
Theoretical yield, m <sup>2</sup> /kg (black)	16	8	10,6

**STORAGE**

The product is stable up to 6 months if stored in its original cans at temperatures between +5 ° C and +30 ° C.

**COLOUR**

Aluminum - Black (upon request).

**PREPARATION OF SURFACE**

The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.

A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.

**STEEL**

Commercial sandblasting, cleaning with Nitro NV 5000 thinner.

**HOT GALVANIZED STEEL**

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then

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proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner. Alternatively, a light silica sandblasting is recommended.

**ALUMINUM AND LIGHT ALLOYS**

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

## TOOLS

Conventional spray.

## APPLICATION

Thinning	5-10% by Diluente Butol
Application condition	+5°C +40°C >3°C at dew point Relative humidity: <70%
Application by conventional spray	Nozzle: 1,6 - 1,8 mm Angle range: 40 - 80° Air pressure: 3,5-4 kg/cm <sup>2</sup>
Thinner for washing	Diluente Nitro NV 5000

## DRYING TIME

DFT 30 micron

The product optimizes its polymerization with the cooking or by putting into operation the structure at a temperature of 180-200°C after about 60 minutes and 250°C after 30 minutes.

## INSTRUCTIONS

The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data intervals between the two phases of the above reported coating system may vary. This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.