

## AMILAC 4010

TYPE	Special Polyester/Melamine resin combinations baking finishing paint.
USES	Finishing enamel and clear for metal substrates where toughness of coating and high resistance to mechanical abrasion is required.
FEATURES	<ol style="list-style-type: none"><li>1. Good adhesion to most substrates that are properly prepared</li><li>2. Tough yet resilient film on proper curing</li><li>3. High gloss retention</li><li>4. Excellent weathering resistance</li></ol>

### APPLICATION SPECIFICATIONS

Methods of application	Manual or auto air spray
Thinner	Amilac Thinner/ Magicron Thinner No.5
Paint dilution	30% ~ 50% (by weight)
Viscosity	15 ~ 25 seconds (NK-2 Cup)
Spray gun nozzle	1.2 ~ 1.5 mm Ø
Spray air pressure	0.3 ~ 0.4 MPa (3 ~ 4 kg/cm <sup>2</sup> )
Setting Duration	5 ~ 10 minutes at room temperature (to prevent bubbling or pinholes)
Curing condition	160°C x 20 minutes
Dry film thickness	25 ± 5 µm

#### Remarks:

1. Stains on application surface such as oil will affect the adhesion, please de-grease the substrates adequately.
2. The wiping solvent may damage the substrate according to the condition of the plastic. Please check carefully before use.
3. Stir paint thoroughly until uniform before using, and ensure paint is stirred continuously even during application
4. The film thickness is very important for the property. It needs to be kept as indicated.
5. The above is only a recommended specs, coater has to do own adjustment and study the best condition to achieve good paint film appearance.



## Film Performance

Paint : Amilac 4010 Black

Materials : Chromated Aluminum

Items	Testing Method	Specifications	Results
Adhesion	Tape adhesion under 100 mesh cut by 1mm	100/100	Passed
Bend test	2mmØ rod and bend at 180°	No peeling of paint	Passed
Impact test	Dupont Test R =1/2", W=9.8N, H= 50cm	No peeling of paint	Passed
Pencil hardness test	Mitsubishi Uni. pencil	2H	Passed
Boiling test	Boiling water × 1 hr immersion	No change in appearance	Passed
Oil resistance test	Castor oil x 60°C x 30minutes	No change in appearance	Passed
Acid test	1N HCl solution spot test x 20°C x 24 hrs	No change in appearance	Passed
Alkaline test	1N NaOH solution spot test x 20°C x 24 hrs	No change in appearance	Passed
Salt spray test	Salt spray chamber (5% NaCl) x 72 hrs	Rusting: Grade 8(ASTM D610) Blistering: Size No.6,Few(ASTM D714)	Passed
Accelerated weathering test	SWOM x 200 hrs	ΔE (color change) < 1.0 Gloss retention(60°) > 90%	Passed

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