



# STOVING ENAMEL PIGMENTED

**Product code: PS3501**

## Composition and Application Field

**EVI Stoving Enamel Pigmented** is based on a special non-drying Resin composition, containing Titanium dioxide and other carefully chosen pigments. The product is specially designed for coating steel substrates that needs to be cured at elevated temperatures. It exhibits very good resistance properties compared to ordinary fast drying enamels. The product cures on a very wide temperature and dwell times making it suitable for mass production of coated products.

Substrates: **Steel furniture, steel frame, steel drum or other metal substrates.**

Area of Use: Interiors and Exteriors.

## Specification

Finish	: Glossy and Smooth.
Color	: White + all colours as per the EVI shade card.
Specific gravity	: 1.0 to 1.2 depending on color
Solids (% by volume)	: 52 ± 2
Diluent	: EVI Stoving Thinner
Flash point	: 29°C

Spread Rate:

While the spread rate is directly dependant on the surface profile and also the type of undulations it has, as a thumb rule EVI Stoving Enamel Pigmented would cover 15 – 17 sq. meters per lit.

Stoving Schedule:

120°C for 25-30 minutes/150°C for 10-15 minutes

: Apply mist coat wet on wet followed by full coat

Recommended DFT : 1 mist coat followed by a good full coat. App 30 - 40 mic.

NOTE: when curing at higher temperature at a shorter dwell time, it is necessary important to make a flash off time of 5 minutes under room temperature for good finishing.

## Surface Preparation

A good surface preparation and following the method statement / recommended system procedure of EVI is an ideal recommendation for the application of EVI Stoving Enamel Pigmented.

For Metals & Steel Surfaces

Achieve a good and clean surface by removing all contaminants by cleaning & drying. Sand surface of any rusts before any applications to be done.

## Application Method

Always ensure adequate ventilation when applying the product. Use goggles, masks and other relevant PPEs' as this product contains

solvent. Avoid high humid conditions i.e., >95% when condensation is likely to interfere and also when the surface temperature is at least 3°C above dew point.

Application: The use of Conventional air spray, air assisted airless spray or airless spray is the recommended application equipment. Brush and roller can be used for touch up only;

Nozzle size: 0.017 - 0.023 inches.

Thin the product according to the application equipment use. The range could be 5 to 15 percent.

Apply the material at no more than 75 microns wet to prevent sag and solvent trapping during stoving.

Caution: Over diluting would result in sag and run downs.

## Paint System

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**Stoving Enamel Pigmented 1 coat of 75 micron WFT**

\*Or as per EVI technical advice

## Storage & Shelf Life

Under dry and cool condition, storage stability can be sound up to 18 months in original sealed containers.

## Handling

Disposal: As per the guidance and legislations of the local Authority e.g., by controlled landfill. In case of doubt, consult local authority. Do not empty into drains, sewers or other water courses.

Flash Point: 29°C and contains aromatic hydrocarbons.

Caution: It is strongly advised not to keep open half used drums as it forms a skin on the top layer.

## Safety Precaution

Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use a barrier cream. Other industrial practices are applicable. Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapour or spray. MSDS is available on request for the safe handling of this product.

## FIRST AID

Eyes: In the event of accidental splashes, flush eyes with warm water immediately and obtain medical advice.

Skin: Wash skin thoroughly with soap and water or approved Industrial cleaner. DO NOT USE solvent or thinners.

Inhalation: Remove to fresh air, loosen collar and keep patient rested.

Ingestion: In case of accidental ingestion DO NOT INDUCE VOMITING. Obtain immediate medical attention.