

Technical Data Sheet

Indostov 1069

Acrylic High Glossy Stoving Finish

Product Description

Single component Acrylic resin based amino cured High Performance finish to provide excellent Gloss and Colour retention. The product is specially designed to meet the harsh test specifications of the two/ four wheeler automotive industry including color retention, gasoline resistance and scratch resistance.

Recommended Use

This product is a balanced formula blended with top quality resins, selective additives and highly durable pigments which impart its exceptional color retention, high gloss and smooth finish coupled with film flexibility, hardness and solvent resistance. An ideal finish over primed surface in OEM industries for OEM components and for automobile industries like two and four wheelers, Electric Vehicles and for other sheet Metal fabrication industries.

Physical Data

Colour	: Range of Customized Shades
Finish	: High Glossy (90+ GU at 60° angle)
Stoving Schedule	: 135°C±5°C for 30 mins
Supply Weight (Kg/ Ltr)	: 1.00±0.05
Flash Point	: 26° C
Supply Viscosity (at 30°C temperature)	: 70 ± 10 Seconds @ F-4 Cup
Shelf Life	: 6 months

Film Thickness

Recommended film thickness per coat

Dry Film Thickness	: 30-40μ in single coat
Wet Film Thickness	: 75-100μ in single coat
Theoretical Coverage Rate	: 12.50 sq.mt / lit at recommended DFT of 30μ

Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

Automotive System: Indostov 1069 stoving can either be directly sprayed over phosphate treated steel or ED coated steel or can also be sprayed over stoving primer coated substance. Highly recommended as final coat in wet-on-wet electrostatic spray coating system.

Primed Surface: Indostov 1069 should be applied over anti corrosive primed surface. For final smooth finish, proper sanding of already coated primer is recommended. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Application Data

Application Method	: Electrostatic or Conventional Spray/ Pressure Feed
Application Viscosity	: 22 ± 02 Seconds @ F-4 Cup at 30°C
Thinner and Cleaner	: Indokote Thinner (IK.1707)
Inter Coat Time	: 05–10 Minutes (depending on booth temperature)
Flash Off Time	: 10–15 Minutes (depending on booth temperature)
Recommended Booth Conditions	: Temperature: 25–30°C, Relative Humidity: 55–70 %

Working Precautions: Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

Maintenance: Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Product Characteristics

Cross Hatch (1mm squares)	: 100/100
Gasoline Resistance (After 12 Hours of Stoving)	: Upto 8 Hours
Pencil Hardness	: Passes H Grade
Salt Spray	: Passes 96 Hours
Flexibility	: Passes Conical Mandrel
MEK Test	: Passes 10 rubs

Product Features

The gloss level and surface finish are dependent on paint application method. Whenever possible application should be done with one method only. The best results in terms of gloss and appearance will always be obtained by spray application.

This product must only be thinned using the recommended thinner. The use of alternative thinners, might contains alcohols, can severely affect the curing mechanism of the coating. Indostov 1069 should be applied at controlled environment of paint shop and at least 3°C temperatures above dew point.

It may be necessary to apply multiple coats to achieve the total specified system dry film thickness. The ability to apply Indostov 1069 in one coat will be affected by the temperature of the substrate. At higher steel temperatures, lower film builds and thin coats are likely to be achieved.

Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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