



Shenzhen Doern Chemical Co.Ltd

The specification of operation about special paint

NO.1.Construction and operation

The environment temperature of construction should not be over 35°C. When the temperature is high, yield will be declined. Before construction, please keep standing for 3min after mixing the raw material for 20min. After, use alcohol or a small amount of mixed pure water to mix at a proportion (volume ratio) of 1:0.6 with raw material and alcohol, then use coating cup No.4 to test the viscosity. The initial test can be started from the 18th second. When the temperature is 25°C, viscosity can be reduced by adding solvent. If the environment temperature is high or low, viscosity should be increased or reduced properly. The general corresponding relations can refer below:

Environment temperature	15	25	30	40
Viscosity (No.4 paint cup)	25 (85.2 mm ² /s)	18 (45.4 mm ² /s)	16 (32.46mm ² /s)	14 (19.48 mm ² /s)

As this variety is highly solid and lowly adhesive, the applicable viscosity can be used in the range of second 13 to second 30. After mixing, please filter for 1-2 times with 300 meshes. It's better to use double layer when filtering. In the process of circulating, the flowing position may be splashed. It's better to remove big bubbles by filtering. It's better to use the membrane pump that is greater than 1cm to reduce mechanical bubbles. Keep not less than 2/3 of paint being circulated in the material pool and upper-end material pool.

No.2.Baking temperature, settings for reference

Temperature zone	Stage I	Stage II	Stage III	Stage IV	Stage V
	Closed in summer	Closed in summer	60	80	150
Air volume	No	No or breeze	Breeze	Huge air volume	Breeze

No.3.Common problems

1.How to calculate the cost of materials?

Coated pipe cost depends on the viscosity which can construction finally, the solid content of raw material and yield. In general, the lower viscosity, the saver cost, but to meet haze, and constructi on performance of the coating itself.

2. Will the waterborne materials be off powder?

Don't worry about long-term reliability of the weather resistance, adhesion of this material after full baking

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