

SINT 742-M

ALKYD 1K MATT

1K flat alkyd topcoat with direct adhesion to iron, steel and aluminum, ideal for cost-effective industrial projects.

PRODUCTS

Toners	DISOLAC	5-10 (w)
Binder	SINT 742-M	95-90 (w)
Reducer	SYNTHETIC SOLV 5 – STANDARD	0-30% (v)
	SYNTHETIC SOLV 3 – SLOW	0-30% (v)
	R225 – exempt VOC & 0 HAPS reducer	0-30% (v)

CHARACTERISTICS OF SINT 742-M

Appearance	matt	
Gloss	5-10 at 60°	
Specific weight	12.5 lb/gal @68°F	
Solid content (binder)	65-70 % (weight)	40-45 % (volume)
Solid content RFU (without reducer)	61-67 % (weight)	41-45 % (volume)
Dry film thickness	1.8-2 mils (2 coats)	
Theoretical coverage per Gallon of mixing without dilution @ 1 mil DFT	670-730 ft²	

VOC

% reducer	VOC REGULATORY Synt. Solv.		VOC ACTUAL Synt. Solv.		VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L
0	4,1	491,3	4,1	491,3	4,1	491,3	4,1	491,3
10	4,4	527,2	4,4	527,2	4,1	491,3	3,8	455,3
20	4,7	562,5	4,7	562,5	4,1	491,3	3,4	407,4
30	4,9	588,8	4,9	588,8	4,1	491,3	3,2	383,4

*VOC in the table is an average, for specific colors check on iCrom






SUSTRATE AND PREPARATION OF THE SURFACE

	CLEAN	SANDED	FINAL CLEAN
Old paint	DA93	P320/400	DA93
Steel	DA93	Optional (P320/400)	DA93
Galvanized steel	DA93	Optional (P320/400)	DA93
Aluminum	DA93	Optional (P320/400)	DA93

For other substates consult with the Technical Assistance (SAT).




APPLICATION

	PIECE		BIG SURFACE	
T(°F)	Hardener	Reducer	Hardener	Reducer
64-77	---	SYNTHETIC SOLV 5 / R225	---	SYNTHETIC SOLV 3 / R225
77-90	---	SYNTHETIC SOLV 5 / R225	---	SYNTHETIC SOLV 3 / R225
>90	---	SYNTHETIC SOLV 3 / R225	---	SYNTHETIC SOLV 3 / R225

	Application	% Reducer (Vol.)	Viscosity – 68°F (Ford Cup 4)	Pressure (psi)	Product pressure (psi)	Nozzle (mm)	Num. Of coats x dry mil	Flash off (min)
	Gravity feed spray gun	0-10%	20-23"	29-43	---	1.3-1.5	2x1	10' 68°F
	Airless	20-30%	20-22"	--	1450- 1900	9.4-11.6	2x1.4	15' 68°F
	Air assisted airless	15-25%	20-22"	13-20	1015- 1300	9.4-11.4	2x1.4	15' 68°F
	Pot life (68°F)	8h	---	---	---	---	---	---

If the application requires the use of an additive, it should be taken into account in the addition of reducer.

DRYING

 TEMPERATURE	 DUST DRY	 TO TOUCH	DRY THROUGH
68° F (air dry)	10 min	2h – 2h 30 min	24h
86°F	5-8 min	40'	24h

The product reaches its maximum performance after 15 days of drying in the air (ambient temperature 64-72°F) or in a shorter time at higher temperature.
The drying of dark black colors may be affected. In this case it is necessary to add DRYING AGENT before application.

ADDITIONAL ADDITIVES FOR SPECIAL USES

SITUATION	ADDITIVE	DESCRIPTION	EFFECT
Craters	Anti-crater additive	Film protection against external contaminations.	Anti-crater, film protection.
Outdoor resistance / UV filters	UV additive	Film protection against UV rays.	Increases film durability.
Sensitivity to spray / Too fast film drying	Flow additive	Improves the applicability, for example in wide superficies or drying weathers.	Increases open film time.
Resistivity adjustment	Electrostatic additive	It's used to adjust the coating resistivity according to the equipment used.	Decreases coating resistivity.
Slip / cleaning	Ultraclean additive	Increases the slip power of the film and facilitate the cleanliness.	More slip and easy to clean.
Insufficient drying	Drying agent	Accelerating agent for single-component solvent-based synthetic systems.	Accelerated drying.

For use and instructions of the additives consult the technical data sheet of each product.

REMARKS

- Recommended to be used in ventilated spray booth at 68°F.

EQUIPMENT CLEANING

- Use a cleaning thinner before the pot life has expired.

SAFETY

- Follow instructions on product label.
- For more information check the Safety Data Sheet.
- Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

- Store the product in a ventilated place far from direct exposure to sunlight.
- Keep between 41 and 86°F.

SHELF LIFE

- One year in unopened original packaging.

ANNEX A

Brightness table (60° angle)

SINT 742-G	SINT 742-M	GLOSS (^60°)	CATEGORY
100	0	>90	HIGH GLOSS
60	40	65-90	GLOSS
50	50	50-65	SEMI-GLOSS
40	60	40-50	SEMI-GLOSS
30	70	20-40	SATIN
20	80	10-20	FLAT
0	100	<10	FLAT

The degree of gloss depends on the color applied, dry thickness, substrate, drying temperature...

These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.

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