

ALPOCRYL EMAILACK LE 5393

Description

Product Description		Particularly fast drying 2C enamel varnish with very good resistance to weather, chemicals and mechanical abrasion.
Raw Material Base / Binder Type / Active Agent		Polyurethane resin
Application		High-quality top-coat and base-coat for - metal - plastics (enquiry at varnish manufacturer) - wood, MDF, chipboard etc. for furniture manufacturing
Certificates / Label		The chemical resistance according to DIN 68861, 1B, is met. The varnish is hardly flammable to DIN EN 13501-1
Colours		RAL and NCS colour chart.
Gloss Level		Satin gloss (30-40 gloss units at 60°)
Hardener	Description	UNIPUR HÄRTER 279/H901
	Product	H90100 - UNIPUR HÄRTER 279/H901
Packaging	Paint	1 L, 5 L, 10 L
	Hardener	0.5 L, 1 L, 2.5 L, 5 L

Technical Data

Technical Data	Product		Hardener		Mixed Product	
Material Safety Data Sheet	539300		H90100			
Mixing Ratio	10		1		10 : 1	
Density (20°C)	1.185	g/cm ³	0.990	g/cm ³	1.167	g/cm ³
Solids Content	52	± 1 w/w-%	45	± 1 w/w-%	51	± 1 w/w-%
Organic Solvent Content	49	± 1 w/w-%	55	± 1 w/w-%	50	± 1 w/w-%
VOC Content (EU)	575	g/L	545	g/L	572	g/L
Shelf Life at 20°C in Unopened Original Containers	12	Months	6	Months		
Theoretical Coverage	120 g/m ² ? 8 m ² /kg					
The data applies to ALPOCRYL LE WEISS 81 (white). Values can vary depending on color or gloss level.						

Safety Data

Refer to the following safety data sheets as well as the instructions on the label	
Product	539300 - ALPOCRYL EMAILACK LE
Hardener	H90100 - UNIPUR HÄRTER 279/H901
Thinner	V13000 - VERDÜNNER V130 V09500 - VERDÜNNER V095 V56000 - VERDÜNNER V560

Application advice

Aluminium and galvanized substrates

Product	Data Sheet	Applied Quantity / Layer Thickness
Only on demand.		

Steel

Product	Data Sheet	Applied Quantity / Layer Thickness
Primer:	ALPOTECT PHOSPHATGRUND 510	FC5100
Recoating:	ALPOCRYL EMAILACK LE 5393	5393
		80-100 g/m ²
		100-150 g/m ²

Chipboards and MDF-panels or wood veneered surfaces

Product	Data Sheet	Applied Quantity / Layer Thickness
(Pre-)priming (edges resp. cut-outs):	ALPOLAN UNIVERSALGRUND 242	5408
Primer:	RAPIFILL 1080	1080
or	ALPOLAN UNIVERSALGRUND 242	
Intermediate sanding:	Grain 220-240	
Recoating:	ALPOCRYL EMAILACK LE 5393	5393
		100-120 g/m ²
		1-2x 150-200 g/m ² wet
		100-120 g/m ²
		100-150 g/m ²

Foil-coated chipboards

Product	Data Sheet	Applied Quantity / Layer Thickness
Recoating:	ALPOCRYL EMAILACK LE 5393	5393
		100-150 g/m ²

Plastics (PVC-profiles)

Product	Data Sheet	Applied Quantity / Layer Thickness
Only on demand		

Old coatings (solvent-resistant)

Product	Data Sheet	Applied Quantity / Layer Thickness
Recoating:	ALPOCRYL EMAILACK LE 5393	5393
		100-150 g/m ² wet

For further application proposals please ask our representative.

Preparation

	Substrate	Every substrate must be well-cleaned, dry and free from grease and oil.
	Aluminium	Clean, then finely sand or pad rub (Scotch Britecoarse) and clean again or use a chemical treatment (chromate).
	Aluminium profile	Clean, sand well or dust blast and clean or use a chemical treatment (chromate).
	ALPOLAN SPRITZSPACHTEL 1090	Sand with 220-240 grit, remove dust
	SUPREMO FÜLLGRUND 3910	Sand with 220-240 grit, remove dust.
	Foil-coated chipboards	Clean, sand with 360 grit
	Plastics (PVC-profiles)	Take note of our "Instructions for the painting of plastic windowprofiles with ALPOCRYL EMAILACK LE 5393". Technichal instruction sheet VTM 2519
	Old coatings	Sand off, clean, prime as necessary

Processing

	Preventative Measures	We recommend wearing personal protective clothing, even in cases where no local regulations are in force. CH: The precautions prescribed by SUVA with respect to hygiene and equipment must be observed.
	Stir	Stir product well before use.
	Mixing Requirements	10:1 (varnish to hardener, by volume)
	Pot Life	8 hours, depending on colour
	Dilution	Dilute to application viscosity using VERDÜNNER V095 (slow) or VERDÜNNER V130 (fast) according to the table mentioned below. Always dilute with VERDÜNNER V560 when used as a base coat!
	Thinner	V13000 - VERDÜNNER V130 V09500 - VERDÜNNER V095 V56000 - VERDÜNNER V560
	Brush	Not recommended
	Roller	Not recommended
	Additional Remarks	<u>Note:</u> We recommend a recoating with ALPOCRYL KLARLACK 1230 for white or pastel-coloured applications on highly stressed areas, such as body panels, work surfaces etc. - in order to improve the "ring strength" (metal abrasion). Mixing ratio: Varnish:Hardener: 5:1 by volume for special applications, eg. for certain plastics. Only suitable for indoor applications on wooden substrates.
	Evaporation	Prior to drying at temperatures over 40°C, an evaporation time of 15 minutes must be observed.

Application

		Viscosity	Dilution	Nozzle	Pressure	Spray Cycles
	Gravity Feed Gun	18-22" DIN 4 mm	25-30 %	1.4-1.8 mm	2-3 bar	2
	Suction Cup Gun	18-22" DIN 4 mm	25-30%	1.4-1.8 mm	2-3 bar	2
	Airless-(Airmix) Spray Application	22-25" DIN 4 mm	25%	0.15-0.23 mm	60-80 bar (material pressure). Atomising air pressure 1.0-1.5 bar	1-2

Drying Time

	Drying Time	At 23 °C and 65% rel. humidity			
		Dust dry after:	10		minutes
		Touch dry after:	30		minutes
		Sandable after:	60		minutes
		Recoat after:	2 to max. 48		hours
		Fully dry after:			
	Remarks	At 80 °C completely dry after: 30 minutes At 100 °C completely dry after: 15 minutes			

Important Remarks

Specific Restrictions	Max. 80% relative humidity
Minimum Application- and Drying Temperature	15 °C The temperature of the floor, air and material must not be below this temperature.
Coating Removal	Strip or sandblast
Equipment Cleaning	Immediately after use with VERDÜNNER V095 (thinner) or UNIVERSAL-REINIGER U V860 (universal cleaner)

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