



SWARCO VICAS SA

Anticorrosive and decorative paints



ALKYD MELAMINE SYSTEM

SWARCO | First in Traffic Solutions.

ALKYD MELAMINE SYSTEM

1 Field of use. Characteristics

ALKYD MELAMINE SYSTEM can be used for:

✓ anticorrosive protection and decoration of steel surfaces, used in indoor and outdoor spaces, located in environments with corrosivity class C1 ÷ C3 (from C1 - very low corrosion to C3 - medium corrosion), including machinery and equipment;

Main features of ALKYD MELAMINE SYSTEM:

- ✓ good adhesion to support, hardness, fastness to weather, impact resistance;
- ✓ fast drying;
- ✓ resistance to neutral saline fog, mineral oil.

2 System compoence

Product	Ferrous metal surfaces
Grund Seria 5068	2 layers x 60-70 µm wet
Vopsea Seria 5068	2 layers x 60-70 µm wet
<i>or</i>	
Grund Seria 5068	2 layers x 60-70 µm wet
Emabrill	2 layers x 60-70 µm wet
<i>or</i>	
Grund Seria 5068	2 layers x 60-70 µm wet
Autovirom	2 layers x 60-70 µm wet

3 Technical data

Technical characteristic	Acceptance criteria			
	Grund Seria 5068	Vopsea Seria 5068	Emabrill	Autovirom
Color	gray, red oxide	On request, according to RAL card		
Solid content, %,minimum	60	55	45	45
Density, g/cm ³	1.1 -1.5		0.9 -1.25	
Drying time, 23±2°C, hours:				
- touch	maximum 1	2-3	maximum 3-4	maximum 3-4
- final	maximum 4	maximum 8	maximum 14	maximum 14
Drying time 80±2°C, hours	maxim 1			
Application conditions	Ambience temperature:10÷35°C/ Surface temperature:10÷40°C/ Relative humidity of the air max. 70%			
Spreading rate	8-10 m ² /kg and layer		10-12 m ² /kg and layer	

4 Application methode

Methode	Grund Seria 5068	Vopsea Seria 5068	Emabrill	Autovirom
		DILUTION (with Autodil).		
○ AIRLESS: - nozzle diameter: 0.33-0.43 mm - pressure: 120-160 bar - viscosity: 35-50 sec. Ø 4 mm ○ Brush ○ - viscosity: 35-50 sec. Ø 4 mm	maximum 5%			
○ Compressed air gun: - nozzle diameter:1.2-1.8 mm - pressure: 3-4 bar - viscosity: 25-30 sec. Ø 4 mm	maximum 15%			

Homogenise the products by mixing in the original containers prior to the processing.

The successive product layers (Grund Seria 5068/Vopsea Seria 5068/Emabrill/Autovirom) are to be applied "wet on wet" after solvent evaporation of previous layer (aprox. 15 minutes).

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5 Preparing the surfaces

The surface must be dry, clean and free of grease, oil or other impurities.

Repainting old coatings	Before applying the products to a surface where another layer of paint has been applied, compatibility with the previous layer must be checked. Applying the product to old paint layers should be done after mechanical roughening of the surface with abrasive discs.
Ferrous metal surfaces	Preparation up to grade Sa 2 ½ according to SR EN ISO 8504-2 (for surfaces prepared by sandblasting). Prepare to Mechanical Prepare 3 according to SR EN ISO 8504-3 (for manual or mechanical cleaning). Grund Seria 5068 must be applied within 4 hours from blasting / mechanical preparation. Application of Vopsea Seria 5068/EmabrilIII/Autovirom on metal surfaces must be done 24 hours after applying Grund Seria 5068.

NOTE: All application instructions, information regarding the field of use as well as the performance data in this Technical Data Sheet, are general in nature, therefore we recommend testing the products under the specific usage scope and user's own application technology. Please consult the manufacturer for additional clarifications. The final decision on the desirability for using the products is the exclusive responsibility of the user.