

PUFFIN HELMET BASECOAT ACRYLIC ENAMEL

Is one component thermoplastic acrylic coating with high gloss finishing. Can be use as base coat for helmet or otomotive. Suitable for carbon steel, iron, aluminum, galvanized steel, concrete, stainless steel, stone, plastic ABS and wooden substrates

1. Properties

| | |
|--|--------------------------------|
| COLOR | Available |
| GLOSS LEVEL | Gloss (70-85) |
| FILM THICKNESS, DRY (μm) | 30-40 |
| FILM THICKNESS, WET (μm) | 90-120 |
| THEORETICAL SPREADING RATE (M^2/L) | 11.5-8.5 |
| SOLIDS (VOL %) | 34 \pm 2 |
| DENSITY (g/cm^3) | 1.1 |
| FLASH POINT | 25°C \pm 2% |
| PRACTICAL COVERAGE | ALLOW APPROPRIATE LOSS FACTORS |

2. Characteristics

1) Recommended

Base coat for helmet / otomotive. Can be apply to steel structure, wooden, stainless steel, iron, aluminium, galvanized steel, plastic ABS, stone and concrete.

3. Usage

1) Surface preparation:

For lasting adhesion to the subsequent product, all surfaces must be clean, dry and free from any contamination. Oil or grease should be removed

2) Substrate minimum recommended :

The surface should be assessed and treated in accordance with substrate minimum recommend:

For wooden substrate: Clean and dry surface. Surface contamination must be removed by detergents and fresh water cleaning.

For Aluminum: Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.

Galvanized steel: the surface must be clean, dry and appear with a rough and dull profile sweep blasting.

For Galvanized steel: Sweep blast-cleaning using non-metallic abrasive leaving a clean rough and even pattern

For Stainless steel: Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile

For carbon steel substrate: Sa 2½ (ISO 8501-1)

For stone: Clean, dry and free from any contamination.

For ABS Plastic: Clean, dry and free from any contamination.

For concrete: Min Age of concrete 1 months with PH<9, moisture content < 17 %. Clean, dry and free from any contamination

For coated substrate: clean, dry, free from any contaminations and undamaged compatibility coatings



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3) Application:

Airless spray, airspray, brush, roller

Spray: Pressure at nozzle (minimum): 150 bar/2100 psi

Nozzle tip (inch/1000): 18~21

Filter Check to ensure that filters are clean.

Brush: For stripe coating and small areas

Care must be taken to achieve the specified dry film thickness

Roller: For small areas. Not recommended for first primer coat. Care must be taken to achieve the specified dry film thickness.

4) Dilution

Puffin thinner HG

5) Drying and Curing time:

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The shortest time allowed before the next coat can be applied.

Surface (touch)Dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

| SUBTRATE TEMPERATURE (°C) | 5 | 10 | 23 | 40 |
|-----------------------------------|----|----|----|----|
| SURFACE DRY (hours) | 10 | 6 | 3 | 1 |
| DRY ON WALK (hours) | 20 | 10 | 5 | 3 |
| Dry to over coat, minimum (hours) | 12 | 6 | 3 | 1 |

6) Heat resistance temperature :
Dry :atmospheric

Continuous Peak
120°C 140°C

Peak temperature

Duration max. 1 hour.

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

7) Product compatibility:

Depends on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product.

Some examples are shown below.

Previous coat:
Subsequent coat:

Epoxy, Vinyl, Acrylic
Acrylic, PU

4. Precaution

1) Ensure to clean the surface before application.

2) Health and safety :

Please observe the precautionary notices displayed on the container.

Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

3) Storage:

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care. Shelf life at 23 °C: 48Month(s)

5. Packing:

20 L