

# MACHINE HEAD CLEAR VARNISH

## Product Scope

Buxly Stoving Machine Head Clear Varnish is an unmatched product with excellent gloss, smooth finish, toughness, elasticity and resistance to weathering and gasoline. It is designed to be used on all kinds of substrates as a top coat, where scratch resistance, solvent resistance, gloss retention and hardness are primary requisites.

## Product Application

Stoving Machine Head Clear Varnish is based on alkyl amino type of medium incorporated resins with special additives to impart its excellent flow, gloss, hardness, flexibility and resistance to gasoline.

### Technical Information

Type of Product	Single Pack-Stoving
Specific Gravity	0.98-1.0
Grind	Clear
Pack Viscosity	45-55 Seconds @ F-4 Cup @ 300 C
Color	Water White-Pale Yellow
Volume Solids	51 ± 2%
Stoving Schedule	140 ± 50°C @ 29-31 Minutes (PMT)
Flash Point	230°C
Finish	Full Gloss
Cross Hatch	97/100-100/100
Gasoline Resistance (After 3 hours of baking)	7 Hours Full System
Pencil Hardness	Passes H Grade (Full System)
Salt Spray Test	96 Hours (Full System)
Flexibility	Passes 1/8 Conical Mandrel (Full System)
MEK Test	Passes 20 Rubs (Full System)

### Application Information

Application Method	Conventional, Pressure Feed, Electrostatic Spray
Application Viscosity	20-22 Sec @ F-4 @ 250 C
Solvent/Cleaner	Buxly's Stoving Thinner
Number of Coats	2 Coats
Dry Film Thickness	40-45µm
Inter-Coat Time	05-10 Minutes (Depending On Booth Temperature)
Flash-off Time	05-15 Minutes (Depending On Booth Temperature)
Recommended	Temperature: 25-30°C Relative Humidity: 55-70%