

STOVING HI-SPARKLES

Product Scope

Buxly Stoving High Sparkles is designed for two wheeler industry to be used as primer coat under flamboyant finishes to give the desired flamboyant look. Buxly Stoving High Sparkles can either be directly sprayed over phosphate treated steel or can also be sprayed over primer coated substance.

Product Application

Buxly Stoving High Sparkles is a blend of premium grade aluminum pigments and alkyd/amino type of medium.

Technical Information

Type of Product	Single Pack-toving
Specific Gravity	1.02-1.06
Grind	6 BF
Pack Viscosity	45-55 Seconds @ F-4 Cup @ 30°C
Color	Metallic Aluminum
Stoving Schedule	140 ± 5°C @ 29-31 Minutes (PMT)
Flash Point	23°C
Finish	Full Gloss (Full System)
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 Conical Mandrel (Full System)
MEK Test	Passes 10 Rubs (Full System)

Application Information

Application Method	Conventional, Pressure Feed, Electrostatic Spray
Spray Viscosity	18-20 Sec @ F-4 @ 25°C
Solvent/Cleaner	Buxly's Stoving Thinner
Number of Coats	2 Coats
Dry Film Thickness	35-40 µm
Inter-Coat Time	05-10 Minutes (depending on booth temperature)
Flash-Off Time	10-15 Minutes (depending on booth temperature)
Recommended Booth Conditions	Temperature: 25-30°C Relative Humidity: 55-70 %