

STOVING ENAMEL

Product Scope

Stoving Enamel is designed to give excellent finish, gloss and color retention properties to the substrate. The product is specially designed to meet the harsh test specifications of the two wheeler automotive industry including color retention, gasoline resistance and scratch resistance.

Product Application

Stoving Enamel is a balanced formula blended with top quality resins, selective additives and highly durable pigments which impart its exceptional color retention, high gloss and smooth finish coupled with film flexibility, hardness and solvent resistance.

Technical Information

Type of Product	Single Pack-Stoving
Specific Gravity	0.96–1.01
Grind	>7.5
Pack Viscosity	50–60 Seconds @ F-4 Cup @ 30°C
Gloss	>90 % @ 60° SHEEN Head @ 35–40 μm
Color	Multi Ranged
Stoving Schedule	135 ± 5°C @ 29–31 Minutes (PMT)
Flash Point	23°C
Finish	Full Gloss
Cross Hatch	97/100–100/100
Gasoline Resistance (After 3 hours of baking)	7 Hours
Pencil Hardness	Passes H Grade
Salt Spray Test	96 Hours
Flexibility	Passes Conical Mandrel
MEK Test	Passes 10 Rubs

Application Information

Application Method	Conventional, Pressure Feed, Electrostatic Spray
Spray Viscosity	22–24 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 %