

# Data sheet



# ROKOPUR INDUSTRY RK 406

## Characteristics:

Dispersion of pigments and extenders in a solution of special acrylicurethane resins in organic solvents with additives.

## Application:

This self-priming acrylicurethane enamel Rokopur Industry RK 406 is ideal for steel and galvanized structures top coats. Above all, it can be advantageously used for coating of living cabins, material containers, shelves, etc. To be applied directly on galvanized iron. Its hardening rate as well as hiding power and adhesion are excellent.

## Technical data:

### **Character film thickness:**

Shade	according to choice (RAL, ČSN, pattern)
Gloss degree	30-40%
Hiding power	1 – 2
Erichsen cupping test	min. 6 mm ( ČSN ISO 1520)
Hardness	98 s ( ČSN ISO 1522 )

### **Paint without cure (A) :**

Viscosity delivered	thixotrop (F4/20°C acc.to ČSN 673013)
Total solids	min.61 weight % (acc. to color shade)
Density	1,33 g/cm <sup>3</sup>
Inflammation point	>23 °C
Shelf life	12 months in closed can at +5 up to +30 °C

### **Paint with cure (A+B):**

Total solids	min.59 weight % (acc. to color shade)
Volume shrinkage	41 %
Density	1,3 g/cm <sup>3</sup>
TOC content	288 gC/1 kg
VOC content	380g/ kg
TOC content in 1 µm.d.c..t.	0,901 gC/µm.d.c.t/m <sup>2</sup>
TOC content in 60 µm.d.c..t.	54,1 gC/m <sup>2</sup>
Spreading rate	5,2 m <sup>2</sup> /kg (at 60 µm dry coat thickness)

## Application:

With spray gun, airless or by brush.

The temperature should not be lower than + 15 °C, the air humidity should not be higher than 70 %.

## Hardening:

Rokopur Industry tužidlo RK 506 hardening agent (10:1 by weight, 7,4:1 by volume)

( Note.: The volume mixing ratio is indicated only approximately, due to different specific gravity of colour shades)

## Pot life:

Min. 12 h at 20 °C

## Thinning:

When applied airless, for the recommended viscosity of approx.. 60 s (4 mm DIN 53211) at 20 °C, approx. 5 % Rokopur ředidlo RK 010 thinner are to be added ( in winter Rokoředidlo C 6000/0000 ).

## Drying:

Air-drying:

Dust-free - degree 1	20 min (at 20 °C)
Dry to handle - degree 4	after 3 hours

Oven drying:

If accelerated drying process (by circulating air) is used, following drying times (the air blasting time of 15-20 min is to be kept in any case!) can be achieved:

40 min at 80 °C or
30 min at 100 °C

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### Standard paint application galvanized iron :

- primary surface treatment – cleaning, degreasing
- 1-2x crosswise coating with Rokopur Industry RK 406 (optimum thickness of one paint coat 60-80 µm, recoating intervals should be 2-4 h , if the application of the 2nd layer is into the 1st wet layer, the time period of recoating interval can be shorter)

### Note:

To increase of anticorrosive resistance of steel structure is suited to apply primer (e.g. Rokoprime EP S 2300) and the paint Rokopur Industry RK 406 used as a topcoat layer.

In the case of very high application temperatures is suited to use a slower thinner e.g. Rokoředidlo 150

Spraying application of metallic colors (for example RAL 9006, 9007) must follow the same application conditions (thickness, dilution, pressure, type of nozzle, etc.). Any deviation from the standard application method causes a change and appearance of color shade. Application by roller painting, or by brushing is not suitable for these color shades.

### Notice:

Due to the large amount of color shades produced, above mentioned technical values are stated as an average of color shades of paint. All data presented in this data sheet are of a recommending nature only. They are based on our best knowledge as well as on a thorough research in accordance with the up-to-date state of technology. These data cannot be interpreted as legal binding. In addition to that, see our Terms of trade.

Safety data sheets in accordance with 91/155/EWG on request.

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