



## TWO COMPONENT OVEN VARNISH

# THERMODUR 600-ASS HSR

- High gloss level
- High scratch resistance
- No adhesion between sealing cords
- No fumes at the first heating

High-temperature resistant 2-component oven paint, which is characterised by its high gloss level, easy cleaning and high surface hardness at temperatures up to 350 °C. Thermodur 600-ASS HSR has a low VOC content – this makes a positive contribution to the environment.

## APPLICATION

PROCESSING	NOZZLE TYPE	PRESSURE
Air syringe	1,5–1,8 mm	2,5–3,5 bar
Airless	0,28–0,33 mm	70–100 bar

# THERMODUR 600-ASS HSR

## APPLICATION:

### Application:

spraying, air-atomisation, electro-static, airless

### Application instructions:

No processing below 10°C!

### Delivered viscosity:

DIN 53211 4 mm, 40–45 sec.

### Mixing ratio:

10 parts by weight      Thermodur 600-HSR  
1 part by weight        Hardener thinner HSR

### Layer thickness:

approx. 20 µm DFT (minimum 10 µm DFT, maximum 50 µm DFT)

### Thinner:

87052 or 200 – use thinner 87052 for dilution and for cleaning the tools.

### Drying:

Dependent on environmental conditions at 20°C and 50 % rel. humidity dry to touch after approx. 20 min.  
Forced drying – possible at 40°C approx. 20 min  
60°C approx. 15 min  
Repair of mechanical damages with touch-up pen.

## DRYING TIME

DRYING	TIME
Forced drying	20 min./40°C 15 min./60°C
Air drying	40 min./20°C

<b>Shelf life:</b>	at least 12 months
<b>Solids content:</b>	EN ISO 3251 60 +/- 3 % in mixture e.g. black
<b>Volume-solids content:</b>	calculated 48 +/- 3 % in mixture e.g. black
<b>Specific gravity:</b>	EN ISO 2811-2 – 1,13 +/- 0,05 g/ml/20°C in mixture e.g. black
<b>Theoretical spread rate:</b>	17 m <sup>2</sup> /kg with 25 microns DFT

Solids content, volume, specific weight and theoretical consumption depend on the colour.

## TECHNICAL DATA

<b>Colours:</b>	red, blue, brown, black, anthracite, silver-grey, cast grey, etc. (behold color card)
<b>Gloss degree:</b>	glossy
<b>Substrate:</b>	steel sheet: sandblasted; sand blasting – SA 2,5 according ISO 8501-1 cast steel: sand blasting – SA 2,5 according ISO 8501-1 Ra value = 3–5 µm and Rz value = 20–30 µm according DIN EN ISO 4287; Do not use chemically treated sheets;



This data is based on experience, for its completeness we assume no liability. As we take no influence on the processing, it lies within the obligation of the customer to test, whether it is suitable for the intended purpose, before using the product. Any change in the processing procedure, the environmental conditions or the failure to comply with instructions may unfavourably influence the result. Images used under license from Shutterstock.com and Videa - Video produkcija d.o.o.