

# GP STOVE COAT 334

## SPECIAL POLYMER STOVING TOP COAT

### == Description

Special polymer melamine amino resin based thermosetting topcoat.

### == Recommended Use

This is a stoving finish coat. This is an ideal protective finish for application on M.S. metal surface for OEM industries allowing faster handling of coated articles.

### == Physical Data

COLOUR	: Assorted
FINISH	: Glossy /semi Glossy /Matt
SOLIDS BY VOLUME	: 35 ± 2% (Depends on shade)
THEORETICAL SPREADING RATE	: 11.66 sq.mt./ltr at recommended DFT of 30 $\mu$
FLASH POINT	: Above 25° C
DRYING CHARACTERISTICS	: Baking Schedule: 140Deg C / 30 Minutes.
SHELF LIFE	: 6 months

### == Surface Preparation

This being a topcoat, which is applied over, primer or intermediate coats, the surface should be free from oil, moisture, dust and dirt.

When used as a unicoat for OEM component the surface should be prepared by following seven tanks pretreatment. It is preferable to have Zinc Phosphating. Iron Phosphated surface is also acceptable under certain conditions Aged coatings should be roughened by emery paper grade 320 for better bonding.

### == Application Data

APPLICATION	: By Conventional Spray / Electrostatic Spray / Dipping
THINNER	: TSA thinner
RECOMMENDED DFT	: 30 - 40 $\mu$ .
COMPATIBILITY	: Compatible over Epoxy, PU and TSA primers

### == Application Method

Stir the base part thoroughly. Add Thinner Type TSA into the mix, if required. Strain the paint through Nylon filter cloth of 400 mesh size and pour it in the dipping tank. Dip the substrate completely ensuring no part remains uncoated. All equipments used for above should be properly clean.

Application: By Conventional Spray / By Electrostatic Spray / By Dipping



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Dipping: Dip the component gradually taking care no / minimum bubbles are formed. Remove the component slowly. The fat edge should be removed with brush.

#### For Conventional Spray application:

Thinner: TSA Thinner  
 Addition: 25 - 30 % max  
 Nozzle Orifice: 1.2 - 1.5 mm  
 Nozzle Pressure: 45 - 55 psi.

#### For Electrostatic Spray application

Thinner: TSA Thinner  
 Addition: 25 - 30 % max  
 Nozzle Orifice: 1.1 - 1.3 mm  
 Resistivity: 300 - 700 KOHms

### Additional Information:

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following section of Grand Polycoats' latest Data manual :

- Guide to Product Data Sheet
- Surface Preparation Details
- Paint Application Details
- MSDS

### Notes:

1. Do not apply paint when temperature falls below 10°C or rises above 50°C, when Relative Humidity is above 85%. & during rain, fog or mist. Surface temperature must always be minimum of 3°C above Dew point.
2. Dip tank should be cleaned with GP's recommended thinner.
3. DFT variation can be obtained by change in application method / thinning ratio. Contact Grand Polycoats' representative for further assistance.
4. Shelf life indicated is minimum for this Product in sealed condition and it is subject to re-inspection thereafter. Individual component is required to be stored in cool, dry and covered condition, away from heat and ignition.

### Health & Safety

This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapours as well as contact between the wet paint and exposed skin or eyes.

### Limitation of Liability

To the best of our knowledge, the technical data in our literature are true and accurate at the date of issuance but are subject to change without prior notice. We guarantee our product to conform to the specifications contained herein. We make no other warranty or guarantee of any kind, express or implied, including merchantability and fitness for particular purpose. Liability, if any, is limited to replacement of the product or refund of the purchased price. Labour or cost of labour and other consequential damages are hereby excluded.



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