

PRODUCT DATA SHEET

PRODUCT : DURABILD HBST MATT BLACK.

S.N.	TEST PARAMETERS	BERGER SPECIFICATION	TEST RESULTS
1)	Appearance	Smooth & uniform	Smooth & uniform
2)	Supply viscosity at 30°C	50 – 70 Sec.	60 Sec.
3)	Specific Gravity	1.35 ± 0.03	1.34
4)	Non-volatile Matter (% by weight, mixed paint)	61+/- 1 % Min. (Base only) 60 +/- 1 % Min (Mixed)	61.9%. (Base only) 59.3%. (Mixed only)
5)	%Volume Solid (Mixed Paint)	40% Minimum	40 +/- 2 %
6)	Recommended Thinner	T11900	T11900
7)	Application Viscosity at RT	17 – 22 Sec.	17– 22 Sec.
8)	Thinner intake (by Vol.)	25 % Thinner – 20 Sec. 35% thinner – 18 sec	25 % Thinner – 20Sec. 35% Thinner – 18 sec
9)	Recommended Catalyst		
10)	Mixing Ratio (Base/Catalyst)	5 : 1 by volume	5: 1 by volume
11)	Pot Life	6-8 Hrs.	8 Hrs.
12)	Shelf Life	6 Months	6 Months
13)	Fineness of Grind (Dispersion)	5.5+ HG	5.5 + HG
14)	Surface Preparation	All surfaces to be coated should be clear, dry and free from contamination.	All surfaces to be coated should be clear, dry and free from contamination.
15)	System	Copper Substrate → Cleaning with thinner → Air Blow → Primer Application (90 micron/180 Micron)- → Over night Air-dry or Bake at 70-80deg c 30 min.	
16)	Application Method	Conventional Airspray.	
17)	Flash off time	10 Mins.	10 Mins.
18)	Baking Schedule	70-80°C/30 Mins. Or Air Dry	70-80°C/30 Mins Or Air dry
19)	Ageing Period	72 Hrs.	72 Hrs.
20)	Gloss (60° Head) only primer	1-8	4
21)	Colour	Close match to approved standard	Close match
22)	Finish of Dried Film	Smooth, uniform & free from any surface defects.	Smooth, uniform & free from any surface defects.
23)	Dry Film Thickness (System)	90µm	90µm
24)	Adhesion (2 mm x 2 mm Sq.)	To pass 100/100 No peel-off in tape test.	Passes 100/100 Passes 6.25 mm
25)	Flexibility	To pass 6.25 mm Overnight	Overnight
26)	Hard Dry	30 Minute Maximum	30 Minutes Maximum
27)	Touch Dry	2 Hours Maximum	1 & ½ Hours
28)	Tack free Dry	HB or More after 48 hours of Airdrying	Passes
29)	Pencil Hardness		

DATE	PREPARED BY	APPROVED BY
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