

PRODUCT DESCRIPTION

High-performance thermosetting coating that cures under heat to create an incredibly hard, chemically resistant surface.

FEATURES AND RECOMMENDED USE

- Creates an incredibly hard, scratch-resistant film
- Excellent chemical and stain resistance
- Superb gloss retention post-baking
- Excellent for ceiling fans, bicycle frames, and industrial panels

TECHNICAL DATA

Colour Range	OEM Shades
Gloss	Thermoset Clear / Solid
Specific Gravity	0.95 - 1.25
Volume Solids	Approx 56%
Recommended DFT / Coat	20 - 25 µm
Theoretical Coverage	14.0 - 16.0 sq.mtr/ltr
Application Viscosity	24-28 Sec (Ford Cup 4)
Curing Schedule	Flash off: 10 mins Baking: Strictly 120°C for 25-35 minutes

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances. The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30°C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General Metal:

- Surfaces must be dry, clean and free from contaminants.
- Ensure removal of dirt, oil and all other contaminants. Oil and grease should be removed as per SSPC-SP1 solvent cleaning.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming.

Primed Surfaces:

- Suitable epoxy, PU, or alkyd primer/undercoat; dry & free from all surface contamination.
- REAL STOVING FINISH** must be applied within the specified over-coating interval of the primer.

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85% to prevent blushing or adhesion loss.
- Good ventilation is required in confined areas to ensure proper curing and solvent evaporation.

Mixing

Stir thoroughly. Ensure no contaminants enter the pressure pot.

Application Details

Air Spray	Thin 50% with Stoving Thinner to achieve 24-28 sec viscosity. Nozzle: 1.3 mm.
Brush / Roller	Not Recommended.
Cleaning	Do not allow the product to remain in hoses or spray equipment. Clean all equipments immediately after use with Stoving Thinner .

STORAGE & REGULATORY

Pack Size: As per standard Drona packaging (1L, 4L, 10L, 20L).
Shelf Life: At least 12 months @ 30°C for original unopened pack (36 months for architectural), subject to inspection thereafter. Store in a cool, dry place away from direct sunlight and heat sources, in accordance with

MATERIAL SAFETY & HANDLING

General Precautions: As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, appropriate respiratory, skin, and eye protection are always recommended when spraying.

Specific Handling: Flammable liquid and vapor. Avoid prolonged breathing of solvent vapors or