

## ROSALEE AIR DRYING CUM STOVING FURNITURE ENAMEL

### ➤ **Scope**

Furniture enamels are different from normal synthetic enamels, as under:

- (a) Capability of stoving besides air-drying.
- (b) Possibility of getting better slip in shorter time.
- (c) Cheaper than normal first quality synthetic enamels.
- (d) By and large, application is done by spraying and hence spraying droplets should not bounce back, causing dry spray and rough finish.

Under current situation of electric power in the country, furniture enamels should be capable of air-drying (whenever power fails). They should also be capable of drying under heat (stoving) to prevent dust collection and for getting faster production. Alkyd-melamine stoving enamels are ideal but they do not air dry and are costlier.

### ➤ **Areas of Application**

All furniture items made with mild steel like tubular chairs, tables, almirahs, filing cabinets and slotted angles.

### ➤ **Surface Preparation**

Oil, grease and rust must be removed before commencing painting. This can best be done by using 7-tank phosphate system or by sand blasting. If for any reason, it is not possible to use either of the above said method, use should be made of rustosan. It must be ensured that no trace of liquid rustosan is left on the surface.

### ➤ **Technical Data**

- APPEARANCE : Free flowing liquid in appropriate shade.
- VISCOSITY : 95 ± 5 sec. At 30° c.
- SPRAYING VISCOSITY : 22 to 25 sec.
- THINNER TO BE USED : Synthetic thinner 011
- DRYING : AIR DRIED : Touch dry : 15 minutes  
Dust free : 30 minutes  
Thumb impression free : 3 hours  
Hard dry : o/n
- STOVING : 30 min. After a flash off time of 10 min. @ 120°c.
- GLOSS : 60° geometry : 80-85°
- WEIGHT PER LITRE : 0.90 – 0.98 kg/ltr.
- SCRATCH HARDNESS : 1000 gms. After 24 hours
- CROSS HATCH TEST : Passes
- FLEXIBILITY : ¼” bending mandrel
- PETROL & OIL RESISTANCE : Very good

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### ➤ **Directions for Use**

- (i) Clean the surface as directed above.
- (ii) Apply a coat of good quality red oxide primer, preferably air-dry cum stoving type. Sand with 400 paper – wet sanding. When the primer film is dry, apply synthetic putty with circular motion of putty knife and allow drying for at least 4-5 hours. Wet sand the putty film, using a fine paper.
- (iii) Apply one more coat (thin) of primer to prevent absorption of paint by the putty film. Wet sand once again.
- (iv) Apply the final coat of air-drying cum stoving enamel, wet on wet three coats.  
It can be allowed to air dry or stove at 120°C for 30 minutes.

### ➤ **Notes**

Some consumers demand orange peel finish on furniture. The effect can be achieved by using higher pressure and by keeping the enamel viscosity slightly higher.

### ➤ **Disclaimer**

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