



PRODUCT DATA SHEET

ORGA M8000

Product Description:

ORGA M8000 is an Alkyd-Melamine based baking enamel paint for application on all steel substrates especially on steel drum. It is a fast-drying but slow curing type of paint that offers good resistance to chemical, oil, grease and mild solvent. The paint can be easily applied and gives good film properties such as flexibility, hardness and impact resistance when it is fully cured.

Physical Characteristics of Paint:

Colour	: Wide range of colour as per request
Finish	: High gloss
Specific Gravity	: 1.18 ± 0.05 ⁽¹⁾
Solid Content	: 56 ± 2 by volume ⁽¹⁾
Hardness	: Min H
Adhesion	: Pass 100/100
Impact Resistance	: Pass 1/2" x 1000g x 50cm
Water Resistance	: Pass 24 hrs x 40oC x rain water

Remark: (1) Base on White colour

Recommendation for Use:
Surface Preparation
Steel Surfaces

The surface must be clean and free from oil, rust and other foreign matters.
For optimum performance we recommended Zinc Phosphating chemical pre-treatment for a better result.

Non-Ferrous Metal Surfaces

Chromating chemical pre-treatment. After surface treatment, priming with VINILEX 120 ACTIVE PRIMER is a must before finishing coat in order to improve paint film adhesion.

Recommended No. of Coats	: 1 - 2 coats
Recommended Film Thickness per coat	: 30 microns for dry film 53 microns for wet film

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Theoretical Coverage at Recommended Film Thickness : 18.8 m² / liter (for dry film thickness of 30 microns)

$$\text{Theoretical Coverage (m}^2/\text{liter)} = \frac{\text{Volume Solid (\%)} \times 10}{\text{Dry Film Thickness (\mu)}}$$

Practical Coverage (20% Loss Factor) : 15.0 m² / liter (for dry film thickness of 30 microns)

Note : This theoretical coverage rate has been calculated from the volume solid of the material and is related to the amount of coating applied onto a perfectly smooth surface without wastage. For a practical coverage rate, due allowance should be made for atmospheric conditions, surface roughness, geometry of the article being coated, the skill of applicator, method of application etc. when estimating quantities required for a particular job.

Application Data:

Application Methods : It is suitable for ordinary air spray, airless spray and electrostatic spray painting application

Guiding Data for Spray	:	<u>Air</u>	<u>Airless</u>
		Delivery Pressure (kg/cm ²)	3 - 4 140 - 170
		Tip size at 60° angle	1.3 mm 0.015" - 0.017"

Thinning	:	Air Spray	20 - 30%
		Airless Spray	5 - 10%

Thinner : NIPPON ORGA M8000 THINNER or ORGA M8000 ELECTROSTATIC THINNER

Cleaning Solvent : NIPPON ORGA M8000 THINNER or ORGA M8000 ELECTROSTATIC THINNER

Note: All equipment should be cleaned IMMEDIATELY with Thinner after use. For thinning, substitute thinners other than those approved or supplied by Nippon Paint may adversely affect the product performance and void product warranty whether expressed or implied.

Drying Time at 25°C to 30°C:

Dry to overcoat : 15 - 20 minutes

Flash-off before baking : 10 - 15 minutes

Baking Temperature : 150°C x 15 mins (Metal surface temperature)

Standard Packing : 5 Liters & 20 Liters

Environmental Conditions during Application:

1. Do not apply when the relative humidity exceeds 85%. The temperature of the substrate to be painted must be

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3°C higher than the dew point.

2. Do not apply at temperature below 7°C. If not, drying and overcoating time will be considerably extended.
3. During application of the paint, naked flame, welding operations and smoking should not be allowed and good ventilation is necessary.

Safety, Health and Environmental Information:

1. Flammable Liquid. Do not expose to heat, sparks or open flame.
2. Skin Contact: May cause moderate skin irritation. Avoid prolong contact with skin. Use solvent resistant glove. To remove splashes of paint from skin, use soap and water.
3. Inhalation: Respiratory irritation. Only used in well ventilated areas. Do not breathe vapor or spray paint. Respirator with organic vapor cartridges recommended.
4. Eye Contact: Cause severe eye irritation and blurred vision. Safety glasses / goggles with side shields recommended. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
5. Ingestion: Harmful if swallowed. Keep away from drinks, food and out of reach of children. If swallowed, seek medical advice immediately and show the container or label.
6. In the event of an accident, contain and collect spillage using sand or earth or absorbent. Do not empty into drain or water courses.
7. Wastes and empty containers should be treated and disposed of in accordance with national and local regulations. Empty containers and packaging should be taken for recycling, recovery or disposal through a suitably qualified or licensed contractor.

NOTE: The information given applies to the product and its performance under specific test conditions. Due to the varied circumstances beyond our control under which the product may be applied, for specific application, please contact Nippon Paint Sales & Marketing Dept. We reserve the right to modify our product data sheet without further notice.

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