



**Colorificio  
Sammarinese  
SpA**

Via del Camerario 7  
47891 Falciano, San Marino  
T +378 (0549) 905 515  
F +378 (0549) 908 453

c.o.e SM00026  
Cap. soc. € 3.000.000,00 i.v.  
Riconoscimento giuridico  
n. 26 del 20 maggio 1944



colorificio@colsam.com  
colsam.com

## 38500350 EKO-LUX KILN MUNSELL RED



Used as a semi-glossy top coat in kiln-based coating cycles with waterborne products to coat iron pipes and metal objects, in industrial applications.

---

|                         |  |
|-------------------------|--|
| <b>Date of revision</b> | 15/05/2020   |
| <b>Composition</b>      | A semi-glossy polyester-melamine water-soluble enamel  |
| <b>Main properties</b>  | <ul style="list-style-type: none"><li>• free of lead compounds;</li><li>• ultra-low VOC content;</li><li>• good resistance to corrosion;</li><li>• elasticity and high adhesion.</li></ul> |
| <b>Applications</b>     | For coating various types of objects such as cast iron objects, semi-processed objects, crankcases, differentials, piping, etc.  |
| <b>Colour</b>           | MUNSELL RED  |

---

| <b>Technical specifications</b><br>(data measured at 20°C, 65% R.H.) | <b>Reference</b> | <b>UoM</b>        | <b>Value</b>                         |
|--|------------------|-------------------|--------------------------------------|
| Specific weight (pycnometer)   | C022             | kg/l              | 1.340 ± 0.040                        |
| Ford Viscosity Cup 8   | C076             |                   | 14 ± 2 sec                           |
| Gloss  | C005             |                   | 70 ± 5 GU                            |
| Adhesion   | ISO 2409         |                   | 100%                                 |
| Dry residue by weight  | C033             | %                 | 58 ± 1                               |
| Recommended DFT  |                  | microns           | 55 ± 5 DFT                           |
| Theoretical coverage   |                  | m <sup>2</sup> /l | 8–9 at the recommended thickness.    |
| Practical coverage   |                  |                   | Consider an appropriate loss factor. |

---



**Colorificio  
Sammarinese  
SpA**

Via del Camerario 7  
47891 Falciano, San Marino  
T +378 (0549) 905 515  
F +378 (0549) 908 453

c.o.e SM00026  
Cap. soc. € 3.000.000,00 i.v.  
Riconoscimento giuridico  
n. 26 del 20 maggio 1944



colorificio@colsam.com  
colsam.com

## Method of use

- . Application method By spraying
- . Thinner Demineralised water
- . Dilution 5–7% (maximum)
- . Application by spraying  
*Airbrush:*  
Nozzle: 1.6–1.8 mm  
Pressure: 3–4 atm  
*Airless:*  
Nozzle: 0.013–0.019 inches  
pressure: 120–160 kg/cm<sup>2</sup>  
compression ratio: 30:1
  
- . Hardening time Drying in kiln:  
- flash-off: 15–20' x 70°C  
- curing: 20' x 130°C

---

## Surface preparation

Apply the product on clean, adequately prepared iron free of rust and calamine. Improved results can be obtained through the phosphatation treatment.

Wash any tools immediately after use with water. The hardened product can be removed from tools using Diluente Nitro nitro thinner.

## Storage

Store between 5 °C and 35°C. The product can be stored for 6 months in its original packaging. After this time you must check the condition of the product.

## Warnings and safety

This product is provided only for professional use and for professional applicators. We recommend always referring to the product Safety Data Sheets for details relating to health and safety and for the storage and disposal rules.

---

This information is the result of our practical experience but is purely indicative. For more detailed information, please contact our technical support service. This sheet cancels and substitutes any previous editions.

---