



MATSUI INTERNATIONAL CO. INC.

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PRODUCT DATA SHEET

PRODUCT IDENTIFICATION Chromicolor® PVC Spray Paint

GENERAL INFORMATION

Chromicolor® PVC Spray Paint is a water based, temperature sensitive colorant for spray painting onto plastisol products with a shore hardness of 75 or below. A topcoat is recommended for better abrasion and adhesion resistance.

PRODUCT SPECIFICATIONS

The “cold” color is the one that changes – it actually disappears at a given temperature to reveal the “hot” color, which is the base color (a conventional colorant). There are eleven standard “cold” colors and ten standard “hot” colors. The eleven standard Chromicolors are:

New Fast Yellow Gold Orange Vermilion Pink Magenta
Fast Blue Turquoise Blue Brilliant Green Fast Black Green Brown

Composition:

	<u>Chromicolor® PVC Spray Paint</u>	<u>PVC Clear Paint</u>	<u>PVC Top Paint (Luster or Non-Luster)</u>	<u>PVC Fixer</u>
Chromicolor®	17 ± 1%	--	--	--
Polyurethane Resin	--	--	4	--
Polyacrylic Resin	24 ± 1%	43 ± 1%	--	--
Polyisocyanate Resin	--	--	--	75
Ester Solvent	--	--	--	25
Ketone Solvent	--	--	60	--
Alcohol Solvent	--	--	36	--
Water	Rest	Rest	--	--
TOTAL	100	100	100	100

	<u>Chromicolor® PVC Spray Paint</u>	<u>PVC Clear Paint</u>	<u>PVC Top Paint (Luster or Non-Lustre)</u>	<u>PVC Fixer</u>
Nature	Colored liquid	Milk white liquid	Transparent liquid	Clear liquid
Specific Gravity	1.05 ± 0.05	1.03 ± 0.05	0.87 ± 0.05	1.09 ± 0.05
Viscosity @ 25°C	1,000 – 3,000 cps	1,000 – 3,000 cps	10-15 cps	500 cps ± 200
Flash Point	N/A	N/A	24°C	-4°C
Solids, theoretical	41 ± 2%	43 ± 1%	870 ± 50	1090 ± 50

Solvents: Pretreatment & Optional Primer: Degrease the surface of molding made of PVC / Plasticizer using solvent (IPA). No special primer needed.

Viscosity reduction:

Chromicolor® PVC Spray Paint / PVC Clear Paint - water up to 5%

PVC Top Paint / PVC Fixer - MIBK

Clean-up

Chromicolor PVC Spray Paint / PVC Clear Paint - water (after the film is dried clean using solvent such as MEK)

PVC Top Paint / PVC Fixer - MEK / IPA=6/4 mixed solvent

Pot Life of Mixed Paint: Eight hours

Coating Material Preparation:

	Formula of Chromicolor Paint	Formula of Top Coat Paint
Chromicolor PVC Spray Paint	25.0	--
PVC Clear Paint	75.0	--
PVC Top Paint (lustre or non-lustre)	--	100.0
PVC Fixer	--	0.5
<hr/> TOTAL	<hr/> 100.0	<hr/> 100.5

APPLICATION METHOD

Recommended Viscosity: Chromicolor Paint: 3,000 - 5,000 cps
Top Coat Paint: 10 - 15 cps

Substrate Preparation: Degrease the surface using IPA

Application Equipment: Air gun. Make sure orifice of gun is large enough to permit the passage of 50µ particle size.

Application Procedure: Filter the Chromicolor Paint with a 180 mesh filter prior to application.

Chromicolor Paint: Apply 150g / m² with spray gun. Cure for 15 – 20 minutes @60°C.

PVC Top Paint (lustre or non-lustre finish): Apply 75gm / m² with spray gun and allow to air dry. Cure at 60° C – 80°C for 10 minutes.

Recommended Dry Film Thickness: Chromicolor Paint: Approx. 60µ / dry
Top Coat Paint: Approx. 3.5µ / dry

SHELF LIFE, STORAGE, SAFETY, HANDLING

Shelf Life: Chromicolor PVC Spray Paint: 30°C x 3 months

PVC Clear Paint: 30°C x 6 months
PVC Top Paint: 30°C x 6 months
PVC Fixer: Tightly sealed - 30°C x 6 months.
After open, 30°C x 1 month

Storage: Store Chromicolor PVC Spray Paint and all components in a cool, dry area below 30°C.

Safety, Handling: Do not inhale the paint fumes.
Avoid skin contact.
Protective clothing should be worn at all times when using this product (safety glasses, gloves).
REFER TO MSDS FOR SPECIFICS.