

# Technical Data Sheet

Solutions for Decoration

## 80 4019 - Hardener

<b>Application</b>	80 4019 is the hardener of the sandblasting mask SANDBLASTING 03. The use can be seen from the Data Sheet SANDBLASTING 03.
<b>Printing properties</b>	The paste consisting SANDBLASTING 03 and 80 4019 is printed with 77-50 PET mesh screens as a starting point. A 24-120 PET mesh is suitable for the strippable Coat L 138/5.
<b>Miscibility</b>	--
<b>Application errors</b>	Once components A and B are mixed, the curing process starts. Using the paste for more than 1h may result in screen clogging. Screens, squeegees and tools should be cleaned right after use with thinner V 191.
<b>Storage</b>	80 40 19 should be stored in the drums in which it was originally supplied by FERRO in a dry place at room temperature (15-25°C). Always seal opened drums carefully as the composition of the product changes when solvents evaporate from open drums. When this storage recommendation is observed, the minimum shelf life in unopened original drums is 6 month.
<b>Environment</b>	Waste material treatment, environmental health and safety protection has to follow the local regulations and legislation.

<b>Field of application</b>	Only in combination with SANDBLASTING 03
<b>Processing</b>	with automatic and semi-automatic screen printing equipment
<b>Appearance</b>	transparent liquid
<b>Composition</b>	aliphatic isocyanate; solvents
<b>Viscosity at 23°C [mPa*s]</b>	1600 at 50 1/s ; 1600 at 200 1/s
<b>Degree of thixotropy</b>	none
<b>Consistency</b>	flowing
<b>Density at 20 °C [g/cm³]</b>	1,15
<b>Non-Volatile parts (nvp) [%]</b>	67
<b>Flash point according to ISO 3680 [°C]</b>	40
<b>Recommended screen material</b>	- -
<b>Recommended pasting ratio</b>	- -
<b>Drying</b>	- -
<b>Drying figures TZ according to Mettler</b>	TZ 10: ; TZ 100: unapplicable
<b>Recommended working temp. [°C]</b>	20 - 25
<b>Recommended rel. humidity [%]</b>	55 - 60
<b>Recommended Covercoats</b>	- -
<b>Thinner</b>	V 191
<b>Cleaner</b>	V 191

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