

Oxipro Forja

Product description

Type

A top quality exterior enamel. Based on alkyd resin.

Features and benefits

Contains micaceous oxide pigments which give anticorrosive properties, compared to standard alkyds. Provides a roughy flat forge finish. Extreme rust protection.

Recommended use

Ideal for use on exterior metallic surfaces, but also on other surfaces like wood and plywood. Its roughy finish mimicking the forge effect is ideal for fences, lampposts, etc.

Product data

Packaging size	0.75 L and 4 L
Colours	As per colour card.
Solids by volume	51 ± 2 volume% Theoretical
VOC	500 g/l ISO 11890 EU

Application data

Remarks

Due to the characteristics of the forge effect pigments, on flat surfaces of a certain size, spray application is recommended to ensure the uniformity of the finish. On large smooth surfaces, slight differences in gloss level can be observed due to its composition of micaceous iron oxide.

The product can be applied by

Roller : Recommended.

Spray : Use airless spray or conventional spray.

Brush : Recommended.

Guiding data for airless spray

Nozzle tip	0.018-0.021"
Spray angle degrees	65-80°
Pressure at nozzle	150 Kg/cm ² (2100 psi)

Cleaning of painting tools

Jotun Thinner No. 2

Film thickness per coat

Typical recommended range

Dry film thickness 40 - 50 μm

Wet film thickness 80 - 100 μm

Film thickness will vary and is calculated as average.

Theoretical spreading rate 12.5 - 10 m^2/l

Spreading rate depends on film thickness applied, type of texture, surface porosity, imperfections, temperature, wastage during painting etc.

Maximum spread rate per coat is obtained at minimum dry film thickness and vice versa.

Thinner

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Conditions during application

The temperature of the substrate should be minimum 10 °C and at least 3 °C above the dew point of the air, measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying. The moisture content in the substrate should not exceed 4 % (by weight). The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Drying times

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

1. Recommended data given is, for recoating with the same generic type of paint.
2. In case of multi-coat application, drying times will be influenced by the number and sequence and by the total thickness of previous coats applied.
3. The surface should be dry and free from any contamination prior to application of the subsequent coat.

The drying time is measured by stated values:

Relative Humidity (RH) 50 %

Substrate temperature	10 °C	23 °C	40 °C
Surface (touch) dry	2 h	1 h	45 min
Hard dry	10 h	6 h	3 h
Dry to over coat, minimum	24 h	24 h	18 h

Directions for use

Surface preparation

The substrate must be sound, clean, dry and free from dust, oil, grease, laitance etc. All traces of form release agents/curing agents must be removed. A light sanding with suitable abrasive material is recommended before application. Any resulting dust/loose particles must be removed.

Recommended paint system

Primer

Imprimación Multiuso Al Disolvente : 1 Coat

Topcoat

Oxipro Forja : 2 Coats

Remarks

Other systems may be specified, depending on area of use.

Contents of packaging with different batch numbers must be mixed together before use.

Please refer to the Decorative Sales Department for technical advice.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 23 °C

Oxipro Forja 24 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Health and safety

Please observe the environmental and precautionary notices displayed on the container.

A Material Safety Data Sheet for the product has been issued.

Detailed information regarding health and safety risks and precautions for the use of this product is specified in the product's Safety Data Sheet.

First-aid measures, refer to section 4.

Handling and storage, refer to section 7.

Transport information, refer to section 14.

Regulatory information, refer to section 15.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.