

## GLASS ENAMEL

High temperature, water based, screen printing/roller coater, lead-free enamel.

### APPLICATION PROCESS RESULTS

All tests have positive result. Coverage is very high after tempering.

### APPLICATION PROCESS

This enamel can be applied by silk screening, roller coating and spraying. For maximum quality, the glass and all equipments have to be cleaned perfectly.

#### For Silk Screening

Add 3-7% medium depending on the mesh size.

#### For Roller Coating

Add 10-15% medium to adjust the viscosity between 90-120 seconds with Ford CupVI.

#### For Spraying

Add 35-45% demineralized water and adjust the viscosity 15-20 seconds with For CupIV.

For all above applications, mix properly-medium and enamel, do not overheat the enamel with high speed mixer, let it cool down to room temperature.

We recommend 18-23°C for enamel application room to control viscosity stability.

### DRYING CONDITIONS

Pre-drying is performed for 3 min. (120-200° C) in the IR drying furnace. If you don't have a drying furnace we suggest 24 hours air drying in recommended room temperature.

## FIRING CONDITIONS

For 4mm glass in tempering furnace 115-170 seconds between 680-720°C. For different thicknesses of glass, you can contact with us.

680 °C - 720 °C  
Tempering

### TYPICAL PHYSICAL PROPERTIES

|               |                                 |
|---------------|---------------------------------|
| Appearance    | High Viscosity Paste            |
| Density       | 2,2550-2,4000 g/cm <sup>3</sup> |
| Particle Size | Less than 20 microns            |
| Viscosity     | 15,0 P – 18,0 P (20° C)         |
| Odor          | Characteristic                  |

### STORAGE CONDITIONS

The enamel should be kept well closed in the original pack.

Their shelf-life should be considered 12 months.

This information is intended for product recommendations.

Metal-Kimya laboratory experiments and the process informations according to test results are shared for the ease of use. Customers do not test our products on their own terms and are required to use the most appropriate way. Otherwise, can not be held responsible for Metal-Kimya.