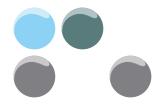
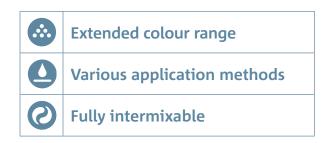
Flat glass Enamels



Product information AF2000 Series heavy metal and lithium-free glass enamels







Colour range

Part Number	Description
AF2000	White
AF2100	Lemon yellow
AF2200	Citrus yellow
AF2202	Honey yellow
AF2300	Iron red
AF2400	Green
AF2401	Turquoise
AF2402	Chrome green
AF2500	Blue
AF2600	Black
AF2700	Autumn brown
AF2730	Rust brown
AF2740	Chocolate brown
AF2900	Imitation etch



Extended colour range*

Part Number	Description
AF2201	Yellow
AF2301	Flaming red
AF2302	Dutch orange

The colours of the AF2000 Series can be supplied as:

- Powder
- Oil based screen print paste
- Water friendly screen print paste
- Water friendly roller coat paste
- *The extended colour range is cadmium containing.



Application Method	Screen Printing		Roller Coating	Spraying
	Oil based IR-medium	WF-IR-medium	WF-IR-medium	Water based medium
Recommended medium	63-485	654-63	654-63	747-65
Recommended thinner	RM.441	RM.444	733-63	Water
Powder/medium ratio	3,5:1	3,5:1	3,5:1	70 parts powder 7 parts medium 30 parts water
Viscosity	10 - 20 Pa.s	10 - 20 Pa.s	10 - 20 Pa.s	15 - 20 sec
Application temperature	5 - 25°C	5 - 25°C	5 - 25°C	5 - 25°C
Humidity	30 - 60%	30 - 60%	30 - 60%	
Screen (mesh)	61 - 120	61 - 120		
Wet film thickness	30 - 40µm	30 - 40µm	80 - 120µm	100 - 150g/m²
Drying conditions	100 - 150°C	100 - 150°C	100 - 150°C	100 - 150°C
Storage	5 - 25°C	5 - 25°C	5 - 25°C	5 - 25°C
Shelf life	1 year	1 year	1 year	6 months

It is recommended that before decoration the glass should be at ambient temperature and completely clean and dry.



Type of Substrate	Firing Range °C	Firing Range °F
Flat glass	620 - 720	1148 - 1328



Acid resistance

When applied and fired correctly the range will meet the chemical resistance levels described in this Technical Data Sheet. This level of resistance, however, does not imply nor guarantee any specific levels of resistance to atmospheric exposure nor product lifespan.

We do not recommend the use of these glass enamels in environments where they will be directly subjected to water and weather for extended periods.

3.7% HCl, 15 minutes at room temperature grade: 2 to 3. Assessment according to ASTM C 724-91

10% Citric acid, 15 minutes at room temperature grade: 1 to 2. Assessment according to ASTM C 724-91

4% acetic acid, 24 hours at room temperature grade: 2 to 3. Assessment according to ASTM C 724-91

Alkaline resistance

10% NaOH, 2 hours at 95°C result: < 1.0 mg/cm² assessment according to ASTM C1203-91

Storage

It is recommended that the glass enamels are stored in tightly sealed containers away from direct sunlight at an even temperature in the range of 5 - 25°C (41 - 77°F). Under these conditions the enamel can be stored for reasonable periods, although storage for longer than 12 months is not recommended.

Water based spray medium should never be stored at temperatures < 0°C.

Health and safety

Good industrial hygiene and work practices should be adhered to when handling the products mentioned in this document. For detailed health and safety requirements, please consult the appropriate Material Safety Data Sheets.





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