

PRODUCT DATA SHEET

CLC 04

Chlorinated rubber enamel

FEATURES	Satin enamel, characterized by low dripping and fast drying; this allows applications that guarantee a finish with uniform thickness, edge coverage and rapid execution of the painting. It is formulated with resins that give particular adhesion properties and ease of maintenance of steel manufactures. Once dried, the enamel provides protection to ferrous structures exposed in marine and industrial environments, and exposed to splashes of basic, acids and saline substances. Due to its resistance to alkalinity is indicated to protect structures in concrete. For its resistance to alkalinity is indicated in the protection of concrete structures (pools, containment basins, etc). It's particularly suitable for the periodic maintenance as it allows a safe adhesion between layers with unlimited overlaying times.			
USE	It is suitable for decoration and protection from the atmospheric agents in rural, marine or industrial environments of artifacts such as industrial machinery, fixtures, railings, containers, agricultural and construction equipment made of iron, galvanized iron, aluminum, alloys, suitably pretreated . It is also used as a coating of hydraulic works in cement.			
PROPERTY OF THE PRODUCT		VALUE	METHOD	
	Application temperature	< +120 °C		
	Flash point	27°C		
	Solid by volume %	45 % ± 2		
	VOC	500 g/l		
SPECIFICATION DATA		VALUE	METHOD	
	Specific weight	1100-1300 g/l	Internal PF3	
	Gloss	25 -35	Internal PF6	
	Drying Time	Overcoatable 3 h Fully 12 h	Internal PF2	
THICKNESS AND COVERAGE		Min.	Max	Recommended
	Thickness of dry film, µm	40	80	50
	Thickness of wet film, µm	89	178	111
	Theoretical yield, m²/l	11,2	5.6	9
	Theoretical yield, m²/kg	8,8	4,5	7,2
SHELF LIFE	1 year stored in its original and unopened can at a temperature between +5°C and +30°C.			
COLOUR RANGE	The range of colours can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.			
PREPARATION OF SURFACE	General observation: Surface must be dry and clean from any kind of oil, grease and salts.			

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Coated surface

With primer: it can be painted if the substrate is clean and free of dirt, oil, grease, and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt).

With complete finishing coat: if undamaged compatible and non-chalky, perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

Rusty coating: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer.

Localized maintenance: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

TOOLS

Conventional or airless spray, roller, brush.

APPLICATION

Thinning	5-10% by Diluente S800
Application condition	+5°C +40°C >3°C at dew point Relative humidity: <70%
Application by airless	Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi.). Nozzle: 0,28 - 0,38 mm (0,011 - 0,018") Angle range: 40 - 80° Air pressure: Compression ratio 30:1 (pressure 150-180 kg/cm²)
Application by conventional spray	Nozzle: 1,6 - 1,8 mm Angle range: 40 - 80° Air pressure: 3,5-4 kg/cm²
Thinner for washing	Thinner Nitro NV 5000

DRYING TIME

Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. High thicknesses per coat and unfavorable environmental conditions slow down the drying and hardening depth.

DTF 50 micron		
Surface temperature	10°C	23°C
Out touch	45'	30'
Dry to touch	5h	3h
Full catalysis	24h	12h
Minimum time of over application	5h	3h
Maximum time of over application	Nn	Nn

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**RECOMMENDED
PRIMER**

Galvanized steel, aluminum, alloys: Aridur, Chromocap W,
Steel: Primer 15, Crometal T.A, Primer 40

**RECOMMENDED
SYSTEM**
Industrial atmosphere

Product	Coat	Wet Thickness	Dry thickness
Primer 15	1	95	60
Primer 15	1	95	60
CLC 04	1	111	50
Total	3	301	170

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Crometal T.A	1	100	65
Crometal T.A	1	100	65
CLC 04	1	111	50
Total	3	311	180

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary.

This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.