

PRODUCT DATA SHEET

ENO OPACO

High performance synthetic enamel

CHARACTERISTIC Enamel characterized by excellent shiny finish, fullness, distension, low tendency to sagging, features that allow results with uniform thickness, adequate edge covering and fast execution of the painting.
 It is formulated with pigments stable to light, synthetic resins and modified alkyd, solvent-based, which guarantee high protection outdoors in conditions of extreme exposure to atmospheric agents and sunlight; It is suitable for the painting systems of artifacts in interior and exterior.

USE It can be used on synthetic undercoats or resistant to the subsequent nitro thinner. It is suitable for decoration and protection of new structures, or undergoing maintenance, made of different substrates like wood, plastic, in rural, marine or industrial environments, such as frames in general, railings, carpentry. To ensure good durability is essential that the artifacts are pretreated with appropriate provisions.
 For spray applications be careful to large thickness to prevent too long drying processes and wrinkling. Ensure that the previous coat is well dried before over-coating and in any case within 72 hours to ensure a good adhesion of subsequent layers, otherwise smooth between layers.
 If the product has been stored at low temperatures we recommend to bring it to at least 15° C before applying.
 Sanding dust and debris spraying paint buckets should not be accumulated since they can cause spontaneous combustion.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Application temperature	<+80 °C	
Flash point	27°C	
Solid by volume	55 % ± 2	
VOC	300 g/l	

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1050-1350 g/l	Internal PF3
Gloss	35-45	Internal PF6
Drying Time	Fully 48 h	Internal PF2

THICKNESS AND YIELD	Min.	Max	Recommended
Thickness of dry film, µm	40	50	45
Thickness of wet film, µm	72	91	81
Theoretical yield, m²/l	13,9	11	12,3
Theoretical yield, m²/kg	11,6	9,2	10,3

STORAGE Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR The range of colors 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.

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PREPARATION OF SURFACE

General observation: Surface must be dry and clean from any kind of oil, grease and salts.

New steel

The surface must be clean and dry, free of oils and other contaminants. Sandblasting Sa2½ ensures the best performance corrosion.

Surfaces treated with shop primer

If undamaged, clean and free from any dirt, oil, grease, salts and dry, it can be painted otherwise perform the preparation as for coated surfaces.

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

Hair roller, brush, Spray.

APPLICATION

Thinning	0-10% by Diluente S800
Application condition	+5°C +40°C
	>3°C at dew point
	Relative humidity: <70%
Application by conventional spray	Nozzle: 1,6 – 1,8 mm
	Angle range: 40 - 80°
	Air pressure: 3,5-4 kg/cm²
Thinner for washing	Diluente S800

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 45 micron	
Surface temperature	23°C
Out touch	60'
Dry touch	24h
Full	48h
Minimum time of over application	24h'
Maximum time of over application	72h

RECOMMENDED PRIMER

Steel: Primer 2; Primer 15, Chromocap
 Galvanised steel, Aluminum, Alloys, plastic: Aridur; Chromocap W.
 Wood: Opakite .

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RECOMMENDED SYSTEM	Atmosfera industriale			
	Product	Coat	Wet Thickness	Dry thickness
	Crometal	1	100	50
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	ENO Opaco	1	81	45
	Total	3	281	145

ALTERNATIVE SYSTEM	Product	Coat	Wet Thickness	Dry thickness
	Primer 15	1	100	70
	Eno Opaco	1	81	45
	Total	2	181	115

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.