PRODUCT DATA SHEET

FER MAX GG 18

Acrylic polyurethane micaceous undercoat finish

CHARACTERISTIC

Anticorrosive two-component top coat, drying at room temperature or forced air, based on hydroxylated acrylic resins and aliphatic isocyanate, anticorrosive pigments, lamellar micaceous iron oxides and aluminium. It has direct adhesion on steel, galvanised steel and aluminium and has an excellent scratch-resistant effect. The dried film is characterised by excellent elasticity, resistance to abrasion, chemical and weathering attack and ensures long-lasting colourfastness.

USE

It is used as a top coat on acrylic or epoxy two-component primers or as a single coat on various metals such as galvanised steel, aluminium and light alloys, on plastics and where high mechanical and UV resistance and good aesthetic characteristics are required. Due to its special aesthetic effect, it is recommended as a one-coat product for items such as gates, balconies, railings, gratings, as it provides effective anticorrosive protection with a highly decorative appearance, with metallic reflections similar to wrought iron.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Specific weight (A+B)	1210-1310 g/l	
Application temperature	< +80 °C	
Flash point	> 23°C ± 2	
Solid by volume %	62 ± 2% by Induritore Poliuretanico MS	
Drying Time	Fully 24 h	Internal PF2

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1300-1400 g/l	Internal PF3

THICKNESS AND YIELD

By Induritore Poliuretanico MS	Min.	Max	Recommended
Thickness of dry film, µm	40	70	50
Thickness of wet film, µm	90	150	110
Theoretical yield, m^2/l	11,1	6,7	9.1
Theoretical yield, m^2/kg	8.9	5.3	7.3

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

As per colour chart. 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

The treatment of the surface to be coated is of primary importance and has an impact on the performance of the coating cycle.
A good and correct preparation of the substrate is a guarantee of quality on the

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durability of the coating: a high quality product applied on a poor substrate or on a substrate treated inadequately is destined to an early wear and tear, characterised by possible alteration phenomena of the coating itself.

HOT GALVANIZED STEEL

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner.
Alternatively, a light silica sandblasting is recommended.

ALUMINUM AND LIGHT ALLOYS

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

COATED SURFACE

With primer: If clean, dry and free of dirt, oil and grease and the application is within the maximum primer coating time, the surface can be painted. If cleaning is necessary, pressure wash Wa2 grade (surface free of oil, grease, salts, dirt).
With complete topcoat: if compatible, undamaged and non-flaking, clean from oil and grease with detergents; then carry out surface sanding followed by pressure washing to remove dust and salts.
Rusty coating: Carry out mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salts or sandblasting Sa2 or Sa2½. Then restore the primer thickness.
Localised maintenance: Carry out mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salts or sandblasting Sa2 or Sa2½. Round off the edges of well-anchored paint and restore the system to its original layers and thicknesses.

TOOLS

Conventional spray o airless (high temperature and humidity <40% is possible the formation of " dusting"), roller, brush (for small surfaces and profiles).

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APPLICATION	Mix ratio in weight	100:25 by Induritore Poliuretanico MS
	Mix ratio in volume	100:30 by Induritore Poliuretanico MS
	Thinning	0-5% by Diluente Butol
	Application time at 23°C	5-6 h
	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: 30 - 50° Air pressure: 3,5-4 kg/cm²
	Thinner for washing	Diluente 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. In over coating, best adhesion can be obtained when next application is done before catalysis is completed.

DFT 60 micron

Surface temperature	5°C	10°C	23°C	30°C
Out touch	2h	60'	45'	30'
Dry touch	16h	8h	4h	3,5h
Full catalysis	3 days	36h	24h	18h
Minimum time of over application	16h	8h	4h	3,5h
Maximum time of over application	5	3 days	48h	36h

RECOMMENDED PRIMER

Epoxy, poly-acrylic.

RECOMMENDED SYSTEM

Urban, industrial, marine atmosphere

Product	Coat	Wet Thickness	Dry thickness
Epox zinc 2k	1	80	50
Capmastic ST	1	150	90
Fer Max GG 18	1	110	50
Total	3	340	190

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Primer 40	1	90	60
Fer Max GG 18	1	150	70
Total	2	240	130

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Product	Coat	Wet Thickness	Dry thickness
Filler 46	1	123	90
Fer Max GG 18	1	130	60
Total	2	253	150

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.

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