

TECHNICAL DATA SHEET
HYDRO RE 30
Waterbased glossy enamel

FEATURES Glossy enamel, mono-component, air-drying, suitable as a protective ferrous metal substrates exposed in interior and exterior. Characterized by excellent adhesion, hardness and flexibility is formulated based on modified synthetic resins dispersed in water and light-resistant pigments. Since it is waterbased, is particularly suitable for applications in poorly ventilated areas. It is formulated with raw materials selected for their low impact, reduced pollution and minimum emissions, so as to preserve the health and safety of users and people living in the environment.

TYPICAL USE It is suitable for the protection of iron artifacts new or undergoing maintenance subjected to particularly corrosive agents such as carpentry, fixtures, railings, barges, tanks or agricultural equipment in rural, marine and industrial. The thickness recommended for effective protection is established on the basis of the aggressiveness of the environment.
 It should be applied on artifacts previously treated with anti-rust. In the case in which the product has been stored at low temperatures it is recommended to take at least 15 ° C before proceeding to the application. The preheating of the product to about 30 ° C, gave good results by improving the coverage of the edges and avoiding sagging. The product is suitable for the forced drying tunnel and hot air at 35 ° C to 50 ° C.

PROPERTY OF THE PRODUCT	DESCRIPTION	VALUE	METHOD
	Working temperature	<+80 °C	
	Solid by volume	50±2%	
	Drying Time	Fully 24 h	Internal PF2

SPECIFICATION DATA		VALUE	METHOD
	Specific weight	1000-1150 g/l	Internal PF3
	Gloss level 60°	> 85	Internal PF6

THICKNESS AND COVERAGE	Minimu m	Maximum	Recommended
Thickness of dry film, µm	40	70	50
Thickness of wet film, µm	80	140	100
Theoretical coverage, m²/l	12,5	7.1	10
Theoretical coverage, m²/kg	11.6	6.6	9.3

SHELF LIFE 1 year if 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 from the RAL colour chart. Between one production run and the next, the hue may differ slightly, so it is necessary to finish the job with the same production run.

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**SURFACE
PREPARATION**

General considerations: The surface must be dry and clean of pollutants of various kinds such as dirt, oil, grease and salts.

Coated surfaces

With primer: If clean, dry and free of dirt, oil, grease, salts, and the overcoating is within the maximum primer coating time, the surface can be painted. If cleaning is necessary, carry out high-pressure washing grade Wa 2 (surface free of oil, grease, salts, dirt).

With complete coating: if compatible, intact and not flaking, clean from oil and grease with detergents; then carry out surface sanding followed by high-pressure washing to remove dust and salts.

Rusty coating: carry out St2 or St3 mechanical preparation followed by high-pressure washing to remove oil, grease, dust and salts.

Localised maintenance: Carry out mechanical preparation St2 or St3 followed by high pressure washing to remove oil, grease, dust and salts. Round off the edges of well-anchored paint and restore the system to its original layers and thicknesses.

TOOLS

Conventional spray, airless, roller, brush.

APPLY

Thinning	0-5% with water
Conditions of application	+15 °C +40 °C >3 °C at dew point Relative humidity:<65%
Application by airless	Nozzle pressure:15 MPa (150 kp/cm ² , 2100 psi). Nozzle: 0,28 - 0,38mm (0,011 - 0,018") Angle range; 40 - 80° Air pressure: Compression ratio 30:1 (pressure 150-180 kg/cm ²)
Application by conventional spray	Nozzle: 1,6 - 1,8mm Angle range; 30 - 50° Air pressure: 3,5-4 kg/cm ²

DRYING TIMES

Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. It is also important that the room is ventilated, to facilitate water evaporation.

Surface temperature	23 °C	50 °C
Out touch	45'	15'
Dry to touch	5h	45'
Full	24h	3h
Minimum time of over application	5h	1h

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RECOMMENDED UNDERCOATS	Hydro Primer 15, Hydro Primer Finish 5, Hydro Primer 40			
RECOMMENDED SYSTEM	Atmosphere C2	Coats	Wet Thickness	Dry thickness
	Product			
	Hydro Primer 15	1	120	65
	Hydro RE 30	1	100	50
	Total	2	220	115
POSSIBLE SYSTEMS	Product	Coats	Wet Thickness	Dry thickness
	Hydro Primer Finish 5	1	140	70
	Hydro Primer Finish 5	1	140	70
	Hydro RE 30	1	100	50
	Totale	3	380	190

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.