

SCHEDA TECNICA

HYDRO RE 35

Waterbased semi-glossy enamel

FEATURES

Mono-component enamel, 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

	VALUE	METHOD
Solid by volume	<+80 °C	
Specific weight	50±2%	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1000-1150 g/l	Internal PF3
Gloss	15-25	Internal PF6
Drying Time	Fully 24 h	Internal PF2

THICKNESS AND COVERAGE

	Minimum	Maximum	Recommended
Thickness of dry film, µm	40	70	55
Thickness of wet film, µm	80	140	110
Theoretical coverage, m²/l	12,5	7.1	9,1
Theoretical coverage, m²/kg	11,6	6,6	8,5

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 colors can be selected in the shades of the RAL folder. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.

SURFACE PREPARATION

General considerations: surface should be free from previous treatments and clean from pollutants of various kinds such as dirt, oil, grease and salts.

Coated surfaces

With primer: if clean and free of dirt, oil, grease, salts and dry, and recoated part in a maximum of the primer coating can be over applied. If cleaning is necessary , perform high-pressure washing Wa 2 (surface free of oil, grease, salt, dirt).

With complete coating: if undamaged compatible and non-chalky perform cleaning

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oil and grease with detergent, then perform surface sanding followed by pressure washer to remove dirt and salts.

Rusty coating: perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salts or sandblasting Sa2 or Sa2,5; then restore the primer thickness.

Localized maintenance: perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2,5. Round off the edges of the paint well stuck and restore the system in the original layers and thicknesses.

TOOLS

Conventional spray, airless, roller, brush

APPLY

Thinning	0-5% con acqua
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 – 1,8 mm 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

RECOMMENDED UNDERCOATS

Hydro Primer 15, Hydro Primer 40

RECOMMENDED SYSTEM

Product	Coats	Wet Thickness	Dry thickness
Hydro Primer 15	1	120	65
Hydro RE 35	1	110	55
Total	2	230	120

POSSIBLE SYSTEMS

Product	Coats	Wet Thickness	Dry thickness
Hydro Primer 40	1	120	60
Hydro RE 35	1	110	55
Total	2	230	115

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions

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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.