

TECHNICAL DATA SHEET

HYDRO RE ONE COAT 32

Water-based undercoat finishing

FEATURES

Semiglossy enamel, one component, air drying with rust inhibiting effect ideal as protective of ferrous metal substrates in both in interior and exterior. It characterized by high penetration of substrate, excellent adhesion, hardness and flexibility. It is formulated based on synthetic resins modified dispersed in water and ionic exchange pigments which have particularly good barrier effect so as to ensure good water-impermeability and an antioxidant effect. The use of specific primers to steel improves corrosion protection.

The properties of good coverage and low tendency for sagging allow easy applications with manual or mechanical tools that allow a finish characterized by uniform thickness and adequate coverage of the edges. It is also characterized by rapid drying which allows for a quick execution of the painting. It is also suitable for use immersion. Since it is water-based, 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 ideal for the protection of steel manufactures, new or undergoing maintenance, such as carpentry, fixtures, railings, barges, tanks, agricultural equipment, industrial body, subjected to the action of corrosive agents in rural, urban, industrial environments.

The thickness recommended for effective protection is established depending on the aggressiveness of the environment and it should always be applied on perfectly clean surface.

It can be applied directly on galvanized steel, alloys, aluminum, plastic, fiberglass. Before being protected the galvanizing must have a period of oxidation weathering of 2-3 months. 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 drying, 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
Specific weight	1100-1200 g/l	
Gloss level 60°	50-60	
Working temperature	<+80 °C	
VOC	<50	
Solid by weight	50 ± 2%	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1200-1300 g/l	Internal PF3
Drying Time	Fully 24 h	Internal PF2

THICKNESS AND COVERAGE

	Minimum	Maximum	Recommended
Thickness of dry film, µm	40	100	60
Thickness of wet film, µm	80	200	120
Theoretical coverage, m²/l	12,5	5	8,3
Theoretical coverage, m²/kg	10.9	4.3	7.2

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SHELF LIFE 1 year if stored in its original and unopened can at a temperature between +5°C and +30°C.

COLOUR RANGE As K7 colour sampler. 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 The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.
A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.
The better the degree of preparation, the better the corrosion performance; on surfaces with poor preparation we recommend applying the first layer with a brush produced slightly diluted to facilitate wetting and penetration of the product in order to promote better adhesion.

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.

NEW STEEL

The surface must be clean and dry, free of grease, oils and other contaminants. The blasting Sa2½ ensures the best anticorrosive performance.

SURFACES TREATED WITH SHOP PRIMER

Se integro, pulito ed esente da sporco, olio, grasso, sali ed asciutto può essere verniciato altrimenti eseguire la preparazione come per superfici rivestite.

COATED SURFACES

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).

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 spray, airless, roller, brush

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APPLY	Thinning	0-5% with water
	Conditions of application	+15°C +40°C >3°C at dew point
	Application by airless	Relative humidity: <65% 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.

DTF 50 micron		
Surface temperature	23°C	50°C
Out touch	45'	15'
Dry to touch	3h	45'
Full	24h	2h
Minimum time of over application	3h	1h

RECOMMENDED FINISHES Hydro RE, Hydro Acryl

RECOMMENDED UNDERCOATS Hydro Primer 15, Hydro Epox 40;

RECOMMENDED SYSTEM	Atmosphere C2			
	Product	Coats	Wet Thickness	Dry thickness
	Hydro RE One Coat 32	1	120	60
	Hydro RE One Coat 32	1	120	60
	Total	2	240	120

POSSIBLE SYSTEMS	Product	Coats	Wet Thickness	Dry thickness
	Hydro Primer 15	1	120	65
	Hydro RE One Coat 32	1	120	60
	Total	2	240	125

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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