ARREGHINI®
ITALIAN PAINTS SINCE 1950

INDUSTRIAL coating

TECHNICAL DATA SHEET

HYDRO OVEN

Waterbased oven finishing

DESCRIPTION	Waterborne thermosetting melamine-polyester finishing with good general performances as toughness, elasticity, chemical resistances.		
USE	It can be applied directly on steel surfaces, in order to protect electrical switchboards, little tanks, cylinders and in all those cases when it's needed to assure the artefacts particular toughness, glossy effect or high resistance, with optimized costs, when an oven drying system is available.		
PROPERTIES OF THE PRODUCT		VALUE	METHOD
	Solids by volume	45% ± 2	
	Gloss level 60°	30-40	
	Adhesion	0	UNI EN ISO 2409
SPECIFICATION DATA		VALUE	METHOD
	Specific weight	1000-1400 kg/l	Internal PF3
	Gloss	30-40	Internal PF6

FILM THIKNESS AND SPREADING RATE		Minimum	Maximum	Recommended
	Dry film thickness, µm	35	55	40
	Wet film thickness, µm	78	122	90
	Theoretical spreading rate, m^2/l	12,8	8,2	11,1
	Theoretical spreading rate, m^2/Kg	10,7	6,8	9,3

SHELF LIFE	1 year stored in its unopened original can(+5 / +35 °C)
COLOUR RANGE	Between different batch may be slightly different, it is therefore important to finish the job with the same batch.
SURFACE PREPARATION	General consideration: the surface must be dry and clean from pollutants of various kinds such as dirt, oil, salt, grease and salts. Steel and cast iron: blasting Sa 2.5 or Phospho-degreasing. Galvanized steel: Perform sweep blasting and alkali wash. Existing coating: removal of the layers by blasting Sa2,5.
TOOLS	Conventional spray, Spray Airless.

CAP ARREGHINI SpA 30026 PORTOGRUARO/VE Viale Pordenone, 80 Tel.0421 278111 Fax 0421 75498/ 0421 278115
Azienda con Sistema Certificato UNI EN ISO 9001

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APPLICATION	Diluition	0-15% water	
	Application conditions	+10°C +30°C >3°C dew point Relative Humidity: < 70%	
	Airless	Nozzle Pressure:15 MPa (150 kp/cm^2, Nozzle: 0,28 - 0,38 mm (0,018 - 0,021") Angle range; 30 - 50° Air pressure: Compression ratio 40:1 (pressure150-180 kg/cm^2)	
	Application by conventional spray	Nozzle: 1,4 – 1,7mm Angle range; 40 - 80° Air pressure: 3,5-4 kg/cm^2	
DRYING	DTF 40 micron		
		Minimum time	Temperature °C
	Drying	15'-30'	20-35
		5'-10'	50
	Cooking	20'-30'	120-130
RECOMENDED PRIMER	Epoxy ester		
RECOMENDED SYSTEM	Direct application on the support with a thickness of 40 microns dry		

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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