

PRODUCT DATA SHEET

NITROLUX 20
Nitrosynthetic glossy enamel

CHARACTERISTIC Finishing enamel gloss, pigmented, suitable for artifacts in metal, easy to apply. It is ideal for professional use as it has high filling powers, adhesion to various substrates and is fast drying, reducing painting time. It forms a finishing film with excellent visual consistency with good resistance to scratch and abrasion. It is solventbased formulated with modified nitrocellulose and alkyd resins.

USE It is used in coating of metal items such as office furniture and shelving, applied directly to the properly cleaned and degreased iron, when particular resistance is not required. Under unfavorable conditions, due to excessive humidity or high temperatures, to avoid pitting or other flaws of the film, use thinner Diluente Butol. The product can also be applied by dipping, especially on turned parts. Spray application generally takes place waiting 15-20' between the layers with the technique of wet-on-wet.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Application temperature	<+80 °C	
Flash point	27°C	
Solid by volume	45 %± 2	

TECHNICAL DATA	VALUE	METHOD
Specific weight	950-1100 g/l	Internal PF3
Gloss	80-90	Internal PF6
Drying Time	Fully 12 h	Internal PF2

THICKNESS AND YIELD	Min.	Max	Recommended
Thickness of dry film, µm	35	45	40
Thickness of wet film, µm	80	100	90
Theoretical yield, m²/l	12.5	10	11.1
Theoretical yield, m²/kg	12.2	9.8	10.9

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 The range of colors can be chosen in shades of RAL. 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 **General observation:** Surface must be dry and clean from any kind of oil, grease and salts.

Coated surface

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).

With complete finishing coat: if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

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.

PRODUCT DATA SHEET

NITROLUX 20
Nitrosynthetic glossy enamel

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 or airless spray: Nitro NV 5000 (with high temperature and humidity <40% it is possible the formation of "dusting"); in this case use Diluente Butol.

APPLICATION

Thinning	5-10% with Diluente Nitro NV5000
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: 40 - 80° 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. High thicknesses per coat and unfavorable environmental conditions slow down the drying and hardening depth.

DTF 45 micron

Surface temperature	10°C	23°C
Out touch	45'	30'
Dry touch	8h	4h
Full	24h	12h
Minimum time of over application	45'	30'

**RECOMMENDED PRIMER
RECOMMENDED SYSTEM**

Steel: Galvanized steel, aluminum, alloys: Primer 40
Primer 15, Primer 40

Product	Coat	Wet Thickness	Dry thickness
Primer 15	1	95	60
Nitrolux 20	1	90	40
Total	2	185	100

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Primer 40	1	120	60
Nitrolux 20	1	90	40
Total	2	210	100

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

PRODUCT DATA SHEET

NITROLUX 20**Nitrosynthetic glossy enamel**

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.