

PRODUCT DATA SHEET

PUR IND 56
Aliphatic polyurethane enamel

DESCRIPTION Glossy enamel, dual-component, with hardener based on aliphatic isocyanate, drying at room temperature or forced-air. Characterized by excellent flow, fullness, and weather resistance. It also has excellent resistance in corrosive, industrial and marine environments with high abrasion resistance. It catalyzes with Induritore Poliuretano MS or with Induritore poliuretano HS when a higher dry thickness with low VOC is required.

USE It is used as finishing where good aesthetic features, high mechanical resistance and to UV rays are required, such as industrial bodywork, containers, chemical plants, port facilities.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Application temperature	<+120 °C	
Flash point	25 °C ±2	
Solid by volume %	50% ±2 with Induritore Poliuretano MS 60% ±2 with Induritore Poliuretano HS	
VOC (A+B)	415 g/l with Induritore Poliuretano MS 350 g/l with Induritore Poliuretano HS	

TECHNICAL DATA

	VALUE	METHOD
Specific weight	1050-1150 g/l	Internal PF3
Gloss	>80	Internal PF6
Drying Time	Recoatable 20h; Fully 5 days	Internal PF2
Pot-life	Max 6h	Internal PF7

THICKNESS AND YIELD

By Induritore poliuretano HS	Min.	Max	Recommended
Thickness of dry film, µm	40	70	55
Thickness of wet film, µm	80	140	110
Theoretical yield, m²/l	12.5	7.1	9.1
Theoretical yield, m²/kg	10.3	5.9	7.5
By Induritore poliuretano MS	Min.	Max	Recommended
Thickness of dry film, µm	55	90	70
Thickness of wet film, µm	90	150	120
Theoretical yield, m²/l	11.1	6.7	8.3
Theoretical yield, m²/kg	9.2	5.5	6.9

SHELF LIFE

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.

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COLOUR RANGE	The range of colours 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	<p>General observation: Surface must be dry and clean from any kind of oil, grease and salts.</p> <p>Coated surface</p> <p><i>With primer:</i> 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).</p> <p><i>With complete finishing coat:</i> 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.</p> <p><i>Rusty coating:</i> 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.</p> <p><i>Localized maintenance:</i> 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.</p>	
TOOLS	Conventional spray or airless (high temperature and humidity <40% is possible the formation of "dusting"), roller, brush (for small surfaces and profiles).	
APPLICATION	Mixing ratio by weight Mixing ratio by volume Thinning Application time at 23°C Application condition Application by airless	100:40 with Induritore poliuretano MS (medium solid aliphatic catalyst) 100:20 with Induritore poliuretano HS (high solid aliphatic catalyst) 100:40 with Induritore R4 (medium solid non-yellowing aliphatic / aromatic mixed catalyst) 100:50 with Induritore poliuretano MS (medium solid aliphatic catalyst) 100:25 with Induritore poliuretano HS (high solid aliphatic catalyst) 100:50 with Induritore R4 (medium solid non-yellowing aliphatic / aromatic mixed catalyst) Ready to use 5-6 h +5°C +40°C >3°C at dew point Relative humidity: < 70% Nozzle pressure: 15 MPa (150 kp/cm²,

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	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
Thinner for washing	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. In over coating, best adhesion can be obtained when next application is done before catalysis is completed.

DTF 60 micron with Induritore poliuretano MS

Surface temperature	5°C	10°C	23°C	30°C
Out touch	2h	60'	45'	30'
Dry touch	16h	8h	4h	3,5h
Full catalysis	3 days	36h	20h	18h
Minimum time of over application	16h	8h	4h	3,5h
Maximum time of over application	5 days	3 days	48h	36h

RECOMMENDED PRIMER

Poly-acrylic, epoxy.

RECOMMENDED SYSTEM

Industrial atmosphere.

Product	Coat	Wet Thickness	Dry thickness
Epoxy Zinc 2K	1	83	50
Primer 40	1	109	60
Pur IND 56	1	110	55
Total	3	302	165

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Primer 40 HS ST	1	109	60
Pur IND 56	1	110	55
Total	2	219	115

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

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enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.