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 Poliuretanico MS or with Induritore poliuretanico HS when a higher dry thickness with low VOC is required.

USE

It is used as a topcoat where high aesthetics, mechanical strength and UV resistance are required, in the painting of industrial bodywork, containers, chemical plants, port equipment.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Application temperature	<+120 °C	
Flash point	25°C ±2	
Solid by volume %	50% ±2 with Induritore Poliuretanico MS 60% ±2 with Induritore Poliuretanico HS	
VOC (A+B)	415 g/l with Induritore Poliuretanico MS 350 g/l with Induritore Poliuretanico HS	
Pot-life	4h	Internal PF7
Drying Time	To the touch 6h; Fully 5 days	Internal PF2

TECHNICAL DATA

	VALUE	METHOD
Specific weight	1110-120 g/l	Internal PF3
Gloss	>80	Internal PF6

THICKNESS AND YIELD

By Induritore poliuretanico HS	Min.	Max	Recommended
Thickness of dry film, µm	40	70	55
Thickness of wet film, µm	80	140	110
Theoretical yield, m^2/l	12.5	7.1	9.1
Theoretical yield, m^2/kg	11.7	6.6	8.5

By Induritore poliuretanico MS	Min.	Max	Recommended
Thickness of dry film, µm	55	90	70
Thickness of wet film, µm	90	150	120
Theoretical yield, m^2/l	11.1	6.7	8.3
Theoretical yield, m^2/kg	9.9	5.9	7.4

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.

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

PRODUCT DATA SHEET

PUR IND 56
Aliphatic polyurethane enamel

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	**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. *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 o airless (high temperature and humidity <40% is possible the formation of " dusting"), roller, brush (for small surfaces and profiles).	
APPLICATION	Mixing ratio by weight	100:40 with Induritore poliuretanico MS (medium solid aliphatic catalyst) 100:20 with Induritore poliuretanico HS (high solid aliphatic catalyst) 100:40 with Induritore R4 (medium solid non-yellowing aliphatic / aromatic mixed catalyst)
	Mixing ratio by volume	100:50 with Induritore poliuretanico MS (medium solid aliphatic catalyst) 100:25 with Induritore poliuretanico HS (high solid aliphatic catalyst) 100:50 with Induritore R4 (medium solid non-yellowing aliphatic / aromatic mixed catalyst)
	Thinning	Ready to use
	Application time at 23°C	Minimun 4h
	Application condition	+5°C +40°C >3°C at dew point Relative humidity: < 70%
	Application by airless	Nozzle pressure: 15 MPa (150 kp/cm²,

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

PRODUCT DATA SHEET

PUR IND 56
Aliphatic polyurethane enamel

		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 poliuretanico 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
Epox 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

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

PRODUCT DATA SHEET

PUR IND 56
Aliphatic polyurethane enamel

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

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