

PRODUCT DATA SHEET

PUR IND 57
Industrial polyurethane enamel

CHARACTERISTIC Semi-glossy enamel, dual-component, with hardener based on aliphatic isocyanate, drying at room temperature or forced-air. It is characterized by excellent flow, fullness and weather resistance. It also has excellent resistance in corrosive, industrial and marine environments with high shock resistance.

USE It is used as finishing where high mechanical and UV resistance are required, together with a good result in the painting of industrial bodywork, containers, chemical plants, port facilities, water tankers.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Specific weight (A+B)	1200-1400 g/l	
Application temperature	< +120 °C	
Flash point	25°C ± 2	
Solid by weight %	55-57	Internal PF25
Solid by volume %	46-48	

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1500-1600 g/l	Internal PF3
Gloss	40-50	Internal PF6
Pot-life	Max 3 h	Internal PF7
Drying Time	Fully 24 h	Internal PF2

THICKNESS AND YIELD	By Induritore MS	Min.	Max	Recommended
Thickness of dry film, µm		45	59	52
Thickness of wet film, µm		95	125	110
Theoretical yield, m²/l		10,5	8,0	9,1
Theoretical yield, m²/kg		8,1	6,2	7,0

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.

Localized maintenance: perform mechanical preparation St2 or St3 followed by

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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 or airless (high temperature and humidity <40% is possible the formation of "dusting"), roller, brush (for small surfaces and profiles).

APPLICATION

Mix ratio in weight	100:25 with Induratore poliuretanico MS
Mix ratio in volume	100:30 with Induratore poliuretanico MS
Thinning	Ready to use
Application time at 23°C	Max 3h
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: 30 - 50°
	Air pressure: 3,5-4 kg/cm²
Thinner for washing	Thinner 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

Surface temperature	23°C
Out touch	30'
Dry touch	4h
Full catalysis	24h
Minimum time of over application	4h
Maximum time of over application	48
Poly-acrylic, epoxy.	

RECOMMENDED PRIMER
RECOMMENDED SYSTEM

Industrial and marine atmosphere.

Product	Coat	Wet Thickness	Dry thickness
Epoxy zinc 2K	1	80	60
Capmastic ST	1	200	120
Pur IND SL 57	1	110	52
Total	3	390	232

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ALTERNATIVE SYSTEM	Product	Coat	Wet Thickness	Dry thickness
	Epoxy zinc 2K	1	80	60
	Primer 40 HS ST	1	200	120
	Pur IND SL 57	1	110	52
	Total	3	390	232

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.