PRODUCT DATA SHEET

RE ONE COAT 32
Fast-drying synthetic enamel

CHARACTERISTIC

Semigloss enamel formulated with anticorrosive pigments zinc phosphates and alkyd resins with phenolic modification, characterized by excellent fullness, distension, low tendency to sagging and fast drying, features that allow applications which guarantee a finish with uniform thickness, adequate edge covering and fast execution of the painting.
The dried film guarantees good mechanical strength and weather resistance and can be used within a single coat as a primer finish. Best resistance still are obtained using specific undercoats.

USE

It is suitable for decoration and protection from the elements in rural, marine or industrial environments (also with intense shades) of new structures or structures undergoing maintenance, eg industrial machinery, fixtures, railings, containers, agricultural equipment and construction of substrates made of iron, galvanized iron, aluminum, alloys, appropriately pre-treated.
The application must take place in layers with wet film; apply the second layer on the wet film within 2 hours. The second layer applied on dry film should be at least 5-7 days and after trying the reaction (possible removal) on a small part. The preheating of the product to about +30°C gave good results by improving the drying, the coverage of the edges and avoiding sagging.
It can be catalyzed with 10% of induritore poliuretanico MS to improve the stackability and resistance to overcoating. It is suitable to forced drying in a hot air tunnel at 40-50 ° C. Sanding dust and / or spraying and dry paint residue should not be accumulated because they can cause spontaneous combustion.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Application temperature	< +120 °C	
Flash point	27°C	
Solid by volume	55% ± 2	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1130-1230	Internal PF3
Gloss	50-60	Internal PF6
Drying Time	Fully 12 h	Internal PF2

THICKNESS AND YIELD

	Min.	Max	Recommended
Thickness of dry film, µm	40	80	50
Thickness of wet film, µm	73	146	90
Theoretical yield, m²/l	13,7	6,8	11
Theoretical yield, m^2/kg	11.9	5,9	9.6

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.

CAP ARREGHINI SpA 30026 PORTOGRUARO/VE Viale Pordenone, 80 Tel.0421 278111 Fax 0421 75498/ 0421 278115
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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 or airless spray (with high temperature and humidity <40% it is possible the formation of "dusting"); in this case use fast drying Diluente, roller, brush with Diluente S800.

APPLICATION		
	Thinning	5-10% con thinner 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/cm^2)
	Application by conventional spray	Nozzle: 1,6 - 1,8 mm Angle range: 40 - 80° Air pressure: 3,5-4 kg/cm^2
	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. High thicknesses per coat and unfavorable environmental conditions slow down the drying and hardening depth.

DTF 50 micron

Surface temperature	10°C	23°C
Out touch	45’	30’
Dry touch	12h	6h
Full	24h	12h
Minimum time of over application	45’	30’

RECOMMENDED PRIMER	Galvanized steel, aluminum, alloys: Aridur, Chromocap W, Corroblock Steel: Primer 15, Crometal TA

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RECOMMENDED SYSTEM — Industrial atmosphere

Product	Coat	Wet Thickness	Dry thickness
Primer 15	1	95	60
Primer 15	1	95	60
RE ONE COAT 32	1	90	50
Total	3	280	170

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Crometal T.A	1	100	65
Crometal T.A	1	100	65
RE ONE COAT 32	1	90	50
Total	3	290	180

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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