

PRODUCT DATA SHEET

RE IND 37
Fast-drying synthetic enamel

CHARACTERISTIC Matt enamel characterized by excellent gloss and fullness, distension, low tendency to sagging and fast drying, features that allow applications which guarantee a finish with excellent visual consistency, uniform thickness, adequate edge covering and fast execution of the painting. The dried enamel ensures good mechanical strength and weather resistance. The dried enamel ensures good mechanical strength and weather resistance.

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 poliuretano 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	
VOC	415 g/l	

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1150-1350	Internal PF3
Gloss	0-10	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, m ² /l	13,7	6,9	11.1
Theoretical yield m ² /kg	11	5.5	8.9

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.

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PREPARATION OF SURFACE	<p>General observation: Surface must be dry and clean from any kind of oil, grease and salts.</p> <p>Coated surface <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). <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. <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. <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	<p>Conventional or airless spray (with high temperature and humidity <40% it is possible the formation of "dusting") roller, brush with Diluente S800.</p>																			
APPLICATION	<p>Thinning</p> <p>Application condition</p> <p>Application by airless</p> <p>Application by conventional spray</p> <p>Thinner for washing</p>	<p>Conventional or airless spray: 5-10% with thinner nitro NV5000 Roller, brush: 5-10% with Diluente S800 +5°C +40°C > 3°C at dew point Relative humidity: < 70% 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) Nozzle: 1,6 – 1,8 mm Angle range: 40 - 80° Air pressure: 3,5-4 kg/cm² Thinner Nitro NV 5000</p>																		
DRYING TIME	<p>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.</p> <table border="0" style="width: 100%;"> <tr> <td>DTF 50 micron</td> <td></td> <td></td> </tr> <tr> <td>Surface temperature</td> <td style="text-align: center;">10°C</td> <td style="text-align: center;">23°C</td> </tr> <tr> <td>Out touch</td> <td style="text-align: center;">45'</td> <td style="text-align: center;">30'</td> </tr> <tr> <td>Dry touch</td> <td style="text-align: center;">12h</td> <td style="text-align: center;">6h</td> </tr> <tr> <td>Full</td> <td style="text-align: center;">24h</td> <td style="text-align: center;">12h</td> </tr> <tr> <td>Minimum time of over application</td> <td style="text-align: center;">45'</td> <td style="text-align: center;">30'</td> </tr> </table>		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'
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RECOMMENDED PRIMER	<p>Galvanized steel, aluminum, alloys: Aridur, Chromocap W Steel: Primer 15, Crometal T.A</p>																			

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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 Ind 37	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 Ind 37	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.