

## PRODUCT DATA SHEET

**ACRILCAP 47 HS PC**
**Aliphatic polyurethane acrylic undercoat - finish**

**CHARACTERISTIC**

It is a satin enamel, non-yellowing and dual-component, based on hydroxylated acrylic resin and aliphatic isocyanate, drying at room temperature or forced air. The dried film is characterized by excellent elasticity, resistance to abrasion, to the attack of chemical and atmospheric agents and it ensures a long lasting colour. It also has excellent resistance in corrosive, industrial and marine environments, with high shock resistance. It catalyzes with Induritore Poliuretano MS or Induritore Pur PC in case you want to get a higher dry film thickness, with low VOC.

**USE**

It is used as a finish on bi-component undercoats, acrylic or epoxy, or as a single coat on different metals such as galvanized steel, aluminum, light alloys, plastics, where it is required high mechanical and UV resistance, and good aesthetical effect. It is indicated in the painting of industrial bodywork, containers, chemical plants, port facilities, wind farms.

**PROPERTY OF THE PRODUCT**

	VALUE	METHOD
Specific weight (A+B)	1300-1400 g/l	
Application temperature	<+120 °C	
Flash point	23°C	
Solid by volume %	62±2% with Induritore Pur PC 56±2% with Induritore Poliuretano MS	
VOC (A+B)	415 g/l with Induritore Pur PC 435g/l with Induritore Poliuretano MS	
Brilliance 60°	45-55	

**SPECIFICATION DATA**

	VALUE	METHOD
Specific weight	1350-1450 g/l	Internal PF3
Gloss	45-55	Internal PF6
Pot-life	> 6 h	Internal PF7
Drying Time	Fully 20 h	Internal PF2

**THICKNESS AND YIELD**

	By Induritore Pur PC	Min.	Max	Recommended
Thickness of dry film, µm		40	100	60
Thickness of wet film, µm		65	161	97
Theoretical yield, m²/l		15,3	6,2	10,3
Theoretical yield, m²/kg		11,3	4,6	7,6

**STOCCAGGIO**

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**

The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.

A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on

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substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself .

**HOT GALVANIZED STEEL**

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner.

Alternatively, a light silica sandblasting is recommended.

**ALUMINUM AND LIGHT ALLOYS**

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

**COATED SURFACES**

*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 temperatures and humidity <40% is possible the formation of "pouncing"), roller, brush (for small surfaces and profiles).

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APPLICATION	Mix ratio in weight	100:20 by Induritore Poliuretano MS
		100:15 by Induritore Pur PC
	Mix ratio in volume	100:25 by Induritore Poliuretano MS
		100:20 by Induritore Pur PC
	Thinning	0-5% by Diluente Poliuretano
	Application time at 23°C	Max 5 h
	Application condition	+5°C +40°C
		>3°C at dew point
		Relative humidity: <70%
	Application by airless	Nozzle pressure: 15 MPa (150 kg/cm <sup>2</sup> , 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 <sup>2</sup> )
	Application by conventional spray	Nozzle: 1,6 – 1,8mm
		Angle range: 30 - 50°
		Air pressure: 3,5-4 kg/cm <sup>2</sup>
	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				
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	3 days	48h	36h

 RECOMMENDED  
PRIMER

Steel: Polyacrylic, Epoxy  
 Galvanized steel: directly on substrate

 RECOMMENDED  
SYSTEM

Urban, industrial, marine atmosphere			
Product	Coat	Wet Thickness	Dry thickness
Cap zinc 14	1	80	60
Capmastic ST	1	200	120
Acrilcap 47 HS PC	1	96	60
Total	3	376	240

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SISTEMI POSSIBILI	Product	Coat	Wet Thickness	Dry thickness
	Primer 40	1	120	60
	Acrilcap 47 HS PC	1	96	60
	Total	3	216	120
	Product	Coat	Wet Thickness	Dry thickness
	Filler 46	1	123	90
	Acrilcap 47 HS PC	1	96	60
	Total	3	219	150

## 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.