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INDUSTRIAL COATINGS

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Water Borne Enamel NT LD extra, series 4816.000

Description and main features

Low VOC water borne enamel.

Like all water-based products, it is influenced by the drying temperature and relative humidity, therefore the structures must be protected for an appropriate time, depending on the environmental conditions, during the drying time of the product.

Recommended use: as a finish coat for steel structures on top of water borne primers, acrylic or epoxy primers where speed of drying, handling time and environmental issues are crucial. It can be applied as a single coat straight on the blasted steel

Technical data

Finish	Glossy, > 80 gloss, according to ISO 2813 (*) (**)
Color	RAL shades, other shades on request(*) (**)
Specific gravity	1,25 ± 0,05 kg/dm ³ at 23 °C, referring to 4816504 sveg green
Solid content	By weight 57 ± 3% referring to 4816504 sveg green
	By volume 46 ± 3% referring to 4816504 sveg green
VOC	6 g/Kg referring to 4816504 sveg green (*)
Viscosity	Brookfield at 23 °C (spindle 2, 0.5 RPM) : 15.000-30.000 mPas according to internal method MS 007 (*) (**)
Drying time	At 23 °C ,50% RH, good ventilation, DFT 70 µm, referring to 4816504 sveg green Touch dry: 48-60 h Hard dry: > 72 h <i>Touch dry:</i> according to internal method MS 035 based on ISO 4622 <i>Hard dry:</i> according to internal method MS 036 based on ISO 4622 (*) To reduce the hard dry time, the product can be put into the oven for 8 h at 50 °C
	<i>Drying times can vary depending on DFT and environmental conditions</i>

Thinning

Thinning	By water at application viscosity
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Application data

Method	Airless or air mix, brush, roller	
Airless or air mix	Pump ratio	30:1
	Nozzle orifice	013-015"
	Nozzle pressure	140-180 atm
	<i>Filters must fit the used nozzle.</i>	
	<i>Indicative data; it is the user's responsibility to chose the right equipment.</i>	
Suggested Primers	Water borne primer series 4812.000, Epox W primer series 7094.000, Epoxy primers series 706.000, 703.000 or 7073.000 and, further to testing, on most of the other primers.	
Application conditions	<p>Application suggested above 10°C, RH<60%. Substrate perfectly degreased or sandblasted to SA 2 ½ according to ISO 8501-1: 1988, no rain nor fog. Temperatures lower than 10°C and RH >60% can stop the film formation.</p> <p>It can be recoated by itself or with the suggested top coats after 24 h from the application and within 96 h at 20°C, 50% RH and good ventilation.</p> <p>After 96 h a surface roughening and a careful cleaning are needed before over coating.</p> <p>Data vary with DFT and environmental conditions</p>	

Recommended DFT

Recommended DFT	60-80 µm
Theretical consumption	approx. 160-220 g/m² referring to 4816504 sveg green (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	<p>ONE</p> <p><i>Some very clear shades such as RAL 1021-2004-3020 etc. may require two coats to achieve an ever coverage, mostly on dark primers and uneven surfaces.</i></p>

Specific tests

Pull-off adhesion test according to ISO 4624

≥ 1,4 MPa

Storage indications

Shelf life: 6 months provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35°C. Susceptible to frost damage.



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Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category **d)** Indoor/Outdoor water borne finishes for wood or plastic.
2010 limit = 130 g/l

(*) indicative value, depending on the color - (**) parameters subject to testing for each batch

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