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INDUSTRIAL COATINGS

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Acrylic Epoxy Enamel, series 7071.000

Description and main features

Two pack acrylic epoxy enamel.

Good wetting properties, high chemical and physical strength. Good gloss retention.

Recommended use: as a finish coat on top of an epoxy primer; it can be also applied on bare steel and, further to testing to ensure adhesion, on other metals.

Technical data

Finish	Glossy, above 80 gloss, according to ISO 2813 (*) (**)
Color	White code 7071029 - Other shades on request (*) (**)
Specific gravity	1,21 ± 0,05 kg/dm ³ at 23°C, referring to 7071029 white cured according to ISO 2811-1 (*)
Solid content	By weight 66± 3% referring to 7071029 white cured (*)
	By volume 54 ± 3% referring to 7071029 white cured (*)
VOC	340 g/kg referring to 7071029 white cured (*)
Viscosity	On the base at 23°C DIN cup n°4 : 100-120" according to ISO 2431 (*) (**)
Drying time	<i>At 20 °C ,50% RH, good ventilation, DFT 70 µm, referring to 7071029 white cured</i> Touch dry: 25-35' according to internal method MS 035 based on ISO 4622 Hard dry: 10 h according to internal method MS 036 based on ISO 4622(*)
	<i>Drying times can vary depending on DFT and environmental conditions</i>

Mixing and thinning

Mixing Ratio	By weight: 100:20 with 701100 By volume: 3,5:1 with 701100 <i>Mix carefully before and after the curing process</i>
Pot life	> 8 h at 20°C - <i>Data vary with temperature and thinning.</i>
Thinning	5-15% by Thinner 900033 or 901040 winter type 5-15% by Thinner 903015 or 901042 summer type 5-15% by Thinner 903014 slow <i>Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.</i>



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Application data

Method	Airless or air mix <i>Roller or brush application not recommended for metallic shades; for other shades specific curing agent and thinners must be used.</i>	
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 choose the right equipment.</i>		
Suggested Primers	Epoxy series 706.000, series 703.000 or series 7073.000, Vinyl Epoxy series 704.000, Intermediate Epoxy series 706.250,706.300 AR or 703.000, Acrylic primers series 773000 or series 7721000.	
Application conditions	Application suggested between 5°C and 30°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. Temperatures below 5°C and high RH can impair the film formation. The product can be over coated by itself between 12 and 72 h from the application, at 20°C, 50% RH, and good ventilation. After 72 h a surface roughening and a careful cleaning are needed before over coating. Data vary with DFT and environmental conditions	

Recommended DFT

Recommended DFT	60-80 µm
Theoretical consumption	approx. 130-180 g/m ² referring to 7071029 white cured (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE <i>Some very clear shades such as RAL 1021-2004-3020 etc. may require two coats to achieve an even coverage, mostly on dark primers and uneven surfaces.</i>

Specific tests

Salt spray test according to ISO 9227:2006

Steel samples coated by Enamel 7071000 cured with 701100 showed no defects after > 400 h.

Storage indications

Shelf life: 18 months, provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35°C.



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Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category **j)** Two component, high performance solvent based paints.
2010 limit = 500 g/l

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

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