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**Veneziani**

## INDUSTRIAL COATINGS

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### RETRON FL Enamel, series 732.000-733.000

#### Description and main features

Two pack polyurethane enamel.

Good flexibility and hardness; high chemical strength and abrasion resistance. Low resistance to acids and bases. Curing agent 600311 helps limiting the yellowing.

**Recommended use:** as a finish coat on top of an epoxy primer for the equipment and machineries painting

#### Technical data

<b>Finish</b>	Glossy, above 90 gloss, according to ISO 2813 (*) (**)												
<b>Color</b>	RAL shades - Other shades on request (*) (**)												
<b>Specific gravity</b>	1,14 ± 0,05 kg/dm <sup>3</sup> at 23°C, referring to 732221 white A/C cured; 1,16 ± 0,05 kg/dm <sup>3</sup> at 23°C, referring to 733120 RAL 7035 cured with 600311-600301 according to ISO 2811-1 (*)												
<b>Solid content</b>	<b>By weight</b> 54± 3% referring to 732221 white A/C cured; 55± 3% referring to 733120 RAL 7035 cured with 600311; 57± 3% referring to 733120 RAL 7035 cured with 600301 (*)												
	<b>By volume</b> 42± 3% referring to 732221 white A/C cured; 42± 3% referring to 733120 RAL 7035 cured with 600311; 45± 3% referring to 733120 RAL 7035 cured with 600301 (*)												
<b>Viscosity</b>	Brookfield on the base at 23°C (spindle 1, 0.5 RPM) : 1.500-3.000 mPas according to internal method MS 007 (*) (**)												
<b>Drying time</b>	<i>At 20 °C ,50% RH, good ventilation, DFT 50 µm</i>												
	<table border="1"> <thead> <tr> <th></th> <th><b>732221</b></th> <th><b>733120/600301</b></th> <th><b>733120/600311</b></th> </tr> </thead> <tbody> <tr> <td><b>Touch dry:</b></td> <td>8-15 h</td> <td>2 h</td> <td>2 h</td> </tr> <tr> <td><b>Hard dry:</b></td> <td>20-24 h</td> <td>8-15 h</td> <td>20 h</td> </tr> </tbody> </table>		<b>732221</b>	<b>733120/600301</b>	<b>733120/600311</b>	<b>Touch dry:</b>	8-15 h	2 h	2 h	<b>Hard dry:</b>	20-24 h	8-15 h	20 h
		<b>732221</b>	<b>733120/600301</b>	<b>733120/600311</b>									
<b>Touch dry:</b>	8-15 h	2 h	2 h										
<b>Hard dry:</b>	20-24 h	8-15 h	20 h										
<i>Touch dry: according to internal method MS 035 based on ISO 4622 Hard dry: according to internal method MS 036 based on ISO 4622 (*)</i>													
<i>Drying times can vary depending on DFT and environmental conditions</i>													

#### Mixing and thinning

<b>Mixing Ratio</b>	<b>Series 732000</b>
	<b>By weight:</b> 100:50 with 600015
	<b>By volume:</b> 1,6:1 with 600015
	<b>Series 733000</b>
	<b>By weight:</b> 100:40 with 600311-600301
<b>By volume:</b> 1,8:1 with 600311-600301	
<i>Mix carefully before and after the curing process</i>	



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<b>Pot life</b>	<p><b>Series 732000:</b> &gt; 8 h at 20°C  <b>Series 733000:</b> 2-3 h at 20°C  <i>Data vary with temperature and thinning.</i></p>
<b>Thinning</b>	<p>0-10% by Thinner 900033 or 901040 winter type  0-10% by Thinner 903015 or 901042 summer type  0-10% 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></p>

### Application data

<b>Method</b>	Airless o air mix <i>for brush or roller application, specific curing agent and thinners must be used.</i>	
<b>Airless or air mix</b>	<b>Pump ratio</b>	30:1
	<b>Nozzle orifice</b>	011-013"
	<b>Nozzle pressure</b>	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>		
<b>Suggested Primers</b>	Epoxy series 706.000, 706.250,706.300 AR, 703.000 or 7073.000, Vinyl Epoxy series 704.000, Retron Acrilico series 773.000. Further to testing it can be applied on most of the water borne primers	
<b>Application conditions</b>	Application suggested between 10°C and 30°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. The product can be over coated by itself any time after a surface roughening and a careful cleaning. Data vary with DFT and environmental conditions	

### Recommended DFT

<b>Recommended DFT</b>	40-60 µm
<b>Theoretical consumption</b>	approx. 110-165 g/m <sup>2</sup> referring to 732221 white A/C cured; approx. 110-165 g/m <sup>2</sup> referring to 733120 RAL 7035 cured with 600311; approx. 100-155 g/m <sup>2</sup> referring to 733120 RAL 7035 cured with 600301 (*)
<b>Practical spreading rate</b>	30-40% lower than the theoretical, by airless application.
<b>Number of coats</b>	ONE <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>



## INDUSTRIAL COATINGS

### Storage indications

Shelf life: 12 months (base only: 18 months), provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35°C.

### Usability according to DL 27.03.2006 n°161

For applications not ruled by D. lgs n° 161/2006 only

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

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