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ENAMEL RETRON FL-C, series 732.000 FL-C

General information and field of application

Polyurethane enamel two components formulated with polyesters (alkyd) resins hydroxylated , to reticulate with isocyanic aliphatic or semi-aliphatic or aromatic catalyst.

The enamel retron FL-C find it's best use as **finishing coat** on epoxy base , giving high resistance to chemical agent and preserving on time a good elasticity and hardness. So we recommend it for varnishing machines , where requested a good resistance to solvents and abrasion .

Can be used with :

Catalyst for enamel retron glossy our reference 730033 with a very low yellowing , with high speed of drying that permit to obtain a film with high hardness and glossy and find it's best use in industrial body .

With **catalyst for acrylics and synthetic RE our reference 730021** (aliphatic , not-yellowing) that permit to obtain a film more elastic and gives a good resistance to yellowing .

With **catalyst for acrylics and synthetics R.E. SA our reference 730022** (semi aliphatic if exposed to light , shows a content yellowing)

Characteristics of product

Appearance	Glossy , more than 90 gloss according to norm ISO 2813 (*) (**)
Color	All Ral colors , on demand (*) (**)
Specific weight	1,16 ± 0,05 kg/dm ³ at 23°C, referring to 732120 grey RAL 7035 catalyzed with 730033 1,13 ± 0,05 kg/dm ³ at 23°C, referring to 732120 grey RAL 7035 catalyzed with 730021-730022 according to norm ISO 2811-1 (*)
Solids	By weight 64± 3% referring to 732120 grey RAL 7035 catalyzed with con 730033; 56± 3% referring to 732120 grey RAL 7035 catalyzed with 730021-730022(*)
	By volume (solid by volume) 54 ± 3% referring to 732120 grey RAL 7035 catalyzed with 730033; 45 ± 3% referring to 732120 grey RAL 7035 catalyzed with con 730021-730022(*)
Viscosity	On first component at 23°C with flow cup n°4 : 60-120" according to norm ISO 2431 (*) (**)



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Drying	At 23 °C, 50% of relative humidity and good ventilation referring to I 732120 grey RAL 7035 to thickness of dry film of 50 µm		
	With 730033	with 730021	with 730022
	Out of print :	15 h	20-24 h
	Completely hard :	20 h	32 h
	Out of print : according to inner method MS 035 based on norm ISO 4622		
	Completely hard: according to inner method MS 036 based on norm ISO 4622 (*)		
	Drying times can vary with thickness and environmental conditions.		

Mixing ratio and dilution

Mixing ratio	By weight : 100:40 with 730033 100:30 with 730021-730022 By volume: 2,3:1 with 730033 2,7:1 with 730021-730022 <i>Make sure of the right mix of the product before and after catalyst..</i>
Pot life	About 3 h at 20 °C with 730033 More than 8 h at 20 °C with 730021-730022 <i>Unsteady data with temperature and dilution.</i>
Dilution	0-10 % with 901032 or 901040 wintry 0-10% with 903015 or 901042 summery 0-10% with 903014 delaying <i>Adapt the kind of thinner according to the environmental and applicative conditions to guarantee an out of dust not less than 5-10'.</i>

Instruction for application

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Application	Spray airless or air-mix <i>For application with roller or paint brush ask for specific thinner and catalyst.</i>	
Airless or air-mix	Compression ratio	30:1
	Nozzle	011-013"
	Exit pressure	140-180 atm
	<i>Filter has to be adapted to the used nozzle .</i> <i>Unsteady data to be value each time by the applier.</i>	
Recommended primers	Primer or intermediate epoxy series 706.000, 706.250, 706.300 AR, 703.000, 7073.000 or primer epoxy-vinyl series 704.000. Can be apply on primer retron acrylics series 773.000 and after control on most part of primer nitro mono component over-coating and water base mono and bi component .	



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Preparation of surface, application conditions and over-painting.	We recommend application with temperature ranging between 10°C and 30°C, and almost 3°C over the dew point . in neither misty or rainy atmosphere , on a perfectly clean support or on appropriate primer or intermediate coat . Can be over painted with itself an any time after appropriate cleansing or chapping of surface .
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Thickness and rendering

Recommended thickness of dry film	40-60 µm
Theoretical consumption referring to thickness of dry film	About 85-130 g/m ² referring to 732120 grey RAL 7035 catalyzed with 730033; About 100-150 g/m ² referring to 732120 grey RAL 7035 catalyzed with 730021-730022(*)
Practical rendering	40-50 % less, if correctly used, according to the form of support, over spray and difficulty to obtain a homogeneous thickness.
Number of coat to apply	One . <i>Some colors very clean and transparent as for example RAL 1021-2004-3020 etc. can require two coats to obtain a uniform covering especially on dark primers and irregular surface.</i>

Storage indications

Product is stable to storage till 18 months for retron enamel and 12 months for catalyst in a cool and dry place and **must be stored in a cover place, dry and ventilated.**

Utilization according to DL 27.03.2006 n°161

No limitation.

Belongs to category: j) Two components paint with high performance, solvent base; limit for 2007 = 550 g/l, limit for 2010 = 500 g/l

(*) Parameters can vary for each colour out of standard or upon request of customer.

(**) Parameters checked for each lot. Upon specific request of customer we can inform about inner methods for tests.

NB. This technical data sheet is a translation .The original is the italian one .



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