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INDUSTRIAL COATINGS

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RETRON ACRILICO Enamel AS, series 7724.000

Description and main features

Two pack high volume and high build, glossy polyurethane enamel
 Good wetting properties, high chemical and physical strength. Excellent flexibility, hardness; good colour and gloss retention; good resistance to weathering and to abrasion. It can be applied on steel, hot dipped galvanized steel and concrete. Curing Agent 730034 improves the chemical resistance of the product.

Recommended use: as a finish coat on top of acrylic and epoxy primers in severely corrosive environments.

Technical data

Finish	Glossy, according to ISO 2813 (*) (**)
Color	RAL shades - Other shades on request (*) (**)
Specific gravity	1,28 ± 0,05 kg/dm ³ at 23 °C, when cured according to ISO 2811-1 (*)
Solid content	By weight 76 ± 3% when cured (*)
	By volume 65 ± 3% when cured (*)
VOC	240 g/kg when cured (*)
Viscosity	Brookfield on the base at 23 °C (spindle 4, 0.5 RPM) : 20.000-60.000 mPas according to internal method MS 007 (*) (**)
Drying time	At 20 °C ,50% RH, good ventilation, DFT 75 µm Touch dry: 35 h Hard dry: 48 h <i>Touch dry: according to internal method MS 035 based on ISO 4622</i> <i>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

Mixing ratio	By weight: 100:12 with 730028 By volume: 7,1:1 with 730028 <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	0-5% by Thinner 900033 or 901040 winter type 0-5% by Thinner 903015 or 901042 summer type 0-5% 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>For brush or roller application, specific curing agent and thinners must be used. Brush or roller are not recommended for the application of metallic shades.</i>	
Airless or air mix	Pump ratio	30:1
	Nozzle orifice	011-013"
	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 primers series 706.000, 706.250, 706.300 AR, 703.000, 7073.000, Vinyl Epoxy primer series 704.000 or Retron Acrilico series 773.000 or series 7721.000. It can be applied, further to testing, on most of the one component primers and of the water based primers.	
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. It can be over coated by itself further to surface cleaning and slight roughening.	

Recommended DFT

Recommended DFT	60-100 µm
Theoretical consumption	ca. 120-200 g/m ² when cured (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE or TWO <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>

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.



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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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