



www.zetagi.it

zetagi

Veneziani

INDUSTRIAL COATINGS

Issued 10.09.2010

RETRON ACRILICO Intermediate, series 773.000

Description and main features

Two pack polyurethane intermediate.

Good wetting properties and flexibility, high chemical and physical strength. Excellent adhesion on steel, concrete, hot dipped galvanized steel and, further to testing to ensure adhesion, on most of the metals. Abrasion resistant. It can be used where optimal surface preparation is hardly achievable.

Recommended use: as an intermediate coat on zinc rich epoxy primers or inorganic zinc silicates or epoxy primers to protect surfaces and equipment in severe chemical and environmental exposure; as a primer in moderately corrosive exposure; as a finish coat (with C.A. 730021) on most of the primers.

Technical data

Finish	Satin, 15-35 gloss according to ISO 2813 (*) (**)												
Color	Standard: White, RAL 1001, RAL 6011, RAL 7032 and RAL 7035. RAL shades on request (*) (**)												
Specific gravity	1,42 ± 0,05 kg/dm ³ at 23°C, referring to 7734046 RAL 7023 cured with 730021-730022; 1,48 ± 0,05 kg/dm ³ at 23°C, referring to 7734046 RAL 7023 cured with 730027 according to ISO 2811-1 (*)												
Solid content	By weight 70±3% referring to 7734046 RAL 7023 cured with 730021-730022; 75 ± 3% referring to 7734046 RAL 7023 cured with 730027 (*) By volume 53 ± 3% referring to 7734046 RAL 7023 cured with 730021-730022; 59 ± 3% referring to 7734046 RAL 7023 cured with 730027 (*)												
VOC	250 g/kg referring to 7734046 RAL 7023 cured with 730027 (*)												
Viscosity	Brookfield on the base at 23°C (spindle 4, 0.5 RPM) : 50.000-150.000 mPas according to internal method MS 007 (*) (**)												
Drying time	At 23°C ,50% RH, good ventilation, DFT 100 µm, referring to 7734046 RAL 7023 <table border="0"> <tr> <td></td> <td>with 730021</td> <td>with 730022</td> <td>with 730027</td> </tr> <tr> <td>Touch dry:</td> <td>15 h</td> <td>15 h</td> <td>12 h</td> </tr> <tr> <td>Hard dry:</td> <td>48 h</td> <td>32 h</td> <td>30 h</td> </tr> </table> <p><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 (*)</p> <p><i>Drying times can vary depending on DFT and environmental conditions</i></p>		with 730021	with 730022	with 730027	Touch dry:	15 h	15 h	12 h	Hard dry:	48 h	32 h	30 h
	with 730021	with 730022	with 730027										
Touch dry:	15 h	15 h	12 h										
Hard dry:	48 h	32 h	30 h										



www.zetagi.it

zetagi

Veneziani

INDUSTRIAL COATINGS

Mixing and thinning

Mixing ratio	<p>By weight:100:20 with 730021-730022 100:10 with 730027 100:25 with 730021 or 100:12,5 with 730027 as a primer-finish on hot dipped galvanized steel</p> <p>By volume:3:1 with 730021-730022 6,5:1 with 730027 2,4:1 with 730021 or 5,3:1 with 730027 as a primer-finish on hot dipped galvanized steel</p> <p><i>Mix carefully before and after the curing process</i></p>
Pot life	> 8 h at 20°C - <i>Data vary with temperature and thinning.</i>
Thinning	<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</p> <p><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

Method	<p>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 as a primer-finish.</i></p>	
Airless or air mix	Pump ratio	45:1
	Nozzle orifice	015-017"
	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	<p>Zinc Rich Epoxy series 706176-706192-706220-706181, Epoxy primers series 706.000, 706.250,706.300 AR, series 703.000 or series 7073.000, Vinyl Epoxy primers series 704.000.</p>	
Suggested Topcoats	<p>Retron Acrilico series 778.000 or 777.000 or 7722.000.</p>	
Application conditions	<p>Application suggested between 5°C and 35°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. When applied on steel, a sandblasting to SA 2 ½ according to ISO 8501-1: 1988 ensures the best performance in terms of salt spray resistance. When applied on hot dipped galvanized steel, a light sand blasting or hot hydro jetting and perfect rinsing are recommended. Galvanizing has to be carried out according to ISO 1461. When applied on old paints, mechanical tool cleaning to PSt2.</p> <p>The product has no maximum over coating time. Data vary with DFT and environmental conditions.</p>	



www.zetagi.it

zetagi

Veneziani

INDUSTRIAL COATINGS

Recommended DFT

Recommended DFT	80-120 μm
Theoretical consumption	approx. 215-320 g/m ² referring to 7734046 RAL 7023 cured with 730021 or 730022 approx. 200-300 g/m ² referring to 7734046 RAL 7023 cured with 730027 (*)
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.

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

The information in this data sheet about the use of our products are based on our present scientific knowledge and practice. Zetagi accepts no commitment and / or responsibility on the final result of the work with our products. It is the customer's responsibility to verify the suitability of our products for the intended use. All the products and the advice given are subject to our general conditions of sale which we recommend you to request and read carefully. This data sheet replaces and annuls the previous ones: it is the user's responsibility to ensure that this sheet is updated prior to using the product. This data sheet is a translation; the Italian text of this document shall prevail over any translation thereof.