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RETRON ACRILICO Enamel, series 777.000

Description and main features

Two pack high gloss polyurethane enamel.

Excellent flexibility, hardness; good colour and gloss retention; good resistance to weathering. It can be applied on steel and concrete. Curing Agent 730034 improves the chemical resistance of the product.

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

Technical data

Finish	Glossy, above 85 gloss, according to ISO 2813 (*) (**)									
Color	RAL shades - Other shades on request (*) (**)									
Specific gravity	1,16 ± 0,05 kg/dm ³ at 23 °C, referring to 777029 white cured with 730021-730022 1,19 ± 0,05 kg/dm ³ at 23 °C, referring to 777029 white cured with 730027 according to ISO 2811-1 (*)									
Solid content	By weight 59 ± 3% referring to 777029 white cured with 730021-730022; 64 ± 3% referring to 777029 white cured with 730027 (*) By volume 47 ± 3% referring to 777029 white cured with 730021-730022; 52 ± 3% referring to 777029 white cured with 730027 (*)									
VOC	360 g/Kg referring to 777029 white cured with 730027 (*)									
Viscosity	On the base at 23 °C DIN cup n°4: 100-140" according to ISO 2431 (*) (**)									
Drying time	<i>At 20 °C, 50% RH, good ventilation, DFT 50 µm, referring to 777029 white</i> <table border="0"> <tr> <td></td> <td>with 730021</td> <td>with 730022-730027</td> </tr> <tr> <td>Touch dry:</td> <td>15 h</td> <td>15 h</td> </tr> <tr> <td>Hard dry:</td> <td>36 h</td> <td>30 h</td> </tr> </table> <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>		with 730021	with 730022-730027	Touch dry:	15 h	15 h	Hard dry:	36 h	30 h
	with 730021	with 730022-730027								
Touch dry:	15 h	15 h								
Hard dry:	36 h	30 h								

Mixing and thinning

Mixing ratio	By weight: 100:25 with 730021-730022 100:12,5 with 730027 from 100:25 to 100:50 with 730034 according to the type of use By volume: 3:1 with 730021-730022 6,6:1 with 730027 from 3,5:1 to 1,8:1 with 730034 according to the type of use <i>Mix carefully before and after the curing process</i>
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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>

Application data

Method	Airless o 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 chose 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 according to the environment. 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	40-60 µm
Theoretical consumption	approx. 100-150 g/m ² referring to 777029 white cured with 730021 or 730022 approx. 90-140 g/m ² referring to 777029 white cured with 730027 (*)
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 ever coverage, mostly on dark primers and uneven surfaces.</i>



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Specific tests

In optimal application conditions the product shows pendulum hardness (according to DIN 53157) 170", Erichsen deep-drawing (DIN 53156) 7 mm. Retron Acrilico Enamel shows, when over cured, an outstanding abrasion resistance according to the following TABER test (grindstone CS10, weight 100g, 1000 cycles):

- cured at 25% with 730021: 118 mg.
- cured at 50% with 730021: 60 mg.
- cured at 50% with 730034: 33 mg.

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

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