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## INDUSTRIAL COATINGS

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### RETRON ACRILICO SL Enamel, series 778.000

#### Description and main features

Two pack semi-gloss polyurethane enamel.

Excellent flexibility and hardness; good colour and gloss retention; good resistance to weathering. Excellent adhesion on steel, concrete, hot dip galvanized steel and, further to testing to ensure adhesion, on most of the metals.

**Recommended use:** in combination with hardener code 730021 and/or 730027 (both aliphatic) as a topcoat over epoxy or acrylic primers, or direct to metal on steel and hot dip galvanized steel. In combination with hardener code 730022 (semi-aliphatic) as a topcoat or direct to metal on steel. In combination with hardener code 730034 (aliphatic) to obtain improved chemical resistance against strong acids and oxidizing substances.

#### Technical data

<b>Finish</b>	Semi-gloss 45-70 gloss, according to ISO 2813 (*) (**)
<b>Color</b>	RAL shades - Other shades on request (*) (**)
<b>Specific gravity</b>	1,27 ± 0,05 kg/dm <sup>3</sup> at 23 °C, referring to 778029 white cured with 730021-730022 1,31 ± 0,05 kg/dm <sup>3</sup> at 23 °C, referring to 778029 white cured with 730027 according to ISO 2811-1 (*)
<b>Solid content</b>	<b>By weight</b> 63 ± 3% referring to 778029 white cured with 730021-730022; 67 ± 3% referring to 778029 white cured with 730027 (*)
	<b>By volume</b> 48 ± 3% referring to 778029 white cured with 730021-730022; 52 ± 3% referring to 778029 white cured with 730027 (*)
<b>VOC</b>	330 g/kg referring to 778029 white cured with 730027 (*)
<b>Viscosity</b>	Brookfield on the base at 23 °C (spindle 4, 0.5 RPM) : 50.000-150.000 mPas according to internal method MS 007 (*) (**)
<b>Drying time</b>	<i>At 20 °C ,50% RH, good ventilation, DFT 60 µm, referring to 778029 white</i>
	<b>with 730021</b> <b>with 730022-730027</b>
	<b>Touch dry:</b> 15 h                      15 h <b>Hard dry:</b> 32 h                      24 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

<b>Mixing ratio</b>	<b>By weight:</b> 100:20 with 730021-730022 100:25 with 730021 to improve the chemical-mechanical strength 100:10 with 730027 from 100:25 to 100:50 with 730034 according to the type of use <b>By volume:</b> 3,5:1 with 730021-730022
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	<p>2,8:1 with 730021 to improve the chemical-mechanical strength          7,6:1 with 730027          from 3,1:1 to 1,6:1 with 730034 according to the type of use  <i>Mix carefully before and after the curing process</i></p>
<b>Pot life</b>	> 8 h at 20 °C. <i>Data vary with temperature and thinning.</i>
<b>Thinning</b>	<p>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></p>

### Application data

<b>Method</b>	<p>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></p>	
<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>	<p>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.</p>	
<b>Application conditions</b>	<p>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.</p>	

### Recommended DFT

<b>Recommended DFT</b>	40-80 µm
<b>Theoretical consumption</b>	<p>approx. 105-210 g/m<sup>2</sup> referring to 778029 white cured with 730021 or 730022          approx. 100-200 g/m<sup>2</sup> referring to 778029 white cured with 730027 (*)</p>
<b>Practical spreading rate</b>	30-40% lower than the theoretical, by airless application.
<b>Number of coats</b>	<p>ONE or TWO  <i>Some very clear shades such as RAL 1021-2004-3020 etc. may require two</i></p>



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coats to achieve an even coverage, mostly on dark primers and uneven surfaces.

### 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 SL 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.
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### Continuous condensation test according to ISO 6270

Steel samples coated by one coat of Retron Acrilico Enamel SL cured with C.A. 730021 showed no defects after >1000 h.

### 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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