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INDUSTRIAL COATINGS

Mixing and thinning

Mixing ratio	<p>By weight: 100:20 with 701455-701462-701466 100:8,8 with 701471</p> <p>By volume: 2,6:1 with 701455-701462-701466 6,2:1 with 701471</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>5-15% by Thinner 900033 or 901040 winter type 5-15% by Thinner 903015 or 901042 summer type 5-15% by Thinner 903014 slow or when applied on top of Inorganic Zinc Silicate or Zinc Rich Epoxy <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

Airless or air mix	Pump ratio	30:1
	Nozzle orifice	013-015"
	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>	
Method	Airless or air mix <i>for brush or roller application, specific curing agent and thinners must be used.</i>	
Suggested Primers	None. It can be applied on top of Zinc Rich Epoxy series 706176-706192-706220-706181, Inorganic Zinc Silicates series 760205-760210.	
Suggested Topcoats	Retron Acrilico 777.000-778.000 or epoxy 700.000, 700.300,702.000, 705.000, 702.800 or Retron Polyurethane 732.000 or 733.000	
Application conditions	<p>With C.A. 701466 and 701471, application suggested between 0°C and 35°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. A sandblasting to SA 2 ½ according to ISO 8501-1: 1988 ensures the best performance in terms of chemical-mechanical strenght. With C.A. 701455 and 701462, 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. Temperatures lower than 5 °C can impair the film formation.</p> <p>The product can be over coated between 12 and 72 h from the application, at 20°C, 50% RH, and good ventilation. After 72 h a roughening or a careful cleaning (according to the finish coat and painting system) is needed before over coating.</p> <p>Data vary with DFT and environmental conditions</p>	



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Recommended DFT

Recommended DFT	40-60 µm
Theoretical consumption	approx. 110-170 g/m ² referring to 706020 RAL 7035 cured with 701455-701462; approx. 125-190 g/m ² referring to 706020 RAL 7035 cured with 701466; approx. 115-170 g/m ² referring to 706020 RAL 7035 cured with 701471 (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE or TWO

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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