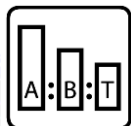


Technical data sheet

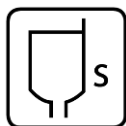
Series 731

K.731

ACRILGRIP DTM GLOSS



1000 gr +
200 gr +
50 - 150 gr (10%)



20" - 30" FORD 4
at 20 °C



Ø 1.7 - 1.9 mm
3 - 4 Atm
N° of coats 2



Drying 15' at 20 °C
At 60 °C: 45' - 60'

NATURE OF PRODUCT:

One-coat "Direct to Metal" two-component high-gloss acrylic product with a HIGH SOLID base of hydroxylated acrylic-polyurethane resins and high-quality anti-corrosive pigments, particularly suitable for direct painting of metal substrates intended for both interior and exterior use

Properties:

- High direct adhesion on various surfaces
- Good anticorrosive and covering power
- Extremely good adhesion and leveling.
- Extremely good outdoor resistance to weathering and chemicals.
- Excellent Brilliance

FIELD OF APPLICATION:

One coat glossy direct adhesion product for general use applications in industrial body shop, machine tools and/or operating machines, furniture, etc. on various types of substrates such as Steel, bare sheet metal, galvanized sheet metal, aluminum, light alloys and plastics.

PREPARATION OF THE SUBSTRATE:

- Iron and steel sheet metal:** Sandblasting grade Sa 2.5 (max. roughness 30µ), or careful sanding with suitable abrasive (P.80 - P.120) followed by degreasing with solvent.
- Galvanized sheet:** Scouring with Scotch Brite followed by degreasing with solvents.
- Aluminum and light alloys:** Sanding with P.280 - 320 followed by degreasing with solvents.

PREPARATION OF THE PRODUCT:

Comp. A:	K.731 + Coloring Pastes (Ratio 80/20 with paste P.)	100 parts by weight
Comp. B:	CZ.711 ⁽¹⁾ Standard	20 parts by weight
	CZ.720 Fast (Operating T° <20 °C)	20 parts by weight
Or:	CZ.221 ⁽²⁾	15 parts by weight
Diluent:	D.737 or D.219	5 - 15 parts by weight

⁽¹⁾ With these application methods, the product, which according to VOC regulations (Directive 2004/42/CE) belongs to the category: "Two-component high performance paints" with a max. limit of 500 gr/lit, has a VOC in the ready-to-use product of about 470 gr/lit.

⁽²⁾ With Airless or mixed air application modes, CZ.221 can be used and catalyzed at high usual and a maximum dilution of 5 percent, resulting in a ready-to-use VOC of less than 420 gr/lit.

Use CZ.221 only on sandblasted steel.

After adding the pastes and mixing them perfectly, catalyze according to the recommended ratios, then mix thoroughly until uniform color and consistency.

Dilute with our D.737 or D.219 up to the desired viscosity.

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: 2K Direct to Metal	
APPEARANCE OF THE FILM	: Glossy	
COLORS	: By choice	
DENSITY Comp. (A)	: 1,49 kg/lit (± 0,05)	
SUPPLY VISCOSITY	: 24" (± 3") Ford 8 at 25 °C	
SOLID % - VOLUME (A+B)	: 55% (± 2%)	
SOLID % - WEIGHT (A+B)	: 72% (± 2%)	
DRYING AT 20°C	: - Dry dust-free	: 10' - 15'
	: - Touch-free	: 3 hours ⁽³⁾
	: - Forced Drying	: 45' - 60' at 60 °C
RECOMMENDED LAYERS	: 2 (cross coat)	
OPACITY	: 85 Gloss (± 5)	
RECOMMENDED - DFT	: 100 - 140 µm	
POT-LIFE AT 20 °C	: 2 - 3 hours. The pot-life decreases at higher temperatures	
THEORETICAL YIELD⁽⁴⁾	: 5,5 m ² /lit or 3,9 m ² /kg at 100 µm dry	

⁽³⁾ 50 - 60 µm with catalyst **CZ.711 Standard**

⁽⁴⁾ In 80/20 ratio with our **P.900**

ACRILGRIP DTM SEMI-GLOSS/MATTE GLOSS RATIOS:

K.731 and K.734 can be mixed in any ratio to achieve the desired opacity, as per the table below:

RATIO K.734 / K.731	GLOSS (Gloss at 60 °C RAL 7035)
K.734	10 ±2
5 : 1	18 ±2
3 : 1	25 ±2
1 : 1	50 ±3
1 : 2	70 ±4
K.731	85 ±5

APPLICATION INSTRUCTIONS:

View pictograms Page 1.

RECOATING:

Wet-on-wet within 12 hours.

SAFETY REGULATIONS:

Strictly follow the instructions on the labeling and in the safety data sheet.

STORAGE CONDITIONS:

The storage room must be dry and with a temperature between +10 °C and +35 °C.

The data and information contained in this sheet are the result of our experience and accurate laboratory tests. However, since the painting process represents a set of operations that are beyond our control, they do not therefore guarantee, in any way, the final performance of the cycle.

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