Data sheet

Series 732 K.732

SEMI-GLOSS DTM ACRILGRIP

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 2/3	Drying 15' at 20 °C At 60 °C: 45' - 60'

NATURE OF PRODUCT:

HIGH SOLID two-component converter based on hydroxylated acrylic-polyurethane resins, anti-corrosive pigments and aliphatic isocyanate adduct to be mixed at the time of use.
Developed for high-thickness, single-coat direct applications on various types of metals, such as bare sheet metal, galvanized sheet metal, and aluminum.
Excellent outdoor resistance and anti-corrosion characteristics.

FIELD OF APPLICATION:

High-quality finish, particularly suitable for direct painting of metal substrates intended for both interior and exterior use.

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.732 + 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/lt, has a VOC in the ready-to-use product of about 470 gr/lt.

(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/lt.
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	: Two-component;	
APPEARANCE OF THE FILM	: Semigloss	
COLORS	: By choice	
DENSITY Comp. (A)	: 1,49 kg/lt (± 0,05)	
SUPPLY VISCOSITY	: 24" (± 3") Ford 8 at 25 °C	
SOLID CONTENT	: 77% (± 2%)	
DRYING	: - *Dry dust-free*	: 10′ - 15′ at 20 °C
	: - *Dry to touch*	: 3 hours (3)
	: - *Forced Drying*	: 45′ - 60′ at 60 °C
RECOMMENDED LAYERS	: 2 - 3 coats	
OPACITY	: 85 Gloss (± 5) depending on the color and thickness applied	
RECOMMENDED THICKNESS	: 80 - 130 µm	
POT-LIFE AT 20 °C	: 2 - 3 hours. The pot-life decreases at higher temperatures	
THEORETICAL YIELD (4)	: 5,6 m^2/lt or 4 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.732 and K.734 can be mixed in any ratio to achieve the desired opacity, as per the table below:

RATIO K.734 / K.732	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.732	85 ±5

RECOATING:

Wet-on-wet within 12 hours.
After complete curing of the film, it is necessary to sand lightly before painting.

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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