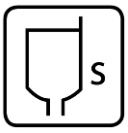
Technical data sheet

Series 731W KW731

WATER-BASED DTM GLOSS ACRYLIC

1000 gr +
250 gr +
50 - 150 gr



30"- 50" FORD 4
at 20 °C

Ø 1.4 - 1.7 mm
4 - 5 Atm
N° of coats 2

Drying: 20' - 30' at 20 °C
Curing: 24 hours at 20 °C
Curing: 40' - 50' at 60 °C

Protect from frost

NATURE OF PRODUCT:

One-coat "Direct to Metal" two-component glossy acrylic water-based product made of hydroxylated acrylic resins in water dispersion.
Properties:
-High direct adhesion to various surfaces.
-Good anticorrosive power
-Extremely good adhesion and leveling.
-Excellent outdoor resistance to weathering and chemical agents.
-Good Glossiness

FIELD OF APPLICATION:

One-coat Direct Adhesion Glossy product for general purpose applications: industrial bodywork, machine tools and/or operating machines, furniture, plastics, etc.

PREPARATION OF THE SUBSTRATE:

Water-based paint products, because of their very low organic solvent content, are characterized by poor substrate wettability, which is much less than that of conventional solvent-based products.
Therefore, the presence on the substrate of substances, such as grease, oil, grease and dirt (and of course, for other reasons, rust and calamine) is not tolerated.
Cleanliness of the substrate is a necessary and fundamental condition so that the outcome of the painting is successful.
Iron surfaces: Remove all traces of rust, scale, grease and moisture from the substrate by SA2 grade sandblasting or thorough mechanical cleaning followed by solvent degreasing.
Galvanized surfaces: Scour or sand. Degrease perfectly with organic solvents.
Aluminum: Light sanding followed by degreasing.
The product can also be applied on plastics with direct adhesion. However, a preliminary adhesion test is recommended because of the wide variety of products on the market.

PREPARATION OF THE PRODUCT:

Comp. A:	**KW731 (75/25 PW)**	100 parts by weight
Comp. B:	**CZW710**	25 parts by weight

Thoroughly mix Comp. A until uniform color and consistency. Dose Comp. B and mix the two components well (possibly with low-speed stirrer) before dilution.

Dilute successively by adding water to the desired viscosity that best suits the application system, then mix again carefully.

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: 2K WB One-coat DTM	
APPEARANCE OF THE FILM	: Gloss	
COLORS	: On request	
SPECIFIC WEIGHT Comp.(A)	: 1,05 Kg/l (± 0,05)	
SUPPLY VISCOSITY	: 27" (± 3) DIN 8 at 20 °C	
SOLID % - VOLUME (A+B)	: 44% (± 2)	
SOLID % - WEIGHT (A+B)	: 52% (± 2)	
DRYING AT 20°C	: - Dry dust-free	: 20' - 30'
	- Touch-free	: 4 - 5 hours
	- Complete curing	: 24 - 36 hours
	- Forced Drying	: 40'-50' at 60 °C
	- Maximum chemical resistance	: after 14 days
RECOMMENDED LAYERS	: 1 (cross coat)	
RECOMMENDED - DFT	: 80 - 100 µm	
THEORETICAL YIELD (*)	: 4,4 m^2/Lt or 3,8 m^2/Kg at 100 µm dry	
POT-LIFE AT 20 °C	: 45' to 2 hours depending on the colors. The pot-life decreases at higher temperatures. Under no circumstances should you apply product that has exceeded pot-life limits, as films would not ensure sufficient adhesion and chemical resistance	

(*) In 75/25 ratio with **PW900**.

APPLICATION INSTRUCTIONS:

View pictograms Page 1.

RECOATING:

Wet-on-wet or at most after 2 to 3 hours.

SAFETY REGULATIONS:

Water-based products fear frost.
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.

Rev.: 12/24