



Colorificio
Sammarinese
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c.o.e SM00026
Fully paid-up share capital
€ 3.000.000,00
Legal title
no. 26 dated 20 May 1944

COMPANY WITH
QUALITY SYSTEM
CERTIFIED BY DNV
ISO 9001

64530001 POLICRIL DTM OPACO BASE NEUTRA

two-component acrylic enamel for direct application on metal



A two-component polyacrylic enamel used as a single coat directly on metal in painting cycles where high resistance to outdoors conditions is required, in addition to excellent durability. Contains zinc phosphate as an anti-corrosive pigment.



Date of revision	04/07/2022
Composition	A two-component product with a polyurethane acrylic resin base and an aliphatic isocyanate hardening agent, with chemical cross-linking.
Main properties	<ul style="list-style-type: none">• versatile and easy to apply• high resistance to weathering• excellent adhesion on metal
Applications	Suitable as a single coat directly on metal or as a top coat in painting cycles for new constructions or for maintenance. The product can be used in a wide variety of environments such as metalworks, mechanical industries and petrochemical plants.
Colour	It can be coloured with the Colormaker Professional tinting system. The colours are available in the Colormaker Lab software.

Technical specifications (data measured at 20°C, with 65% R.H.)	Reference	UoM	Value
Specific weight (pycnometer)	C022	g/cm ³	1.420 ± 0.10 (coloured)
Ford viscosity cup no. 8	C076	s	28 ± 3 (coloured)
Gloss 60° (instrumental control)	C005	GU	15 ± 3 matt
Dry residue by volume (A+B)		%	47 ± 2 (coloured)
Adherence	ISO 2409	%	0 (zero) (zero) standardised support type Q-Panel Type S Ground
Recommended DFT	ISO 2808	microns	50-70
Recommended wet thickness		microns	105-150
Theoretical coverage		m ² /l	7-9 at the recommended thickness.
Practical coverage			Consider an appropriate loss factor.

Method of use

. Surface and application conditions	Ambient temperature min. +5°C / max. +35°C and R.H. < 80%. Temperature of the support min. +5°C / max. +35°C and at least 3°C above the dew point.
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. Catalysis ratio	POLICRIL DTM OPACO BASE NEUTRA: Catalyst 94200226, alternatively 94200301. 100:33 by volume. 100:20 by weight.
. Pot life	3 hours at 20°C.
. Application method	Airless, spraying, brush.
. Thinner	93200013.
. Dilution	Airless 3-10%, spraying 7-15%, brush 5-10%.
. Airless application	Recommended Usable nozzles 0.009-0.015" Misting pressure 120-180 atm. Compression ratio 30:1 (min.). The data for airless spraying is purely indicative and subject to adjustments. The filters must be suited to the nozzle used.
. Application by spraying	Recommended Usable nozzles 1.2-1.8 mm Misting pressure 3-4 atm. The data for spraying is purely indicative and subject to adjustments.
. Brush application	Suitable Only over reduced areas. Normally it is possible to achieve 45-50 microns.
. Mixing	This product is supplied in two different containers. 1) Mix POLICRIL DTM OPACO BASE NEUTRA (Part A) using a mechanical mixer; 2) Add the catalyst (Part B) and mix together with a mechanical mixer; 3) Dilute according to the instructions. After mixing, the product must be applied within the specified pot life.
. Hardening time	■ Values referred to recommended DTF and 65% R.H. High thicknesses, insufficient ventilation or low temperatures require longer hardening times. Maximum coat-over time: 2 months.



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Precautions and warnings

- make sure that no catalysed product remains inside the spray gun or in the painting plant;
- once the product's pot life has expired, the product is no longer usable;
- only the specified thinners must be used; refer to the "Method of use" technical data sheet section under the item "Thinner". The use of other solvents, especially for recovery, may impair the chemical-physical characteristics of the varnish film;
- try to prevent condensation effects during or immediately after application (including weather-related events), to ensure that the varnish film forms correctly;
- do not apply to a thickness of more than 100-110 microns DFT per coat, to prevent superficial defects from forming;
- this product cures with difficulty below 5°C; for optimal performance of the varnish film, temperatures above 10°C are recommended;
- if you wish to paint over POLICRIL DTM OPACO BASE NEUTRA that has exposed outdoors for a long time, make sure you remove any dirt and/or contaminants; depending on the chosen coating cycle, sanding may be required;
- POLICRIL DTM OPACO BASE NEUTRA attains its maximum chemical and physical performance upon the final polymerisation (see "Hardening times" table);
- the 94200226 catalyst is sensitive to humidity. Even minute traces of water will reduce their duration and cause defects in the coating film.

. Cleaning of equipment

Clean the equipment immediately after use with one of the following thinners:
Diluyente per Polidur 93200013 or Diluyente Nitro 92100012.

Surface preparation

IRON - STEEL

The surface should be clean, dry and free from contaminants. Before applying any coating product, one should first assess the most appropriate treatment in accordance with ISO 8504:2000.

Oil and grease must be removed in accordance with SSPC-SP1 (cleaning with solvents).

Sandblast with appropriate abrasives at grade Sa 2½ (ISO 8501-1:2007) or SSPC-SP10 - NACE No. 2.

We suggest a roughness profile (Rz) of 35-50 µm (ISO 8503-4:2012).

If any rusting occurs between sandblasting and application, repeat the sandblasting.

For moderately aggressive environments or for maintenance work, **brush** the surface using a machine tool to grade St3 (ISO 8501-1:2007).

GALVANISED STEEL

The surface should be clean, dry and free from contaminants. Before applying any coating product, one should first assess the most appropriate treatment in accordance with ISO 8504:2000.

Oil and grease must be removed in accordance with SSPC-SP1 (cleaning with solvents).

Sandblast, brush or sand the surface.



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Application cycle

Apply one or two coats directly to the prepared surface. For improved resistance to corrosion, it can be applied on epoxy or polyacrylic primers (series 6120 Epotec, 6126 Epogard HS, 6223 Policril Primer).

Compatibility of cycles

POLICRIL DTM OPACO BASE NEUTRA can be coated over with itself. For further details, contact the Colorificio Sammarinese S.p.A. Technical Support Service.

Storage

Store at temperatures between +10°C and 35°C in a dry place. The product and catalyst can be stored for up to 00 months in their original packaging.

After this time, you must check the condition of the product.

Warnings and safety

This product is provided only for professional use and for professional application technicians.

We recommend always referring to the product Safety Data Sheets for details relating to health and safety and for the storage and disposal rules.

This information is the result of our practical experience but is purely indicative. For more detailed information, please contact our technical support service. This sheet annuls and replaces any previous editions.
