

745-G 3.5 VOC

PREMIUM 1K HIGH GLOSS ANTICORROSIVE DTM

Direct to metal gloss 1K premium quality topcoat with good anticorrosive protection and high chemical resistance.

PRODUCTS

Toners	DISOLAC	15 (w)
Binder	745-G 3.5 VOC	85 (w)
Reducer	R225 – exempt VOC & 0 HAPS reducer	40-50% (v)

CHARACTERISTICS OF 745-G

Appearance	High gloss	
Gloss	>90 at 60°	
Specific weight	10 lb/gal @68°F	
Solid content (binder)	63-67 % (weight)	51-55 % (volume)
Solid content RFU (without reducer)	64-68 % (weight)	53-57 % (volume)
Dry film thickness	1.8-2.2 mils (2 coats)	
Theoretical coverage per Gallon of mixing without dilution @ 1 mil DFT	835-915 ft ²	

VOC

% reducer	VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L
0	3,2	380,9	3,0	355,0
10	3,2	380,9	2,7	322,7
20	3,2	380,9	2,5	295,8
30	3,2	380,9	2,3	273,1
40	3,2	380,9	2,1	253,6
50	3,2	380,9	2,0	236,7



*VOC in the table is an average, for specific colors check on iCrom

SUSTRATE AND PREPARATION OF THE SURFACE

	CLEAN	SANDED	FINAL CLEAN
Steel	DA93	---	DA93
Galvanized steel	DA93	---	DA93
Aluminum	DA93	---	DA93

For other substates consult with the Technical Assistance (SAT).

APPLICATION

	Application	% Reducer (Vol.)	Viscosity – 68°F (Ford Cup 4)	Pressure (psi)	Product pressure (psi)	Nozzle (mm)	Num. Of coats x dry mil	Flash off (min)
	Gravity feed spray gun	40-50%	20-25"	29-43	---	1.3-1.5	2x1	10' 68°F

If the application requires the use of an additive, it should be taken into account in the addition of solvent

DRYING

 TEMPERATURE	 TO TOUCH	TO HANDLE	DRY THROUGH
68° F (air dry)	5-10 min	4-5h	9-10h

The product reaches its maximum performance after 15 days of drying in the air (ambient temperature 64-72°F) or in a shorter time at higher temperature.

ADDITIONAL ADDITIVES FOR SPECIAL USES

SITUATION	ADDITIVE	DESCRIPTION	EFFECT
Outdoor resistance / UV filters	UV additive	Film protection against UV rays.	Increases film durability.
Sensitivity to spray / Too fast film drying	Flow additive	Improves the applicability, for example in wide superficies or drying weathers.	Increases open film time.
Resistivity adjustment	Electrostatic additive	It's used to adjust the coating resistivity according to the equipment used.	Decreases coating resistivity.
Slip / cleaning	Ultraclean additive	Increases the slip power of the film and facilitate the cleanliness.	More slip and easy to clean.

For use and instructions of the additives consult the technical data sheet of each product.

REMARKS

- Recommended to be used in ventilated spray booth at 68°F.

EQUIPMENT CLEANING

- Use a cleaning thinner before the pot life has expired.

SAFETY

- Follow instructions on product label.
- For more information check the Safety Data Sheet.
- Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

- Store the product in a ventilated place far from direct exposure to sunlight.
- Keep between 41 and 86°F.

SHELF LIFE

- One year in unopened original packaging.

These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.

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