



# BICHODUR 2K HIGH GLOSS

**PRODUCT CODE: 9253**

## Description

BICHODUR 2K HIGH GLOSS is a reactive 2-component enamel based on an acrylate resin combination with an aliphatic isocyanate hardener. Specially developed for use as a finish coating on the BICHODUR 2K DTM product lines.

## Features

- elastic/hard and scratch-resistant
- long gloss and colour retention
- high outdoor durability
- attractive high gloss finish
- air and forced drying

## Uses

2K enamel for industrial applications where high demands are placed on the quality of the finish coating, such as outdoor durability and elasticity. Also suitable as finish coating for the Bichodur 2K DTM product line. Basic Bichodur 2K High gloss is also suitable for application as a semi-transparent topcoat. In that case you should apply a hardener mixing ratio of 3:1 (base:hardener) by volume.

## Specifications

(at 20°C)  
(without spray thinning)

Finish	: High Gloss
Gloss level (60°)	: approx. 90%
Colour	: As per BICCS "BC-S"
Theoretical coverage	: approx. 13 m <sup>2</sup> /l at 40 µm dry film thickness
Specific gravity	: 1.15 g/ml
Solids content	: 64% wt. / 54% vol.
Flash point	: 25°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 410-430 g/l (supply visc.)
Shelf life in can	: min. 1 year in original unopened packaging (5 – 25°C)

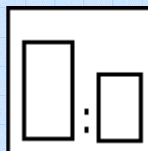
## APPLICATION INSTRUCTIONS



### Surface preparation

The surface must be completely clean, dry, and grease-free. Thoroughly sand old, intact paint layers. If in doubt about the substrate, first paint a test area and assess the adhesion.

To prevent condensation, the surface temperature must be at least 3°C above dew point.



### Mixing ratio

Tinted base : hardener 9280  
4 : 1 by volume

White enamel : hardener 9280  
3:1 by volume

### Hardener

Bichodur 2K DTM Hardener 9280

### Potlife (20°C)

3 hours

### Supply form (mixed)

70-85 sec DIN cup 4



### Viscosity and thinning

BICCS Thinner 0102, 0103, 0110 or 105  
Air spray: 15 – 25% BICCS Thinner 0102  
Airless: 5 – 15% BICCS Thinner 0102

### Air spray

Nozzle 1.2 – 1.8, 3 to 4 bar  
20 – 30 sec. DIN cup 4

### Airless

Nozzle 0.007"- 0.011"  
110 – 130 bar  
30 – 50 sec. DIN cup 4



### Spraying instructions

Two-stage spray painting recommended

### Recommended film thickness:

Min. 100 µm wet  
Min. 50 µm dry.

### Tool cleaning

Washing thinner or BICCS thinner 0102



### Drying times

Touch-dry	- approx. 45 min.
Tack free	- approx. 2.5 hours
Hard dry	- approx. 5 hours
For overcoating	- approx. 24 hours
For re-spraying	- after 10-15 min.
For sanding	- after thorough curing
Cured	- approx. 7 days

Data at 20°C and 65% RH



## Substrates

- Intact existing paint layers
- Bichodur 2K DTM product line
- Corr-O-Cryl 2K Adhesive Primer
- 2K Bipox Midcoat
- 2K Bipox HB Zinc Phosphate Primer
- 2K Wash Primer

## Additional Information

Bichodur 2K HIGH GLOSS GL90 can be obtained from the BICCS Industrial Colour System "S" in virtually every colour, and in various packaging units. The BICCS Industrial Colour System "S" colour mixing system is based on a system of (only!) 15 universal colour pastes and 2 base enamels (white and semi-transparent) enabling a consistently high coverage across the entire range of colours. The colour pastes used in the BICCS Industrial Colour System "S" are free of lead and aromatics.

## Safety

See the appropriate safety sheet

Version : 1.0  
Date of publication : 7 October 2005

The information provided in this product information sheet is based on accurate testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by BICCS, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge. The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. BICCS bv has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of the use of or reference to this data sheet, except where otherwise agreed in writing.

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Dukdalfweg 41 – 1332 BK Almere – Postall address: P.O. Box 30109 – 1303 AC Almere – The Netherlands  
Telephone: +31 (0)36 – 5492066 – Fax: +31 (0)36 – 5370286 – www.biccs.nl – Email: info@biccs.nl

## INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.