



BICHODUR 2K TOPCOAT

clear

PRODUCT CODE: 9097

Description

BICHODUR 2K TOPCOAT clear is a non-yellowing, 2 component clear topcoat based on an acrylate resin with an isocyanate hardener.

Features

- clear and non-yellowing
- tough and highly scratch-resistant
- long gloss retention
- highly chemical-resistant

Uses

As glossy and scratch-resistant clear finish coat over (industrial) coatings.

Specifications

(at 20°C)

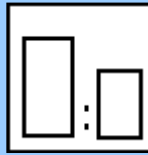
Finish	: high gloss
Gloss level (60°)	: approx. 95%
Colour	: clear transparent
Theoretical coverage	: 8.5 m ² /l at 40 µm dry film thickness
Specific gravity	: 0.94 g/ml
Solids content	: 39% wt. / 34% vol.
Flash point	: 14°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 576 g/l
Shelf life in can	: minimum 1 year in original unopened packaging (5 – 25°C)

APPLICATION INSTRUCTIONS



Surface preparation

The previous primer coat must be completely clean, dry, and free of grease and rust.
First sand old and intact paint layers.
Previously applied primers: see overcoating interval given in primer datasheet.



Mixing ratio

2 : 1 by volume

Hardener

Bichodur 2K Hardener

Potlife

6 hours



Viscosity and thinning

BICCS Thinner 0102

Approx. 10%, depending on the object, the application and the requirements.

Air spray

Nozzle 1.3 – 1.5, 3 to 4 bar
17 – 19 sec. DIN cup 4



Spraying instructions

Apply multiple cross-coats. Keep flash-off time between layers as brief as possible.

Recommended film thickness

Min. 105 µm wet
Min. 40 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

Touch-dry	approx. 30 min.
Tack free	approx. 60 min.
For re-spraying	approx. 16 hours, or after fully cured
For sanding	after curing
Cured	after. approx.. 24 hours

Data at 20°C and 65% RH



Additional Information

Various thinners can be used with the Bichodur 2K system:

BICCS Thinner 0102	standard thinner
BICCS Thinner 0103	a special thinner for large surfaces, without overspray effect
BICCS Thinner 0105	a special thinner for short drying and curing times. The potlife of the of the thinned enamel is then shortened to approx. 2 hours at 20°C and for small areas.
BICCS thinner 0106	a thinner for good flow and a very high gloss.

Safety

See the appropriate safety sheet

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INDUSTRIAL COATING & COLOURANT SYSTEMS

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