# BICHOTHANE 2K PU HB
gloss

**PRODUCT CODE: 3358**

## Description

BICHOTHANE 2K PU HB gloss is a fast-drying high-build enamel based on of polyurethane resin with an isocyanate hardener.

## Features

- elastic
- tough and highly scratch-resistant
- attractive appearance
- long gloss- and colour retention
- highly chemical-resistant
- also suitable as a spatter or effect finish

## Uses

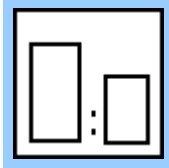
For equipment, containers, steel structures, the chassis and heavy transport sector and other industrial applications where a high film thickness is required, coupled to aesthetic requirements for the finish.

## Specifications
**(tinted product at 20°C)**

| | |
|---|---|
| Finish | : gloss |
| Gloss level (60°) | : approx. 80% |
| Colour | : using BICCS colour mixing system |
| Theoretical coverage | : 6 m²/l at 70 µm dry film thickness |
| Specific gravity | : 1.12 g/ml |
| Solids content | : 55% wt. / 42% vol. |
| Flash point | : 21°C |
| Application conditions | : min. 5°C / 80% R.H. |
| VOC content | : 506 g/l |
| 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 free of grease and rust.
First sand old and intact paint layers.



**Mixing ratio Base Enamel : hardener**
4 : 1 by volume[1]

**Hardener**
Bichothane 2K PU Standard Hardener[1]

**Potlife**
6 hours

**Viscosity and thinning**
BICCS Thinner 0102[1]
Max. 10%.

**Air spray**
Nozzle 1.8 – 2.0, 3 to 4 bar
30 – 50 sec. DIN cup 4

**Airless**
Nozzle 0.011"- 0.013"
130 – 160 bar
40 – 60 sec. DIN cup 4

**Spraying instructions**
If necessary, one or more cross-coats.

**Recommended film thickness**
Min. 160 µm wet
Min. 70 µm dry.

**Tool cleaning**
Washing thinner or BICCS Thinner 0102 or 0103

**Drying times**

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|---|---|
| Touch-dry | approx. 1 hour |
| Tack free | approx. 2 hours |
| For re-spraying | after initial drying, but within max. 4 hours or after thorough curing. |
| For sanding | after curing |
| Cured | after 4 days |

Data at 20°C and 65% RH

[1] see additional information on page 2

**Substrates**
Old intact paint layers, clean, dry, free of grease, rust and contamination and adequately roughened if necessary.
Bichothane 1K PU Filler Primer, Bicholux QD HB Body Primer or QD HB Zinc Phosphate Primer, 2K Bipox HB Midcoat, 2K Bipox HB Zinc Phosphate Primer, 2K Wash Primer, Corr-O-Cryl 2K Adhesive Primer

**Additional Information**
For almost all colours, the standard mixing ratio is 4 parts by volume to one of Bichothane Standard Hardener.
The colours clear, Ral 5002, Ral 5022 and Ral 9005, may be made up solely in combination with Bichothane 2K PU Extra Hardener, or in a mixing ratio of 2 : 1 by volume with Bichothane Standard Hardener.

Bichothane Standard Hardener may be replaced by Bichothane Extra Hardener when high demands apply for abrasion and chemical resistance, or when the colours stated above are being prepared.

The solids content of Bichothane 2K PU Extra Hardener is higher than that of Bichothane Standard Hardener. This makes Extra Hardener very suitable for use in combination with high build coatings and effect finishes, and when Bichothane 2K PU HB is to be spattered.
High film thickness can be achieved without the tendency to sag on vertical surfaces.
Effect finishes attain great hardness with Bichothane 2K PU Extra Hardener.
For mixing ratios, see also the datasheet for Bichothane 2K PU Extra Hardener.

[1]*Use of the different thinners:*

| | |
|---|---|
| BICCS Thinner 0102 | : standard thinning |
| BICCS Thinner 0103 | : slow thinning; retards the drying process |
| BICCS Thinner 0105 | : fast thinning; accelerates the curing and drying process of the mixed coating. |

For further information regarding the use, application and characteristics of the different thinners, see the Thinners chapter in this product manual.

**Safety**
See the appropriate safety sheet

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|---|---|
| Version | : 2.0 |
| Date of publication | : January 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.
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The data in this information sheet is subject to amendment, and is the result of practical experience and continuous product development.
This data sheet replaces all earlier publications, and it is therefore the responsibility of the user to make certain that this sheet is the correct version, before proceeding to use the product to which it pertains.

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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.