



BICHOTHANE 2K PU HB INDUS 40

PRODUCT CODE: 3392

Description

BICHOTHANE 2K PU HB INDUS 40 is a high build enamel based on polyester and acrylate resins with an isocyanate hardener. Suitable for use as a single-layer system on non-ferrous substrates.

Features

- tough and highly scratch-resistant
- highly chemical-resistant
- can be used as single-layer paint system especially for non-ferrous metals and various hard plastics.
- elastic

Uses

For equipment, steel structures and other industrial applications where direct adhesion to non-ferrous substrates is required.

Specifications

(tinted product at 20°C)

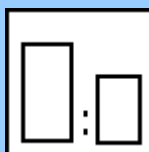
Finish	: semi matt
Gloss level (60°)	: approx. 35 – 45%
Colour	: using BICCS colour mixing system
Theoretical coverage	: 10.5 m ² /l at 50 µm dry film thickness
Specific gravity	: 1.31 g/ml
Solids content	: 69% wt. / 53% vol.
Flash point	: 23°C
Application conditions	: min. 15°C / 70% R.H.
VOC content	: 409 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

4 : 1 by volume¹

Hardener

Bichothane 2K PU MS Standard Hardener¹

Potlife

4 hours



Viscosity and thinning

BICCS Thinner 0105

Always add a minimum of 10% Thinner 0105.

The viscosity may optionally be increased using Thinner 0102.

Air spray

Nozzle 1.8 – 2.0, 3 to 4 bar
20 – 30 sec. DIN cup 4

Airless

Nozzle 0.011"- 0.013"
110 – 160 bar
40 – 60 sec. DIN cup 4



Spraying instructions

If necessary, one or more cross-coats.

Recommended film thickness

Min. 120 µm wet
Min. 50 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0105.

Drying times

Touch-dry
Tack free
For re-spraying

approx. 1 hour
approx. 2 hours
after initial drying, but within
max. 4 hours or after
thorough curing. Essential to
sand to matt after curing.
after curing
approx. 48 hours



For sanding
Cured

Data at 20°C and 65% RH

¹ see additional information on page 2



Substrates

Intact existing paint layers, dry, free of contamination and thoroughly sanded. Suitable for direct application to non-ferrous metals and hard plastics.

Additional Information

For almost all colours, the standard mixing ratio is 4 parts by volume of Base to one of Hardener.

The colours clear, Ral 5002, Ral 5022 and Ral 9005, may be made up solely in the ratio of 3 : 1 by volume of Base : Bichothane 2K PU MS Hardener.

Considering the good adhesion properties, priming is not necessary as long as the application conditions and curing time are respected. It is essential to de-grease and sand the stated substrates.

Warning/restricted applicability

Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend a single coating system that will apply to all kinds of aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

Safety

See the appropriate safety sheet

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. 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.

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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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.