BICHOTHANE 2K PU HB
semi matt

PRODUCT CODE: 3359

Description

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

Features

- elastic
- tough and highly scratch-resistant
- attractive appearance
- can be applied in thick layers
- long gloss- and colour retention
- highly chemical-resistant

Uses

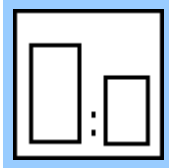
For equipment, containers, steel structures, the chassis and heavy transport sector and other industrial applications where a high film thickness is required, coupled to aesthetic requirements for the finish.

Specifications
(tinted product at 20°C)

Finish	: semi matt
Gloss level (60°)	: approx. 35%
Colour	: using BICCS colour mixing system
Theoretical coverage	: 6.3 m²/l at 70 µm dry film thickness
Specific gravity	: 1.16 g/ml
Solids content	: 58% wt. / 44% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 489 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, multiple cross-coats.

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

Tool cleaning
Washing thinner or BICCS thinner 0102

Drying times

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

[1] see additional information on page 2

Data at 20°C and 65% RH

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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 and 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*.

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 addition of Bichothane Extra Hardener will influence the gloss level.

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**
Version	:	2.0
Date of publication	:	January 2005

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