



# BICHOTHANE 2K PU SPRAY ENAMEL

## high gloss

**PRODUCT CODE: 3353**

### Description

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

### Features

- elastic
- tough and highly scratch-resistant
- attractive high gloss finish
- long gloss retention
- fast-drying
- highly chemical-resistant

### Uses

For containers, steel structures and other industrial applications where stringent aesthetic demands apply to the finish.

### Specifications

(tinted product at 20°C)

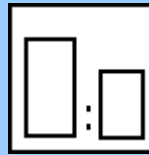
Finish	: high gloss
Gloss level (60°)	: > 90%
Colour	: using BICCS colour mixing system
Theoretical coverage	: 100.6 m <sup>2</sup> /l at 40 µm dry film thickness
Specific gravity	: 1.12 g/ml
Solids content	: 55% wt. / 43% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 505 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

### APPLICATION INSTRUCTIONS



#### Surface preparation

First sand old and intact paint layers. Apply over appropriate 2K primers, see additional information.



#### Mixing ratio base enamel : hardener

4 : 1 by volume<sup>1</sup>

#### Hardener<sup>1</sup>

Bichothane 2K PU Standard Hardener

#### Potlife

6 hours



#### Viscosity and thinning

BICCS Thinner 0102<sup>1</sup>  
Max. 10 – 15%.

#### Air spray

Nozzle 1.2 – 1.5, 3 to 4 bar  
18 – 22 sec. DIN cup 4

#### Airless

Nozzle 0.009"- 0.011"  
110 – 130 bar  
30 – 50 sec. DIN cup 4



#### Spraying instructions

Spray a thin base coat, followed by 1 – 2 cross-coats.

#### Recommended film thickness

Min. 100 µm wet  
Min. 40 µm dry.

#### Tool cleaning

Washing thinner or BICCS thinner 0102



#### Drying times

Touch-dry	approx. 30 minutes
Tack free	approx. 60 minutes
For re-spraying	after 24 hours or after total curing, (provided lightly sanded)
For sanding	after curing
Cured	approx. 4 days

<sup>1</sup> see additional information on page 2

Data at 20°C and 65% RH



## 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

2KBipox HB Zinc Phosphate Primer

2K Wash Primer

Corr-O-Cryl 2K Adhesive Primer

## Additional Information

Bichothane 2K PU high gloss Spray Enamel drying can be accelerated at up to 60°C. There is a risk of lifting with sanded existing paint layers.

For almost all colours, the standard mixing ratio is 4 parts by volume of Base to one of Hardener. For the colours Ral 5002, Ral 5022 and Ral 9005 and when applying as semi-transparent enamel, the mixing ratio of base : hardener is 2 : 1 in connection with drying and curing.

Changing the hardener (dosage) can affect the gloss level.

Extra abrasion and chemical resistance can be achieved by replacing the Bichothane Standard Hardener with Bichothane Extra Hardener. The mixing ratio base : hardener is unchanged. See also the additional information in this product data book.

### *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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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.

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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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## 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.