



# BICHOTHANE 2K PU SPRAY ENAMEL

## satin gloss

**PRODUCT CODE: 3352**

### Description

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

### Features

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

### Uses

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

### Specifications

(tinted product at 20°C)

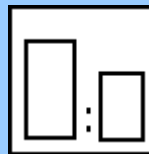
Finish	: satin gloss
Gloss level (60°)	: approx. 50%
Colour	: using BICCS colour mixing system
Theoretical coverage	: 10.4 m <sup>2</sup> /l at 40 µm dry film thickness
Specific gravity	: 1.16 g/ml
Solids content	: 56% wt. / 42% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 511 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<sup>1</sup>

#### Hardener

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 or 0103



#### Drying times

Touch-dry approx. 30 minutes  
Tack free approx. 60 minutes  
For re-spraying after 24 hours or total curing, provided lightly sanded.



For sanding after curing  
Cured after 4 days

Data at 20°C and 65% RH

<sup>1</sup> 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

Bichothane 2K PU satin 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 datasheets for the hardeners.

### <sup>1</sup> 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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Dukdalfweg 41 – 1332 BK Almere – Postall address: P.O. Box 30109 – 1303 AC Almere – The Netherlands  
 Telephone: +31 (0)36 – 5492066 – Fax: +31 (0)36 – 5370286 – www.biccs.nl – Email: info@biccs.nl

## 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.