



BICHODUR 2C DTM GL-70

PRODUCT CODE: 9258

Description

BICHODUR 2C DTM GL70 is a high quality 2 component "direct-to-metal" coating based on a non-yellowing acrylate resin combination with an aliphatic isocyanate hardener. BICHODUR 2C DTM GL70 is specially developed for use as a one-coat conservation system over various ferrous and non-ferrous metals and hard plastics.

Features

- one-coat "Direct-To-Metal" system
- excellent direct adhesion to steel, grit blasted steel, aluminium and galvanised steel
- can be applied in very thick layers
- anticorrosive
- non-yellowing
- air and forced drying
- good adhesion to various plastics

Uses

As durable 2C enamel for industrial applications where stringent demands apply for outdoor durability, hardness and wear-resistance.

Specifications

(at 20°C)
(without spray thinning)

| | |
|------------------------|--|
| Finish | : gloss 70 |
| Gloss level (60°) | : approx. 70% (colour-dependent) |
| Colour | : As per BICCS "BC-S" |
| Theoretical coverage | : approx. 13 m ² /l at 40 µm dry film thickness |
| Specific gravity | : 1.31 g/ml |
| Solids content | : 67% wt. / 53% vol. |
| Flash point | : 25°C |
| Application conditions | : min. 5°C / 80% R.H. |
| VOC content | : 415-430 g/l (supply visc.) |
| Shelf life in can | : min. 1 year in original unbroken packaging (5 – 25°C) |

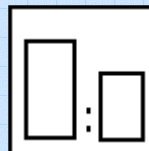
APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and grease-free. Thoroughly remove any rust, corrosion, zinc salts etc. or loose materials. We recommend grit blasting (SA2½) or machine sanding the substrate, plus degreasing with a suitable agent for the substrate in question. Thoroughly sand old, intact paint layers. If in doubt about the substrate, first paint a test area and assess the adhesion.

To prevent condensation, the surface temperature must be at least 3°C above dew point.



Mixing ratio

Tinted base : hardener 9280
6 : 1 by volume

Hardener

Bichodur 2C DTM Hardener 9280

Pot life (20°C)

4 hours

Supply form (mixed)

60-100 sec DIN cup 4



Viscosity and thinning

BICCS Thinner 0102

Air spray: 15 – 25% BICCS Thinner 0102

Airless: 5 – 15% BICCS Thinner 0102

Air spray

Nozzle 1.2 – 1.8, 3 to 4 bar
25 – 30 sec. DIN cup 4

Airless

Nozzle 0.009"- 0.011"
150 – 180 bar
30 – 50 sec. DIN cup 4



Spraying instructions

1 – 2 cross-coats.

Recommended film thickness:

Min. 180 µm wet
Min. 75 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

| | |
|-----------------|----------------------|
| Touch-dry | - approx. 60 min. |
| Tack free | - approx. 2 hours |
| Hard dry | - approx. 4 hours |
| For overcoating | - approx. 24 hours |
| For re-spraying | - approx. 10-15 min. |
| For sanding | - approx. 24 hours |
| Cured | - approx. 5 days |

Data at 20°C and 65% RH



Substrates

Steel, grit blasted steel and thermally zinc-plated steel (galvanised, Senzimir zinc-plating), electrolytically galvanised steel (Zincor, Metalco), aluminium, stainless steel, synthetics (Trespa, hard PVC, polyester, HD polyethylene, ABS, polypropylene).

Warning/restricted applicability

Because of the diversity of metal alloys in the market, plus the widely-ranging composition of synthetic materials, in case of doubt as to the properties of a substrate, we recommend that you first paint a test area, and carefully assess the suitability of the DTM system for the substrate in question.

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.

Additional Information

Bichodur 2C DTM can be obtained from the BICCS Industrial Colour System "**S**" in virtually every colour, and in various packaging units. The BICCS Industrial Colour System "**S**" colour mixing system is based on a system of no more than 15 universal colour pastes and a 2-base enamel system (white and clear), ensuring a consistently high hiding power across the entire colour range. The colour pastes used in the BICCS Industrial Colour System "**S**" are free of lead and aromatics.

Safety

See the appropriate safety sheet

Version : 1.0
Date of publication : Nov 2007

The information provided in this product data sheet is based on precision 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 using or referring to this data sheet, except where otherwise agreed in writing.

The information in this data 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 for the product, before starting to use the product.



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.