



BICHODUR 2C SATIN GLOSS TOPCOAT

PRODUCT CODE: 9297

Description

BICHODUR 2C SATIN GLOSS TOPCOAT 9297 is a 2 component metal protection enamel for stainless steel (INOX) based on high quality acrylate resin and an isocyanate hardener.

Provided it is applied as a thin film (approx. 40 microns), Bichodur 2C Satin Gloss Topcoat 9297 offers maximum protection without detracting from the attractive look of the stainless steel substrate. Contamination, such as fingerprints, is easy to remove.

Bichodur 2C Satin Gloss Topcoat 9297 can likewise be used on various other metal types but can also serve as a clear satin gloss top coat on durable 2 component paint systems.

Features

- Durable 2C satin gloss top coat for protection of stainless steel (INOX) and other types of metal.
- Preserves the aesthetically attractive uncoated stainless steel look
- Weather-resistant; suitable for both indoor and outdoor applications.
- The coated surface is easily cleaned.
- non-yellowing
- also suitable for other non-ferrous metal types

Uses

As a durable top coat for maximum protection of various types of metal.
Suitable for applications with high demands for durability, hardness and wear-resistance.

Specifications

(at 20°C)
(without spray thinning)

Finish	: satin gloss
Gloss level (60°)	: approx. 50%
Colour	: As per BICCS "BC-S"
Theoretical coverage	: approx. 12 m ² /l at 40 µm dry film thickness
Specific gravity	: 1.32 g/ml
Solids content	: 67% wt. / 50% vol.
Flash point	: 25°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 430-445 g/l (supply visc.)
Shelf life in can	: min. 1 year in original unbroken packaging (5 – 25°C)

APPLICATION INSTRUCTIONS

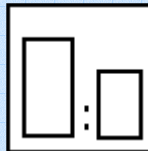


Surface preparation

The surface must be completely clean, dry, and grease-free. Thoroughly remove any rust, corrosion, zinc salts etc. We recommend grit blasting (SA2½) or machine sanding the substrate, plus de-greasing 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. See the additional information on the 2nd page.

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



Mixing ratio

Base : hardener 9280
3 : 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: 25 – 30% 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:

Max. 80 µm wet
Max. 40 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

Touch-dry	- approx. 30 min.
Tack free	- approx. 1 hour
Hard dry	- approx. 2.5 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



Important/procedure

The final result is largely dependent on meticulous substrate preparation and working methods.

If the composition of the metal permits, and this does not negatively affect the aesthetic character, it is strongly recommended to grit-blast, sand or scotch the substrate.

You must thoroughly de-grease the substrate using a suitable de-greasing product, such as BICCS Thinner 0104 or BICCS non-ferrous cleaner. If waterborne BICCS non-ferrous cleaner is used, you must copiously rinse the surface with clean tapwater and allow it to dry.

You will mostly need to thin Bichodur 2C Satin Gloss Topcoat 9297 by 20 to 40% with BICCS Thinner 0102 in order to apply a virtually invisible protective layer to stainless steel. We recommend pre-spraying the object, then spraying the top coat as a single layer with a maximum dry film thickness of 40 microns.

Because of the great diversity of stainless steel types (there are several hundred), you should always first paint a test area to check the methods of preparation and paint application. Be alert to materials that have undergone a specific treatment such as grinding, brushing and polishing, and/or a chemical surface preparation. In particular, inspect those points where the metal has been handled by means such as welding and laser cutting. The wrong choice may lead to insufficient adhesion.

Substrates

SS (stainless steel) and various other non-ferrous metal types. Also applicable as a clear top coat in durable 2 component paint systems.

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

Safety

See the appropriate safety sheet

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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.



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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.