



# BICHOthane 2C-PU SPRAY ENAMEL SILK GLOSS

*2C spray enamel silk gloss based on PU/isocyanate resins*

## Description

Bichothane 2C-PU Spray Enamel Silk Gloss [3352] is a solvent based spray enamel silk gloss based on polyurethane resins combined with an aliphatic isocyanate hardener.

## Properties

- Elastic
- Fine silk shiny appearance
- Good hardness and scratch resistance
- Long gloss and colour retention
- Good chemical resistance
- Fast drying
- Suitable for spraying
- Bichothane 2C products are lead and chromate free
- Available in all colours by the BC-S 8200 CMS

## Typical Applications

Suitable for various heavy industrial applications such as machinery, vehicles, steel and other structures that have to meet stringent requirements.

## Substrates

- Several Bipox 2C epoxy Primers
- Bipox 2C HB Midcoat [6145]
- Several Bicholux QD Primers
- Bichothane 1C-PU Filler Primer White [9047]

## Technical Specifications

(ready mixed product at 20°C)

Finish	: silk gloss
Gloss level (°)	: ca. 50% (depending on colour)
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 10,4 m <sup>2</sup> /ltr. at 40 µm DFT
Specific gravity	: 1,16 g/ml (depending on colour)
Solids content	: 56% by weight / 42% by volume
Flashpoint	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 487 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

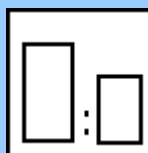
## APPLICATION INSTRUCTIONS



### Pre-treatment

The surface needs to be entirely clean, dry and degreased. Old, intact paint layers need to be abraded/sand papered. Pre-treatment (also) depends on the substrate, but in any way needs to be done in such a way that a solid and suitable substrate is obtained, suitable to be painted.

See the additional info in this sheet. Please contact our Technical Department for further enquiries.



### Mixing ratio BC-S Colourants, 8200 series:

Add 20% BC-S Colourants (by volume)

### Mixing ratio Hardener

Hardener : Bichothane 2C PU ST Hardener [3380]  
Mixing ratio : 4:1 by volume (base:hardener)  
Potlife : ca. 6 hours at 20°C

**Pay attention!** Basecoat and hardener have to be mixed carefully mechanically on the right scale. Because of quality loss, do not use products after expired potlife.

### Viscosity and thinning

BICCS Thinner 0102 [9162]  
Max. 10 – 15%.



### Airspray

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

### Airless

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



### Spraying instructions

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

### Recommended film thickness

Min. 100 µm WFT > 40 µm DFT

### Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]



### Drying times

Dust-free : approx. 30 minutes  
Tack-free : approx. 60 minutes  
For re-spraying : after 24 hours or after curing (a little sanding is then required)  
For sanding : after curing  
Hard drying time : after 4 days

Data at 20°C and 65% RH



## Additional information

Bichothane 2C-PU Spray Enamel Silk Gloss [3352] can be dried faster to a temperature of 60°C. In case of old, abraded paint layers there is a risk of burning particles. Almost all colours need a fix ratio of 4 volumes base and 1 volume hardener. The Ral 5002, Ral 5022 and Ral 9005 colours as well as for work up as blank varnish need a ratio of base:hardener 2 : 1. This because of drying and hardening.

Pay attention! Changing dosage of hardener can influence gloss rate.

Extra scratch and chemical resistance can be achieved by replacing Bichothane 2C PU Standard Hardener [3380] by Bichothane 2C PU Extra Hardener [3381]. Base:hardener ratio remains equal.

### Use of different thinners:

BICCS Thinner 0102 [9162] : standard thinner  
BICCS Thinner 0103 [9163] : slow thinner; slows down the drying process/prevents respraying  
BICCS Thinner 0105 [9165] : reactive thinner; speeds up the curing and drying process

(<sup>1</sup>) Due to variable pigment content of/in the colour pastes, gloss degree of the end product may vary somewhat. Data in our datasheets are based on the average gloss degree of the RAL K7 colours, measured under an angle of 60° according to ISO 2813.

## Pre-treatment

To prevent recurrent corrosion, the object/item needs to be coated immediately after blasting/grinding/degreasing. If there is any doubt about what's beneath the surface and/or about the pre-treatment, you always must do a trial to judge adhesion.

## Application conditions

Data in this publication are based on a temperature of 20°C and a RH of 65%. In case of higher film thicknesses and/or lower temperatures, longer drying times apply. During application and drying, avoid temperatures lower than 10°C and an RH higher than 80%. The temperature of the object to be sprayed must be at least 3°C above dew point. See the dew point table on the download page of our website ([www.biccs.nl](http://www.biccs.nl)). Good ventilation is required during application and drying.

## Safety

Only for professional use. See the appropriate safety datasheet, downloadable from our website: [www.biccs.nl](http://www.biccs.nl).

*For more information about this product please contact our laboratory by phone or email.*

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.

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