



BICHODUR 2C BRUSH ENAMEL HIGH GLOSS

2C brushing enamel based on polyester/isocyanate resins

Omschrijving

Bichodur 2C Brush Enamel High Gloss [9223] is a high quality solvent based 2C enamel high gloss for brushing application, based on specific polyester resins in combination with an aliphatic isocyanate hardener.

A unique feature of this enamel is its excellent flow. This enamel can therefore extremely easily be applied by brush, paint roller and by spraying.

Bichodur 2C Brush Enamel High Gloss [9223] along with the BICCS BC-S IC System (8200-series) can produce all available colours. Can also be processed as a clearcoat.

Properties

- Optimal flow, to be applied by brush or paint roller
- High hardness and scratch resistance
- Highly chemical resistant
- Excellent colour and gloss retention
- Good (direct) adhesion to various plastics (no primer needed)
- Bichodur 2C products are lead and chromate free
- Available in all colours of the BC-S 8200 CMS

Typical Applications

Suitable for widely ranged industrial applications that have to meet high standards (concerning load and durability) of a 2C paint system, in cases in which spraying is not possible.

Bichodur 2C Brush Enamel High Gloss [9223] is very suitable as a topcoat, in combination with (for example) Bipox 2C HB Zinc Phosphate Primer on steel, galvanized steel, aluminium, plastic, polyester, etc.

Technical Specifications

(ready mixed product at 20°C)

Finish	: high gloss
Gloss level (1)	: approx. 85-95% (depending on colour)
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 8,6 m ² /ltr. at 50 µm DFT
Specific gravity	: 1,2 g/ml (depending on colour)
Solids content	: 53% by volume
Flashpoint	: 45°C
Application conditions	: min. 15°C / 80% R.V.
VOC content	: 503 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

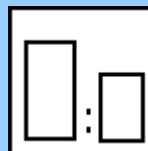
APPLICATION INSTRUCTIONS



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 30% BC-S Colourants (by volume)

Mixing ratio Hardener

2:1 by volume (base:hardener)

Hardener

[9229] Hardener Bichodur 2K Brush Enamel
Potlife: ca. 3 hours at 20°C.

Pay attention! *Basecoat and hardener have to be mixed carefully mechanically on the right scale. Then, let the created product repose for 30 minutes (induction time) before being used. If necessary dilute after induction time. Because of quality loss, do not use products after expired potlife.*



Brush/paint roller-application:

Thinner : BICCS Thinner 0130 [9130]

Viscosity : 55 sec. DIN cup 4

N.B.: use a fine foam roller or short mohair roller (solvent-resistant quality)



Spray application:

Thinner : BICCS Thinner 0130 [9130]

Airspray : nozzle 1.2 – 1.4 (pressure: 2 to 3 bar)

Viscosity : 18 – 20 sec. DIN cup 4

N.B.: first spray a thin layer, followed by multiple cross-coats

Recommended film thickness

Min. 75-100 µm WFT <> 40-80 µm DFT

Tool cleaning:

Washing thinner or BICCS Thinner 0104 [9164]



Drying times

Dust-free : approx. 2 hours

For re-painting : approx. 24 hours

Hard drying time : after 5 days

Data at 20°C and 65% RH



Additional information

System Advice

Pre-treatment (*)

<i>Steel</i>	Blasting SA 2,5 according to ISO 8501-1 or brush mechanically to cleanliness level ST3. Remove dirt and dust, then apply primer immediately to prevent corrosion.
<i>Thermally zinc-plated steel</i>	Degrease, sandpaper and remove zinc corrosion (zinc salts) using water and <i>Scotch-Brite</i> [™] . Remove dirt and dust from surface. Then apply primer.
<i>Polyester</i>	Sandpaper carefully using grain P220-P280, remove dirt and dust, then degrease. Apply Bichodur 2C Brush Enamel High Gloss [9223].
<i>Intact old paint layers</i>	Sandpaper with grain P120-P180, then remove dirt and dust and degrease. But only if the substrate is in good shape and suitable to be painted with a 2C Coating System! Apply Bichodur 2C Brush Enamel High Gloss [9223].

(*) 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. To prevent recurrent corrosion/contamination, 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.

(*) *Warning/restricted applicability*

Because of the diversity in combinations of materials on the market, one always (especially when one is in doubt about or unfamiliar with the substrate/surface) has to test whether a product is suitable for a specific substrate/surface or not.

(¹) 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

During application and drying is a minimum temperature of 15 ° C is required.

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%. 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). 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.

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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