



BICHODUR 2C HIGH GLOSS-98

2 component spray enamel based on an acrylic/isocyanate resin

Description

Bichodur 2C High Gloss-98 [9253] is a solvent containing enamel, based on a non-yellowing acrylic resin combination with an aliphatic isocyanate hardener.

Properties

- Elastic/Good hardness and scratch resistance
- Long gloss and colour retention
- Good weather resistant
- Fine shiny, glossy appearance
- Air- and forced drying
- Suitable for spraying
- Bichodur 2C products are lead and chromate free
- Available in all colours of the BC-S 8200 CMS

Properties

Long lasting industrial 2C top coat, suitable for various heavy industrial applications such as machinery, vehicles, steel and other structures having to meet stringent requirements on elasticity and outdoor durability.

Also suitable as a top coat in combination with the Bichodur 2C DTM products, when high gloss level is needed.

Substrates

- Bipox 2C (epoxy) products
- Bichodur 2C (DTM) products
- Intact old paint layers
- See the additional information in this sheet

Technical Specifications

(ready mixed product at 20°C)

Finish	: high gloss
Gloss level (1)	: approx. 98% (depending on colour)
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 15 m ² /ltr. at 40 µm DFT
Specific gravity	: 1,11 g/ml (depending on colour)
Solids content	: 68% by weight / 60% by volume
Flashpoint	: 25°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 350-360 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

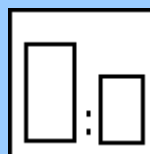
APPLICATION INSTRUCTIONS



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 : BICHODUR 2C HARDENER [9281]

Mixing ratio : 4:1 by volume (base:hardener)

Potlife : ca. 3 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 0110 [9110]

Airspray : 20 – 30%

Airless : 20 – 30%



Airspray

Nozzle : 1.2 – 1.8

Pressure : 3 to 4 bar

Viscosity : 20 – 30 sec., DIN cup 4

Airless

Nozzle : 0.009"

Pressure : 110 – 130 bar

Viscosity : 20 – 30 sec., DIN cup 4



Spraying instructions

Preferably in 2 cross-coats

Recommended film thickness

Min. 100 µm WFT < 50 µm DFT

Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]



Drying times

Dust-free : approx. 3 hours

Tack-free : approx. 5 hours

Dry to touch : approx. 6 hours

For re-painting : approx. 24 hours

For re-spraying : approx. 10-15 minutes

For sanding : after curing

Hard drying time : after 5 days



Additional information

To protect metal objects (both ferrous as non-ferrous) by using a durable, non-yellowing, 2 component blanc top coat, we advise Bichodur 2C Topcoat Silk Gloss [9297]. This product is also suitable as a clearcoat (silk gloss) in a multiple layer paint system. Productvariant(s): Bichodur 2C Topcoat Matt [9291].

Use of different thinners:

BICCS Thinner 0105 [9165] : reactive thinner; speeds up the curing and drying process

(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.

Bichodur 2C High Gloss-98 [9253] can also be used as a clearcoat. Then, mixing ratio 3:1 (base:hardener) needs to be Applied (hardener = Bichodur 2C Hardener [9281])

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%. 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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