



BICHODUR 2C DTM GLOSS-70

2C "direct-to-metal" coating based on acrylic/isocyanate resins

Description

Bichodur 2C DTM Gloss-70 [9258] is a high quality 2 component "direct-to-metal" coating based on a non-yellowing acrylic resin combination with an aliphatic isocyanate hardener.

Bichodur 2C DTM Gloss-70 [9258] is developed specifically for use as a one-layer conservation system (no primer needed) on various ferrous and non-ferrous metals and hard plastics.

Can also function well as high-quality corrosion resistant primer in durable multi-layer coating systems.

Properties

- One-layer "Direct-To-Metal" system
- Excellent direct adhesion to steel, grit blasted steel, aluminium and galvanised steel
- High build; can be applied easily in thick layers
- Anti-corrosive
- Non-yellowing
- Air- and forced drying
- Good adhesion to various plastics
- Suitable for spraying
- Bichodur 2C products are lead and chromate free
- Available in all colours of the BC-S 8200 CMS

Typical Applications

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

Substrates

- (grit blasted) Steel
- Non-ferrous metals
- Various (hard) plastics
- See also the additional information in this sheet

Technical Specifications

(ready mixed product at 20°C)

Finish	: gloss
Gloss level (!)	: ca. 70% (depending on colour)
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 13 m ² /ltr. at 40 µm DFT
Specific gravity	: 1,31 g/ml (depending on colour)
Solids content	: 67% by weight / 53% by volume
Flashpoint	: 25°C
Application conditions	: min. 5°C / 80% R.V.
VOC content	: 415-430 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

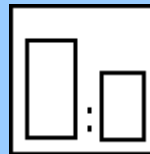
APPLICATION INSTRUCTIONS



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 [9280]
Mixing ratio : 6:1 by volume (base:hardener)
Potlife : ca. 4 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]

Airspray : 15 – 25%
Airless : 10 – 15%

Airspray

Nozzle : 1.5 – 1.8
Pressure : 3 to 4 bar
Viscosity : 25 – 30 sec., DIN cup 4



Airless

Nozzle : 0.011" - 0.013"
Pressure : 150 – 180 bar
Viscosity : 30 – 50 sec., DIN cup 4

Spraying instructions

1 – 2 cross-layers

Recommended film thickness

Min. 180 µm WFT < > 75 µm DFT



Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]

Drying times

Dust-free : approx. 60 minutes
Tack-free : approx. 2 hours
Dry to touch : approx. 4 hours
For re-painting : approx. 24 hours
For re-spraying : approx. 10-15 minutes
For sanding : approx. 24 hours
Hard drying time : after 5 days





Additional information

(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.

Substrates

Steel, grit blasted steel and thermally zinc-plated steel (galvanised, Sendzimir zinc-plating), electrolytically galvanised steel (Zincor, Metalco), aluminium, stainless steel, synthetics (HPL (Trespa), hard PVC, polyester). Especially when one is in doubt about or unfamiliar with the substrate, one always has to test whether a product is suitable for a specific substrate or not.

Warning/restricted applicability

Because of the diversity of metal alloys in the market, plus the widely-ranging composition of synthetic materials (and in case of doubt about 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 one 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.

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

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). 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.

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.