

INDICATIVE OVERVIEW OF BICCS PAINT SYSTEMS IN ACCORDANCE WITH NEN-EN-ISO 12944-2.

(steel, galvanized steel, aluminium/stainless steel, plastics, MDF/chipboard and old paint layers)



The right paint system for every surface!



Note: The paint systems for steel in this brochure are based on the international standard NEN-EN-ISO 12944-2 according to corrosion categories C1 (very low) to C5 industrial and C5 maritime (very high).





SUBSTRATE: STEEL

Interior Exterior



The paint systems below are indicative examples of the various options for steel preservation in accordance with the NEN-EN-ISO 12944-2 standard. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

CORROSIVITY CATEGORY

C2 - low

Environment example:

Buildings which are not heated, where condensation may occur e.g. storage facilities, sports halls Atmospheres contaminated to a small extent, mainly rural regions.

Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	alkyd (OH)	system: BICHOLUX HB COATING SEMI MATT-30	[1156]	80 µm
				DFT:	80 µm
	brush	alkyd (OH)	primer: B.I.K. ANTI-CORROSIVE PRIMER LIGHT GREY	[9522]	40 µm
	brush	alkyd (OH)	topcoat: B.I.K. ENAMEL HIGH GLOSS	[9533]	40 µm
Low:				DFT:	80 µm
2 - 5 years	spray	alkyd (WG)	system: AQUA 1C SYSTEM-COATING SILK GLOSS	[5256]	80 µm
				DFT:	80 µm
	brush	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER	[5048]	40 µm
	brush	alkyd (WG)	topcoat: AQUA 1C BICHOLUX ENAMEL HIGH GLOSS	[5253]	40 μm
				DF1:	80 µm
Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
Estimated life	Application:	Type of Paint: alkyd (OH)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER	[1243]	Thickness (DFT): 80 μm
Estimated life	Application: spray spray	Type of Paint: alkyd (OH) alkyd (OH)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS	[1243] [1253]	Thickness (DFT): 80 μm 40 μm
Estimated life Medium:	Application: spray spray	Type of Paint: alkyd (OH) alkyd (OH)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS	[1243] [1253] DFT:	Thickness (DFT): 80 μm 40 μm 120 μm
Estimated life Medium: 5 - 15 years	Application: spray spray brush	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER	[1243] [1253] DFT: [5048]	Thickness (DFT): 80 μm 40 μm 120 μm 80 μm
Estimated life Medium: 5 - 15 years	Application: spray spray brush brush	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG) alkyd (WG)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER topcoat: AQUA 1C SYSTEM-COATING MATT	[1243] [1253] DFT: [5048] [5255]	Thickness (DFT): 80 μm 40 μm 120 μm 80 μm 40 μm
Estimated life Medium: 5 - 15 years	Application: spray spray brush brush	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG) alkyd (WG)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER topcoat: AQUA 1C SYSTEM-COATING MATT	[1243] [1253] DFT: [5048] [5255] DFT:	Thickness (DFT): 80 μm 40 μm 120 μm 80 μm 40 μm 120 μm
Estimated life Medium: 5 - 15 years Estimated life	Application: spray spray brush brush brush	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG) alkyd (WG) Type of Paint:	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER topcoat: AQUA 1C SYSTEM-COATING MATT BICCS Paint System: BICCS Paint System:	[1243] [1253] DFT: [5048] [5255] DFT:	Thickness (DFT): 80 μm 40 μm 120 μm 80 μm 40 μm 120 μm 120 μm
Estimated life Medium: 5 - 15 years Estimated life	Application: spray spray brush brush brush	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG) alkyd (WG) Type of Paint: alkyd (OH)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER topcoat: AQUA 1C SYSTEM-COATING MATT BICCS Paint System: primer: primer: BICHOLUX QD HB ZINC PHOSPHATE PRIMER	[1243] [1253] DFT: [5048] [5255] DFT: [1243]	Thickness (DFT): 80 μm 40 μm 120 μm 80 μm 40 μm 120 μm Thickness (DFT): 80 μm
Estimated life Medium: 5 - 15 years Estimated life	Application: spray spray brush brush brush spray spray	Type of Paint: alkyd (OH) alkyd (OH) alkyd (WG) alkyd (WG) Type of Paint: alkyd (OH) alkyd (OH)	BICCS Paint System: primer: BICHOLUX QD HB BODYPRIMER topcoat: BICHOLUX QD SPRAYCOATING GLOSS primer: AQUA 1C BICHOLUX PRIMER topcoat: AQUA 1C SYSTEM-COATING MATT BICCS Paint System:	[1243] [1253] DFT: [5048] [5255] DFT: [1243] [1256]	Thickness (DFT): 80 μm 40 μm 120 μm 40 μm 120 μm 120 μm Thickness (DFT): 80 μm 80 μm

AQUA 1C BICHOLUX PRIMER RAL1013

AQUA 1C SYSTEM-COATING SILK GLOSS

BIPOX 2C HB ZPH PRIMER RM1013 (4:1)

AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)

topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)

topcoat: BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)

Note: SB = solvent based WB = water based DFT = dry film thickness

alkyd (WG)

alkyd (WG)

2K epoxy (OH)

2K acrylic (OH)

2K epoxy (WG)

2K pu (WG)

primer:

topcoat:

primer:

primer:

Depending on the product, the dry film thicknesses for primer, topcoat, etc. must be applied in one or more layers

brush

brush

spray

spray

brush

brush

High:

> 15 years



[5048]

[5256]

[6146]

[9243]

[5045]

[5055]

DFT:

DFT:

DFT:

80 µm

80 µm

160 µm

80 µm

80 µm

160 µm

80 µm

80 µm

160 µm



When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

The second part of the NEN-EN-ISO 12944 standard describes the corrosion protection of steel by means of paint systems based on various corrosion load categories. This is based on the cleanliness level Sa2.5 of the surface according to the ISO 8501-1 standard ('very careful blasting').

Despite the fact that this is a general indication, which says nothing about specific chemical and/or mechanical loads, this standard can still be seen as a good guideline with regard to the choice of a paint system for a certain atmospheric load. Please note: the stated lifespan in the overviews are emphatically not guarantee periods.

The ISO standard 12944 contains 5 corrosion categories which vary from 'C1-very low' to 'C5-very high':

	Environment examples				
Corrosivity categorie	Exterior	Interior			
C1 - very low		Heated buildings with a clean atmosphere such as offices, shops, schools, hotels.			
C2 - low	Atmospheres contaminated to a small extent, mainly rural regions.	Buildings which are not heated, where condensation may occur e.g. storage facilities, sports halls.			
C3 - medium	Industrial and urban atmospheres with a low sulphur oxide (IV) contamination level. Inshore areas of low salinity.	Production halls to facilities humidity and certain air contamination e.g. foodstuff plants, laundries, breweries, dairies.			
C4 - high	Industrial areas and inshore areas of medium salinity.	Chemical plants, swimming pools, ship repair yards.			
C5-I - very high (INDUSTRIAL)	Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.	Buildings and areas of almost constant condensation and high contamination.			
C5-M – very high (MARINE)	Coastal and offshore areas with a high salt content.	Buildings and areas of almost constant condensation and high contamination.			

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

To all deliveries, offers and advises are applicable the Uniform Terms of Sale and Delivery for Paint and Printing ink of the VVVF, filed under no. 310/91 of the Amsterdam County Court, unless agreed otherwise. The information provided in this product information sheet is based on laboratory tests that have been accurately performed by us and is intended only as a guideline to give you an indication of the application possibilities. All recommendations and proposals related to the use of our products, whether in technical documentation or in response to a specific question, or otherwise, are based to our current knowledge, the data being compiled to the best of our knowledge. The products and the information are intended for professional industrial users with the specific knowledge and industrial skills required and it is the responsibility of the end user to determine the suitability for the application or port to our be substrate, nor over the many factors that affect the application and application of the product, and therefore does not accept any responsibility arising from loss, damage or damage arising from its use or content. of this data sheet, unless there is a written agreement stating otherwise.







SUBSTRATE: STEEL

Interior

Exterior



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CORROSIVITY CATEGORY

C3 - medium

Environment example:

Production halls to facilities humidity and certain air contamination e.g. foodstuff plants, laundries, breweries, dairies. Industrial and urban atmospheres with a low sulphur oxide (IV) contamination level. Inshore areas of low salinity.

Estimated life	Application:	Type of Paint:	BICCS Pa	aint System:		Thickness (DFT):
	brush	(SB)	system:	B.I.K. 3-IN-1 SILK GLOSS-30	[9556]	120 µm
					DFT:	120 µm
	spray	alkyd (OH)	system:	BICHOLUX QD HB SYSTEM-COAT SATIN MATT-30	[1256]	120 µm
Low:					DFT:	120 µm
2 - 5 years	spray	alkyd (OH)	primer:	BICHOLUX QD HB BODYPRIMER	[1243]	80 µm
	spray	alkyd (OH)	topcoat:	BICHOLUX SPRAY ENAMEL HIGH GLOSS	[1153]	40 µm
					DFT:	120 µm
	spray	alkyd (WG)	system:	AQUA 1C SYSTEM-COATING SILK GLOSS	[5256]	120 µm
					DFT:	120 µm
	brush	alkyd (WG)	primer:	AQUA 1C BICHOLUX PRIMER	[5048]	80 µm
	brush	alkyd (WG)	topcoat:	AQUA 1C SYSTEM-COATING MATT	[5255]	40 µm
					DFT:	120 µm

Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 MATT-10	[9551]	160 μm
				DFT:	160 µm
	spray	alkyd (OH)	primer: BICHOLUX QD HB BODYPRIMER	[1243]	80 µm
	spray	alkyd (OH)	topcoat: BICHOLUX QD SPRAYCOATING GLOSS	[1253]	80 µm
Medium:				DFT:	160 µm
5 - 15 years	brush	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER	[5048]	100 µm
	brush	alkyd (WG)	topcoat: AQUA 1C BICHOLUX ENAMEL HIGH GLOSS	[5253]	60 µm
				DFT:	160 µm
	brush	2K epoxy (OH)	primer: B.I.K. 2C EPOXYPRIMER R1013 (hardener incl.)	[9525]	100 µm
	brush	alkyd (OH)	topcoat: B.I.K. ENAMEL S SILK GLOSSE	[9532]	60 µm
				DFT:	160 µm

Estimated life	Application:	Type of Paint:	BICCS Pa	int System:		Thickness (DFT):
	spray spray	2K epoxy (OH) 2K acrylic (OH)	primer: topcoat:	BIPOX 2C HB ZPH PRIMER (5:1) BICHODUR 2C DTM EXTRA MATT- 5 (6:1)	[6142] [9250]	120 μm 80 μm
High:					DFT:	200 µm
> 15 years	brush brush	2K epoxy (WG) 2K pu (WG)	primer: topcoat:	AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)	[5045] [5055]	100 μm 100 μm
					DFT:	200 µm

Note: SB = solvent based WB = water based DFT = dry film thickness



When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

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C4 - high	Industrial areas and inshore areas of medium salinity.	Chemical plants, swimming pools, ship repair yards.
C5-I - very high (INDUSTRIAL)	Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.	Buildings and areas of almost constant condensation and high contamination.
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Interior

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CORROSIVITY CATEGORY

C4 - high

Environment example:

- mgn

Chemical plants, swimming pools, ship repair yards. Industrial areas and inshore areas of medium salinity.

Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30 [[9556]	160 μm
				DFT:	160 µm
	spray	alkyd (OH)	primer: BICHOLUX QD HB ZINC PHOSPHATE PRIMER	[1242]	100 µm
	spray	alkyd (OH)	topcoat: BICHOLUX QD SPRAYCOATING GLOSS	[1253]	60 μm
Low:	. ,	, , , ,		DFT:	160 μm
2 - 5 years	spray	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER [[5048]	100 µm
	spray	alkyd (WG)	topcoat: AQUA 1C SYSTEM-COATING SILK GLOSS	[5256]	60 μm
				DFT:	160 µm
	brush	alkvd (WG)	primer: AQUA 1C BICHOLUX PRIMER	50481	100 um
	brush	alkyd (WG)	topcoat: AQUA 1C BICHOLUX ENAMEL HIGH GLOSS	5253]	60 µm
		, , , ,		DFT:	160 μm
	·	<u> </u>			
Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2K epoxy (OH)	primer: 2C BIPOX HB ZPH COATING SG (4:1) [[6143]	120 μm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM GLOSS-70 (6:1) [[9258]	80 µm
Medium:				DFT:	200 µm
5 - 15 years	brush	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER (5:1) [[6142]	100 µm
	brush	chloorrbr. (OH)	topcoat: UNIDECK CR DECK PAINT HB	[7156]	120 μm
				DFT:	220 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [[5045]	80 µm

Estimated life	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	spray spray	2K epoxy (OH) 2K acrylic (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) [6146] topcoat: BICHODUR 2K HB FINISH GLOSS-80 (4:1) [9268]] 160 μm] 80 μm
High:			DFT	: 240 μm
> 15 years	brush brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [5045 topsort: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1) [5055] 160 μm
	510311			280 μm

topcoat: AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)

Note: SB = solvent based WB = water based DFT = dry film thickness

2K pu (WG)

Depending on the product, the dry film thicknesses for primer, topcoat, etc. must be applied in one or more layers



[5056]

DFT:

120 µm

200 µm

brush



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The ISO standard 12944 contains 5 corrosion categories which vary from 'C1-very low' to 'C5-very high':

	Environme	ent examples
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C3 - medium	Industrial and urban atmospheres with a low sulphur oxide (IV) contamination level. Inshore areas of low salinity.	Production halls to facilities humidity and certain air contamination e.g. foodstuff plants, laundries, breweries, dairies.
C4 - high	Industrial areas and inshore areas of medium salinity.	Chemical plants, swimming pools, ship repair yards.
C5-I - very high (INDUSTRIAL)	Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.	Buildings and areas of almost constant condensation and high contamination.
C5-M – very high (MARINE)	Coastal and offshore areas with a high salt content.	Buildings and areas of almost constant condensation and high contamination.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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Interior

Exterior



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CORROSIVITY CATEGORY

C5-I - very high

Environment example:

Buildings and areas of almost constant condensation and high contamination. Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.

Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	brush	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER (5:1)	[6142]	100 µm
	brush	chloorrbr. (OH)	topcoat: UNIDECK CR DECK PAINT HB	[7149]	120 µm
Low:				DFT:	220 µm
2 - 5 years	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	120 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)	[9243]	80 µm
				DFT:	200 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	120 µm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)	[5056]	80 µm
				DFT:	200 µm
Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2K epoxy (OH)	primer: B.I.K. 2C EPOXYPRIMER R1013 (hardener incl.)	[9525]	140 µm
	brush	2K acrylic (OH)	topcoat: B.I.K. 2C ENAMEL HIGH GLOSS (hardener incl.)	[9513]	100 µm

Medium:				DFT:	240 µm
5 - 15 years	spray	2K epoxy (OH)	primer: BIPOX 2C ZINCRICH PRIMER (9:1)	[6147]	40 µm
	spray	2K epoxy (OH)	Midcoat: 2C BIPOX HB ZPH COATING SG (4:1)	[6143]	120 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2K HB FINISH GLOSS-80 (4:1)	[9268]	80 µm
				DFT:	240 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	160 µm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1) [5055]	100 µm
				DFT:	260 µm
Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
Estimated life	Application: spray	Type of Paint: 2K epoxy (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1)	[6147]	Thickness (DFT): 40 μm
Estimated life	Application: spray spray	Type of Paint: 2K epoxy (OH) 2K epoxy (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1) Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6147] [6146]	Thickness (DFT): 40 μm 140 μm
Estimated life	Application: spray spray spray	Type of Paint: 2K epoxy (OH) 2K epoxy (OH) 2K acrylic (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1) Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) topcoat: BICHODUR 2C DTM GLOSS-70 (6:1)	[6147] [6146] [9258]	Thickness (DFT): 40 μm 140 μm 100 μm
Estimated life High:	Application: spray spray spray	Type of Paint: 2K epoxy (OH) 2K epoxy (OH) 2K acrylic (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1) Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) topcoat: BICHODUR 2C DTM GLOSS-70 (6:1)	[6147] [6146] [9258] DFT :	Thickness (DFT): 40 μm 140 μm 100 μm 280 μm
Estimated life High: > 15 years	Application: spray spray spray spray	Type of Paint: 2K epoxy (OH) 2K epoxy (OH) 2K acrylic (OH) 2K epoxy (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1) Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) topcoat: BICHODUR 2C DTM GLOSS-70 (6:1) primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6147] [6146] [9258] DFT: [6146]	Thickness (DFT): 40 μm 140 μm 100 μm 280 μm 200 μm
Estimated life High: > 15 years	Application: spray spray spray spray spray	Type of Paint: 2K epoxy (OH) 2K epoxy (OH) 2K acrylic (OH) 2K epoxy (OH) 2K acrylic (OH)	BICCS Paint System: primer: BIPOX 2C ZINCRICH PRIMER (9:1) Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) topcoat: BICHODUR 2C DTM GLOSS-70 (6:1) primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) topcoat: BICHODUR 2C DTM SATIN GLOSS-50 (6:1)	[6147] [6146] [9258] DFT: [6146] [9252]	Thickness (DFT): 40 μm 140 μm 100 μm 280 μm 200 μm 100 μm

Note: SB = solvent based WB = water based DFT = dry film thickness





When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

The second part of the NEN-EN-ISO 12944 standard describes the corrosion protection of steel by means of paint systems based on various corrosion load categories. This is based on the cleanliness level Sa2.5 of the surface according to the ISO 8501-1 standard ('very careful blasting').

Despite the fact that this is a general indication, which says nothing about specific chemical and/or mechanical loads, this standard can still be seen as a good guideline with regard to the choice of a paint system for a certain atmospheric load. Please note: the stated lifespan in the overviews are emphatically not guarantee periods.

The ISO standard 12944 contains 5 corrosion categories which vary from 'C1-very low' to 'C5-very high':

	Environment examples				
Corrosivity categorie	Exterior	Interior			
C1 - very low		Heated buildings with a clean atmosphere such as offices, shops, schools, hotels.			
C2 - low	Atmospheres contaminated to a small extent, mainly rural regions.	Buildings which are not heated, where condensation may occur e.g. storage facilities, sports halls.			
C3 - medium	Industrial and urban atmospheres with a low sulphur oxide (IV) contamination level. Inshore areas of low salinity.	Production halls to facilities humidity and certain air contamination e.g. foodstuff plants, laundries, breweries, dairies.			
C4 - high	Industrial areas and inshore areas of medium salinity.	Chemical plants, swimming pools, ship repair yards.			
C5-I - very high (INDUSTRIAL)	Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.	Buildings and areas of almost constant condensation and high contamination.			
C5-M – very high (MARINE)	Coastal and offshore areas with a high salt content.	Buildings and areas of almost constant condensation and high contamination.			

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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SUBSTRATE: STEEL

Interior

Exterior



The paint systems below are indicative examples of the various options for steel preservation in accordance with the NEN-EN-ISO 12944-2 standard. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

CORROSIVITY CATEGORY

C5-M - very high

Environment example:

Buildings and areas of almost constant condensation and high contamination. Coastal and offshore areas with a high salt content.

Estimated life Application:		Type of Paint:	BICCS Paint System:	Thickness (DFT):
	brush	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER (5:1) [614	2] 100 μm
Low:	brush	chioorrbr. (UH)		7: 220 μm
2 - 5 years	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) [614	6] 120 μm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1) [924	3] 80 µm
			D	T: 200 μm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [504	5] 120 μm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1) [505	6] 80 μm
			D	Τ: 200 μm

Estimated life	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2К ероху (ОН)	primer: B.I.K. 2C EPOXYPRIMER R1013 (hardener incl.)	[9525]	140 µm
	brush	2K acrylic (OH)	topcoat: B.I.K. 2C ENAMEL SILK GLOSS (hardener incl.)	[9512]	100 µm
Medium:				DFT:	240 µm
5 - 15 years	spray	2К ероху (ОН)	primer: BIPOX 2C ZINCRICH PRIMER (9:1)	[6147]	40 µm
	spray	2K epoxy (OH)	Midcoat: 2C BIPOX HB ZPH COATING SG (4:1)	[6143]	120 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2K HB FINISH GLOSS-80 (4:1)	[9268]	80 µm
				DFT:	240 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	160 μm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)	[5055]	100 µm
				DFT:	260 µm
Estimated life	Application:	Type of Paint:	RICCS Paint System		Thickness (DFT)
Lotimated inc	Application.				
	spray	2К ероху (ОН)	primer: BIPOX 2C ZINCRICH PRIMER (9:1)	[6147]	40 µm
	spray	2K epoxy (OH)	Midcoat: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	140 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM GLOSS-70 (6:1)	[9258]	100 µm
High:				DFT:	280 µm
> 15 years	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	200 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM SATIN GLOSS-50 (6:1)	[9252]	100 µm
				DFT:	300 µm

Note: SB = solvent based WB = water based DFT = dry film thickness





When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

The second part of the NEN-EN-ISO 12944 standard describes the corrosion protection of steel by means of paint systems based on various corrosion load categories. This is based on the cleanliness level Sa2.5 of the surface according to the ISO 8501-1 standard ('very careful blasting').

Despite the fact that this is a general indication, which says nothing about specific chemical and/or mechanical loads, this standard can still be seen as a good guideline with regard to the choice of a paint system for a certain atmospheric load. Please note: the stated lifespan in the overviews are emphatically not guarantee periods.

The ISO standard 12944 contains 5 corrosion categories which vary from 'C1-very low' to 'C5-very high':

	Environment examples						
Corrosivity categorie	Exterior	Interior					
C1 - very low		Heated buildings with a clean atmosphere such as offices, shops, schools, hotels.					
C2 - low	Atmospheres contaminated to a small extent, mainly rural regions.	Buildings which are not heated, where condensation may occur e.g. storage facilities, sports halls.					
C3 - medium	Industrial and urban atmospheres with a low sulphur oxide (IV) contamination level. Inshore areas of low salinity.	Production halls to facilities humidity and certain air contamination e.g. foodstuff plants, laundries, breweries, dairies.					
C4 - high	Industrial areas and inshore areas of medium salinity.	Chemical plants, swimming pools, ship repair yards.					
C5-I - very high (INDUSTRIAL)	Industrial areas of high humidity and aggressive atmosphere and inshore areas of high salinity.	Buildings and areas of almost constant condensation and high contamination.					
C5-M – very high (MARINE)	Coastal and offshore areas with a high salt content.	Buildings and areas of almost constant condensation and high contamination.					

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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VRF06 SUBSTRATE: GALVANIZED STEEL (*)

The paint systems below are indicative examples of the various options for preserving galvanized steel. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

(*) A	Appearances: hot-dip galvanized,	, sendzimir galvanized,	electrolytically galvanized,	, galvanizing, scooping (metalizing
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Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30 [955 DI	6] 60 μm 77: 60 μm
Low	brush brush	alkyd (OH) alkyd (OH)	primer: B.I.K. MULTI PRIMER WHITE [952 topcoat: B.I.K. ENAMEL HIGH GLOSS [953 D	1] 40 μm 3] 40 μm 7 . 80 μm
exposure	spray	2K acrylic (OH)	system: BICHODUR 2C DTM GLOSS-70 (6:1) [925	8] 60 μm 7 7: 60 μm
	brush brush	2K epoxy (WG) alkyd (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [504 topcoat: AQUA 1C SYSTEM-COATING GLOSS-70 [525 D	8] 40 μm 8] 40 μm 7 7: 80 μm
Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30 [955	6] 80 μm 77: 80 μm
Medium	spray spray	2K epoxy (OH) 2K acrylic (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) [614 topcoat: BICHODUR 2C DTM SATIN GLOSS-50 (6:1) [925 DI DI DI	6] 60 μm 2] 40 μm 7 7: 100 μm
	spray spray	polyvinylb (OH) 2K pu (OH)	primer: 2C WASHPRIMER BEIGE (1:1) [904 topcoat: BICHOTHANE 2C PU HB GLOSS (4:1) [335 DI	0] 40 μm 8] 60 μm 7 . 100 μm
	brush brush	2K epoxy (WG) 2K pu (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [504 topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1) [335 D	5] 80 μm 1] 60 μm 7 . 140 μm
	brush brush	2K epoxy (OH) 2K acrylic (OH)	primer:B.I.K. 2C EPOXYPRIMER R1013 (hardener incl.)[952topcoat:B.I.K. 2C ENAMEL HIGH GLOSS (hardener incl.)[951Di	5] 60 μm 3] 60 μm T: 120 μm
Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	spray spray spray	polyvinylb (OH) 2K acrylic (OH) 2K acrylic (OH)	primer:2C WASHPRIMER BEIGE (1:1)[904primer:BICHODUR 2C DTM MATT-10 (6:1)[925topcoat:BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)[924DIDIDI	0] 30 μm 1] 90 μm 3] 80 μm T: 200 μm
High exposure	spray spray	2K epoxy (OH) 2K acrylic (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1) [614] topcoat: BICHODUR 2K HB FINISH GLOSS-80 (4:1) [926] DI DI [614]	6] 100 μm 8] 80 μm 7 7: 180 μm
	brush brush	2K epoxy (WG) 2K pu (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1) [504 topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1) [505 DI	5] 120 μm 5] 80 μm T: 200 μm

Note: SB = solvent based WB = water based DFT = dry film thickness

Depending on the product, the dry film thicknesses for primer, topcoat, etc. must be applied in one or more layers



When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

Due to the diversity of material compositions on the market, in case of doubt and/or unfamiliarity with an unknown surface, the suitability of a product for a certain surface should always be tested first. Specifically for aluminum, for example, unambiguous system advice is unfortunately not possible due to the many alloys and forms that sometimes require an adjustment of the paint system. Our advice on paint systems for aluminum is usually based on pure, unalloyed aluminium, also known as the 1000 series.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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VRF07 SUBSTRATE: ALUMINUM & STAINLESS STEEL (*)

The paint systems below are indicative examples of the various options for the preservation of aluminum and stainless steel (Inox). However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

(*) See the remarks on the back of this publication regarding these substrates

Exposure:	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2K acrylic (OH)	system: BICHODUR 2C TOPCOAT CLEAR SILK GLOSS-50 (3:1)	[9297]	40 µm
				DFT:	40 µm
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30	[9556]	50 μm
				DFT:	50 µm
	brush	alkyd (OH)	primer: B.I.K. MULTI PRIMER WHITE	[9521]	40 µm
Low	brush	alkyd (OH)	topcoat: B.I.K. ENAMEL S SILK GLOSSE	[9532]	40 μm
exposure				[0252]	ου μπι 60 μπι
	spray	2K acrylic (OH)	system: BICHODUR 2C DTM SATIN GLOSS-50 (6:1)	[9252]	60 μm
	h			[5040]	00 µm
	brush	alkyd (WG) alkyd (WG)	topcoat: AQUA IC BICHOLUX PRIMER	[5048] [5258]	40 μm 40 μm
	brush			[3230] DFT:	80 μm
					•
Exposure:	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30	[9556]	80 µm
				DFT:	80 µm
	spray	2K acrylic (OH)	system: BICHODUR 2C DTM SATIN GLOSS-50 (6:1)	[9258]	80 µm
				DFT:	80 µm
Medium	spray	polyvinylb (OH)	primer: 2C WASHPRIMER BEIGE (1:1)	[9040]	40 µm
exposure	spray	2K pu (OH)	topcoat: BICHOTHANE 2C PU HB SEMI MATT (4:1)	[3359]	60 μm
				DF1:	100 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	80 µm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)	[5056]	60 μm
				DFT.	140 µm
Exposure:	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2K acrylic (OH)	primer: BICHODUR 2C DTM MATT-10 (6:1)	[9251]	120 μm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2K HB FINISH GLOSS-80 (4:1)	[9268]	80 µm
				DFT:	200 µm
High	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	100 µm
exposure	spray	2K acrylic (OH)	topcoat: BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)	[9243]	80 μm
chposure				DFT:	180 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	120 μm
	nrush	7 K DU (\\/(-i)	I topcoat: AOUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)	150551	XU IIM

Note: SB = solvent based WB = water based DFT = dry film thickness



When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

Due to the diversity of material compositions on the market, in case of doubt and/or unfamiliarity with an unknown surface, the suitability of a product for a certain surface should always be tested first. Specifically for aluminum, for example, unambiguous system advice is unfortunately not possible due to the many alloys and forms that sometimes require an adjustment of the paint system. Our advice on paint systems for aluminum is usually based on pure, unalloyed aluminium, also known as the 1000 series.

Given the enormous number of types of stainless steel (there are several hundred types!) you should always spray a test surface in order to check the method of pre-treatment and paint application. Be alert to materials that have undergone a certain treatment, such as grinding, brushing and polishing, and/or a chemical pre-treatment. Check specifically for places where any operations such as welding and laser cutting have taken place. A wrong choice can result in insufficient adhesion.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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VRF08 SURFACE: PLASTIC (*)

The paint systems below are indicative examples of the various options for plastic. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

(*) See the remarks on the back of this publication regarding these substrates

Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	brush	(SB)	system: B.I.K. 3-IN-1 SILK GLOSS-30 [9550	j] 60 μm
			DF	Γ: 60 μm
	brush	alkyd (OH)	primer: B.I.K. MULTI PRIMER WHITE [952]	.] 40 µm
	brush	alkyd (OH)	topcoat: B.I.K. ENAMEL S SILK GLOSSE [953]] 40 µm
Low			DF	r: 80 μm
exposure	spray	2K acrylic (OH)	system: BICHODUR 2C DTM SATIN GLOSS-50 (6:1) [925]] 60 μm
			DF	Γ: 60 μm
	brush	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER [504	-] 40 μm
	brush	alkyd (WG)	topcoat: AQUA 1C SYSTEM-COATING GLOSS-70 [5258] 40 μm
			DF	r: 80 μm

Exposure:	Application:	Type of Paint:	BICCS Pa	int System:		Thickness (DFT):
	brush	(SB)	system:	B.I.K. 3-IN-1 SILK GLOSS-30	[9556]	80 µm
					DFT:	80 µm
	spray	2K acrylic (OH)	system:	BICHODUR 2C DTM GLOSS-70 (6:1)	[9258]	100 µm
					DFT:	100 µm
	brush	2K pu (WG)	system:	AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)	[5056]	80 µm
Medium					DFT:	80 µm
exposure	spray	2K acrylic (OH)	primer:	BICHODUR 2C DTM MATT-10 (6:1)	[9251]	60 µm
	spray	2K acrylic (OH)	topcoat:	BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)	[9243]	40 µm
					DFT:	100 µm
	brush	2K epoxy (WG)	primer:	AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	80 µm
	brush	2K pu (WG)	topcoat:	AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)	[5056]	60 µm
					DFT:	140 μm

Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):	
	spray	2K acrylic (OH)	primer: BICHODUR 2C DTM MATT-10 (6:1)	[9251]	80 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C HIGH GLOSS 98 FINISH PLUS (2:1)	[9243]	80 µm
				DFT:	160 µm
	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	80 µm
High	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM EXTRA MATT- 5 (6:1)	[9250]	80 µm
exposure				DFT:	160 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	80 µm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)	[5055]	80 µm
				DFT:	160 µm

Note: SB = solvent based WB = water based DFT = dry film thickness



When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

Due to the diversity of material compositions on the market, in case of doubt and/or unfamiliarity with an unknown surface, the suitability of a product for a certain surface should always be tested first. Specifically for plastic, for example, unambiguous system advice is unfortunately not possible due to the many types of plastic that occur. Due to their composition, some types are unsuitable for applying a paint system (PE/PP, as well as soft plastics). Our advice on paint systems for plastics is usually based on hard plastics such as Trespa, hard PVC, polyester and ABS.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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VRF09 SUBSTRATE: OLD (CURED) PAINT COATINGS (*)

The paint systems below are indicative examples of the various options for painting over old, hardened paint layers. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

(*) See the remarks on the back of this publication regarding these substrates

Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):	
	brush	alkyd (OH)	system: BICHOLUX HB COATING SEMI MATT-30	[1156]	60 µm
				DFT:	60 µm
	spray	alkyd (OH)	primer: BICHOLUX QD HB BODYPRIMER	[1243]	40 µm
Low	spray	alkyd (OH)	topcoat: BICHOLUX SPRAY ENAMEL HIGH GLOSS	[1153]	40 µm
exposure				DFT:	80 µm
	brush	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER	[5048]	40 µm
	brush	alkyd (WG)	topcoat: AQUA 1C SYSTEM-COATING GLOSS-70	[5258]	40 µm
				DFT:	80 µm

Exposure:	Application:	Type of Paint:	BICCS Pa	aint System:		Thickness (DFT):
	brush	(SB)	system:	B.I.K. 3-IN-1 SILK GLOSS-30	[9556]	80 µm
					DFT:	80 µm
	spray	2K acrylic (OH)	system:	BICHODUR 2C DTM GLOSS-70 (6:1)	[9258]	120 µm
					DFT:	120 µm
Medium	spray	alkyd (OH)	primer:	BICHOLUX QD HB BODYPRIMER	[1243]	80 µm
exposure	spray	alkyd (OH)	topcoat:	BICHOLUX QD SPRAYCOATING GLOSS	[1253]	60 µm
					DFT:	140 µm
	brush	2K epoxy (WG)	primer:	AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	80 µm
	brush	2K pu (WG)	topcoat:	AQUA 2C BICHOTHANE ENAMEL SILK GLOSS (6:1)	[5056]	60 µm
					DFT:	140 um

Exposure:	Application:	Type of Paint:	BICCS Paint System:		Thickness (DFT):
	spray	2K acrylic (OH) 2K acrylic (OH)	primer: BICHODUR 2C DTM MATT-10 (6:1)	[9251] [9243]	120 μm 80 μm
	spruy			DFT:	200 μm
	spray	2K epoxy (OH)	primer: BIPOX 2C HB ZPH PRIMER RM1013 (4:1)	[6146]	120 µm
High	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM GLOSS-70 (6:1)	[9258]	80 µm
exposure				DFT:	200 µm
	brush	2K epoxy (WG)	primer: AQUA 2C BIPOX PRIMER RAL1013 (1,2:1)	[5045]	120 µm
	brush	2K pu (WG)	topcoat: AQUA 2C BICHOTHANE ENAMEL HIGH GLOSS (4:1)	[5055]	80 µm
				DFT:	200 µm

Note: SB = solvent based WB = water based DFT = dry film thickness





When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

Painting over an old, existing paint layer certainly does not always have to be a problem. However, caution is advised as certain (old) types of paint cannot always be painted over with every paint product. When it is no longer known which type of paint was applied at the time, various tests are possible to get more certainty about this. The PearlPaint Group technical service can advise you on this. In all cases you should check the adhesion of the old paint layer before you decide to paint it over. We always recommend carrying out a test beforehand with an unknown surface that you want to paint over. In case of doubt, one can only decide to remove the old paint layers down to the surface and apply a new paint system.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

To all deliveries, offers and advises are applicable the Uniform Terms of Sale and Delivery for Paint and Printing ink of the VVVF, filed under no. 310/91 of the Amsterdam County Court, unless agreed otherwise. The information provided in this product information sheet is based on laboratory tests that have been accurately performed by us and is intended only as a guideline to give you an indication of the application possibilities. All recommendations and proposals related to the use of our products, whether in technical documentation or in response to a specific question, or otherwise, are based to our current knowledge, the data being compiled to the best of our knowledge. The products and the information are intended for professional industrial users with the specific knowledge and industrial skills required and it is the responsibility of the end user to determine the suitability for the application. PearlPaint Group has no control over the quality or condition of the substrate, nor over the many factors that affect the application of the product, and therefore does not accept any responsibility arising from loss, damage or damage arising from its use or content. of this data sheet, unless there is a written agreement stating otherwise.





VRF10 SUBSTRATE: MDF, CHIPBOARD (*)

The paint systems below are indicative examples of the various options for painting wooden panels such as MDF and chipboard. However, PearlPaint Group also supplies many other paint systems, precisely tailored to your specific situation. For more information, please contact our technical service.

(*) See the remarks on the back of this publication regarding these substrates

Exposure:	Application:	Type of Paint:	BICCS Paint System:	Thickness (DFT):
	spray	cell./pu (OH)	primer: BICHOTHANE 1C PU FILLER PRIMER WHITE [9047]	40 µm
	spray	cell./pu (OH)	optional: BICHOTHANE 1C PU FILLER PRIMER WHITE [9047]	40 µm
	spray	2K pu (OH)	topcoat: BICHOTHANE 2C PU SPRAY ENAMEL HIGH GLOSS (4:1) [3353]	40 µm
			DFT:	80-120 μm
	spray	2K pu (OH)	primer: BICHOTHANE 2C PU HB FILLING BODYPRIMER (10:1) [3349]	40 µm
	spray	2K pu (OH)	optional: BICHOTHANE 2C PU HB FILLING BODYPRIMER (10:1) [3349]	40 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM SATIN GLOSS-50 (6:1) [9252]	60 µm
			DFT:	100-140 µm
	spray	alkyd (WG)	primer: AQUA 1C BICHOLUX PRIMER [5048]	40 µm
	spray	alkyd (WG)	optional: AQUA 1C BICHOLUX PRIMER [5048]	40 µm
	spray	2K acrylic (OH)	topcoat: BICHODUR 2C DTM SATIN GLOSS-50 (6:1) [9252]	60 µm
			DFT:	100-140 µm
	spray	alkyd (WG)	primer: AQUA 1C BICHOLUX FILLER PRIMER WHITE [5047]	40 µm
	spray	alkyd (WG)	optional: AQUA 1C BICHOLUX FILLER PRIMER WHITE [5047]	40 µm
	spray	alkyd (WG)	topcoat: AQUA 1C BICHOLUX ENAMEL HIGH GLOSS [5253]	40 µm
			DFT:	80-120 μm

Note: - SB = solvent based WB = water based DFT = dry film thickness

- Depending on the product, the dry film thicknesses for primer, topcoat, etc. must be applied in one or more layers

- When the primer product is applied to wood (like) material, there is a chance that fibers will pull up and form a rough layer. These should be sanded off and then an extra primer layer applied. E.e.a. strongly depends on the substrate.





When choosing a (corrosion-resistant) paint system, the ultimate conditions to which the construction will be exposed must be taken into account: temperature, humidity, UV radiation, chemical and mechanical stress.

We always recommend carrying out a test beforehand with an unknown surface that you want to paint over. The quality of the wood material can vary greatly, for example due to the type of glue used. The PearlPaint Group technical service can advise you on this.

Note: The estimated lifetime of paint systems (for metal preservation) depends on many factors. Usually, defects will first manifest themselves at critical points such as bolted connections, welds, sharp edges and corners. For that reason it is necessary to treat these places properly. Only in this way can the entire object eventually be provided with a paint layer with the required layer thickness, with which maximum protection is obtained.

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