

DESCRIPTION	two component aliphatic acrylic polyurethane filler/ build coat.
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - general purpose polyurethane coating in protective coating systems for the protection of steel subject to atmospheric exposure - good adhesion to steel substrate - good flow and wetting properties - easy application by airless spray - will cure at temperatures down to +5°C
COLOURS AND GLOSS	grey
BASIC DATA AT 20°C	(1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) (data for mixed product)
<u>POLYURTHANE</u>	
Mass density	approx. 1.48 g/cm ³
Viscosity	25 (dpa)
Solid content	approx. 35,25% by volume
<u>HARDENER</u>	
Mass density	approx. 1 g/cm ³
Viscosity	7 (nk2)
Solid content	approx. 18,65% by volume
<u>POLYURETHANE + HARDENER</u>	
Mixing ratio by weight	4:1 (epoxy : hardener)
Mass density	approx. 1,35 g/cm ³
Viscosity	15 dpa
Solids content	approx. 31,93% by volume
Thinner	max. 335g/l (approx. 2,8 lb/gal)
Recommended dry film thickness	100 µm depending on system
Theoretical spreading rate	3,19 m ² /l for 100 µm
Touch dry after	15 minutes,
Over coating interval	min. 20 minutea, max. Unlimited
Full cure after	24 hours
Shelf life (cool and dry place)	at least 12 months
Flash point	base 22°C, hardener 26,5°C
AND TEMPERATUES	<p>even flat appearance (only for internal dry exposure conditions)</p> <ul style="list-style-type: none"> - aged suitable coatings, dry and free from any contamination and sufficiently roughened - during application and curing a substrate tempertaure down to -10°C is acceptable provided substrate is dry and free from ice - substrate temperature should be at least 3°C above dew point - maximum relative humidity during application and curing is 95%
INSTRUCTIONS FOR USE	<p>mixing ratio by weight : base to hardener 4:1</p> <ul style="list-style-type: none"> - the temperature of the mixed base dan hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity - too much solvent results in reduced sag resistance and slower cure - thinner should be added after mixing the components
Induction time	20 minutes if applied at temperatures below 10°C none above 10°C
Pot life	8 hours at 20°C

AIRLESS SPRAY

Recommended thinner
Volume of thinner
Nozzle orifice
Nozzle pressure

Spesial PU thinner
5 - 10%, depending on required thickness and application conditions
approx. 0.48 mm (= 0.019 in)
15 MPa (=approx. 150 bar; 2130 p.s.i)

AIR SPRAY

Recommended thinner
Volume of thinner
Nozzle orifice
Nozzle pressure

Spesial PU thinner
5 - 10%, depending on required thickness and application conditions
1.5 - 3 mm
0.3 - 0.4 MPa (=approx. 3 - 4 bar, 43 - 57 p.s.i)

SAFETY PRECAUTIONS

this is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes.

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.


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