BICHODUR 2C DTM SATIN GLOSS-50

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

Description

Bichodur 2C DTM Satin Gloss-50 [9252] 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 Satin Gloss-50 [9252] is developed specifically for use as a one-layer conservation system (no primer needed) on various ferrous and non-ferrous metals and hard plastics. It 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	:	satin gloss
Gloss level (¹)	:	ca. 50% (depending on colour)
Colour	:	all colours by BICCS CMS BCS-8200
Theoretical consumption	:	approx. 12 m²/ltr. at 40 µm DFT
Specific gravity	:	1,22 g/ml (depending on colour)
Solids content	:	67% by weight / 50% by volume
Flashpoint	:	25°C
Application conditions	:	min. 5°C / 80% R.V.
VOC content	:	430-445 g/l
Shelf life in can	:	24 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 abrabed/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.

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. 150 µm WFT < > 75 µm DFT
Note: indicative layer thickness per layer. For system layer thicknesses in accordance with ISO 12944 (see 'BICCS Paint Systems', www.biccs.nl) or contact your account manager or the Technical Support department for project-based advice.

Tool cleaning:
Washing thinner or BICCS Thinner 0102 [9162]

Drying times

Dust-free	:	approx. 30 minutes
Tack-free	:	approx. 60 minutes
Dry to touch	:	approx. 2,5 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

Data at 20°C and 65% RH

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 you to 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 0110 [9110]	: slow thinner; slows down the drying process, prevents respraying
BICCS Thinner 0105 [9165]	: reactive thinner; speeds up the curing and drying process
BICCS Thinner 0115 [9115]	: very slow thinner; for use at higher ambient temperatures

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, please contact your BICCS account manager or the Technical Support department.

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