



BICHODUR 2C TOPCOAT CLEAR SILK GLOSS-50

2C clear coat silk gloss based on acrylic/isocyanate resins

Description

Bichodur 2C Topcoat Clear Silk Gloss-50 [9297] is a 2 component solvent based metal protection clear silk gloss top coat enamel for stainless steel (INOX) based on high quality acrylate resin and an isocyanate hardener.

Provided it is applied as a thin film (approx. 40 microns), Bichodur 2C Topcoat Clear Silk Gloss-50 [9297] offers maximum protection without detracting from the attractive look of the stainless steel substrate. Contamination, such as fingerprints, is easy to remove.

Bichodur 2C Topcoat Clear Silk Gloss-50 [9297] can be used on various other metal types but can also serve as a clear satin gloss top coat on durable 2 component paint systems.

Properties

- Durable 2C satin gloss top coat for protection of stainless steel (INOX) and other types of metal.
- Preserves the aesthetically attractive uncoated stainless steel look
- Weather-resistant; suitable for both indoor and outdoor applications.
- Coated surfaces can be easily cleaned.
- Non-yellowing
- Also suitable for other non-ferrous metal types

Typical Applications

Suitable as a durable top coat for maximum protection of various types of metal and as a clear topcoat on 2C paint layers. Suitable for applications with high demands on durability, hardness and abrasion-resistance.

Substrates

- Ferro and non-ferrous metals
- Bichothane 2C-PU and Bichodur 2C layers

Technical Specifications

(product at 20°C)

Finish	: silk gloss
Gloss level (!)	: ca. 50 GU
Theoretical consumption	: approx. 12 m ² /litr. at 40 µm DFT
Specific gravity	: 1,32 g/ml
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.

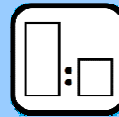
APPLICATION INSTRUCTIONS



Pre-treatment

The surface needs to be entirely clean, dry and degreased. Old, intact paint layers need to be 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 Hardener

Hardener : Bichodur 2C Hardener [9280]
Mixing ratio : 3:1 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 : 25 – 30%

Airspray

Nozzle : 1.2 – 1.8
Pressure : 3 to 4 bar
Viscosity : 25 – 30 sec., DIN cup 4

Airless

Nozzle : 0.009" - 0.011"
Pressure : 150 – 180 bar
Viscosity : 30 – 50 sec., DIN cup 4

Spraying instructions

Spray a thin layer first, followed by 1 – 2 cross-layers

Recommended film thickness

Min. 80 µm WFT < > 40 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]



Data at 20°C and 65% RH

Drying times

Dust-free : approx. 30 minutes
Tack-free : approx. 1 hours
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

Additional information

The final result largely depends on meticulous substrate preparation and working methods. If the composition of the metal permits it, and if it does not negatively affect the aesthetic character, it is strongly recommended to grit-blast, sand or scotch the substrate. You must thoroughly de-grease the substrate using a suitable de-greasing product, such as BICCS Thinner 0104 [9164].

Bichodur 2C Topcoat Clear Silk Gloss-50 [9297] needs to be thinned by 20 to 40% with BICCS Thinner 0102 [9162] in order to apply a virtually invisible protective layer on stainless steel. We recommend pre-spraying the object, then spraying the top coat as a single layer with a maximum dry film thickness of 40 microns.

Because of the huge diversity of stainless steel (more than hundred different types are available on the market) one always has to spray a test panel in order to check the necessary way to pre-treat and to apply top coat. Do pay attention to materials that sustained/underwent a certain pre-treatment like grinding, brushing, polishing and/or a chemical pre-treatment. Also check spots like weld seams and laser cutting edges. A wrong choice may cause insufficient adhesion.

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

Warning/restricted applicability

Because of the diversity of metal alloys in the market, plus the widely-ranging composition of synthetic materials, in case of doubt as to 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. Specifically regarding to aluminium: Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

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

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 PearlPaint Group, 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. PearlPaint Group 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. PearlPaint Group 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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