

Name **BINDER ACRYLIC 2K GLOSS**
Definition: **Acryl-urethane top coat**
Code: **5E.1.K1**

Category: **Special Finish (B/e)**
V.O.C (ready to use): **550 g/l**
V.O.C limit: 840
Product according to 2004/42/CE

Nature of this product:

Two-pack topcoat, based on acryl-polyester resins and isocyanic adduct to mix before use.

General Uses

Car refinishing, commercial vehicles, vans and trucks refinishing. Suitable for high quality finishes when maximum outdoor resistance is required.

APPLICATION METHOD

Preparation of Surfaces

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle. The product needs a primer coat like our epoxy series, 2I.3 or Acrylic series.

Ferrous surfaces. SA2 1/2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents. Then proceed with the application of a primer and then the top coat.

Galvanized sheet. Accurate sanding (with scotch brite paper coarse grain) followed by degreasing using thinners. Then proceed with the application of a primer and then the top coat.

Aluminium. Chromate or phosphorous chromate treatment or in alternative light sanding procedure followed by degreasing using organic thinners. Then proceed with the application of a primer and then the top coat.

Preparation of the product

	code	name	By Weight	By Volume
Component A	5E.1.K1(TINTED)	BINDER ACRYLIC 2K GLOSS	100 parts	100 parts
Component B	0A.014	ACTIVATOR STANDARD	50parts	50parts
Alternatively	0A.H2	HARDENER ACRYLIC	50parts	50parts

Carefully mix until an even colour and consistency are obtained. Usually dilution is not requested. Once hardened the product is ready to be used since it has a viscosity of 19"-22" Ford 4. If necessary, dilute at 5-15% with our thinners OG.093 or OG.055. With temperature over 25°C we suggest using the slow hardener 0A.012 and thinner OG.094 or OG.075 with the same ratio as the standard versions.

This information is based on our present knowledge and is intended to provide information about our products and their employment opportunities. They are not intended therefore to provide certain specific properties of the products or their fitness for specific application. We guarantee the quality of our product under our conditions of sale.

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Application

Spray gun: nozzle of 1,2-1,4 mm diameter and 2-4 atm pressure.

Roller or brush¹: Only for small surfaces

¹You may need Antifoam additive in order to avoid bubble formation whilst using these tools

Technical data

- Product Type** Two pack product
- Colors:** By request. 5E.1.K1 is mixed at a ratio 70/30 with our tinting system tinters.
- Film Appearance:** Glossy (>90 gloss)
- Specific Weight** (ISO 2811): 1.02 Kg/L
- Supply Viscosity:** 85 KU @25°C +/- 5
- Solid Content:** 48±2% (A+B)
- Drying at 20°C**
 - Dust dry: 20-30 minutes
 - Touch dry: 3 hours
 - Total hardening: 24 hours
 - Forced Drying 45' mins at 60°C
 - Maximum chemical resistance: After 7 days
- Recommended coats:** One crossed coat, followed after 5-10' by one coat.
- Thickness²:** 50 - 60 µm
- Theoretic Yield³:** 8-10 m²/kg
- Pot-Life at 20°C:** 3 hours at 20°C. At higher temperatures, pot-life decreases.

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- **Repainting:** After minimum 1-2 hours minimum as wet on wet. Over 8 -12 hours it is better a light sanding before over coating.
- Storage Stability:** One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.

² Considering a dry film.

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.