

Name **BINDER POLYURETHANE IND. GLOSS**  
 Definition: **Industrial polyurethane enamel**  
 Code: **6C.1.K2**

Category: **Topcoat**  
 V.O.C (ready to use): **600 g/l**  
 Product outside the uses referred to 2004/42/CE

## Nature of this product:

Top coat based on alkyd resins and isocyanic adducts

## General Uses

Machines tools, metallic structural work, furniture, industrial vehicles, earthmoving vehicles, agricultural machinery, etc.

## **APPLICATION METHOD**

### Preparation of Surfaces

The product shows direct adhesion only on iron. On other metals a primer coat is required, like our epoxy series 2I.3, or our polyacrylic urethane or polyurethane series.

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.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or thinners. Then proceed either with the direct application of the product or, for more guarantees of protection of the product over time, of the primer chosen and subsequently of the top coat.
- Galvanized sheet. Accurate sanding (with scotch brite paper coarse grain) followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.
- Aluminium. Mechanical cleaning of the substrate by sanding, followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.

### Preparation of the product

			<b>By Weight</b>	<b>By Volume</b>
Component A	6C.1.K2	BINDER PU IND. GLOSS (Tinted)	100 parts	100 parts
Component B	0A.014	ACTIVATOR STANDARD	40 parts	42 parts
Diluent	OG.013	REDUCER PU STANDARD @ 20°C	5-15parts	6-17 Parts

**For standard applications with spray gun dilute to get a viscosity of 18-20 Sec Ford 4 (for temperatures higher than 25°C use thinner OG.030).**

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### Application

Spray gun: Nozzle of 1,2-1,4 mm diameter and 3-4 atm pressure.

Roller or brush<sup>1</sup>: only for large surfaces.

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

### Technical data

**Product Type** Two pack product

On request (by using the binder 6C.1.K2 mixed in a ratio 75/25 or 70/30 with our tinting system tinters )

**Film Appearance:** Glossy 90± 5 gloss

**Specific Weight** (ISO 2811): 1,00 Kg/L (±0,1)

**Supply Viscosity:** 60" Ford 4 at 25°C (± 2")

**Solid on Volume:** 40% (±2%)

**Solid Content:** A + B 43% (±3%)

**Drying at 20°C**

Dust dry:	20-30 minutes
Touch dry:	4-6 hours
Total hardening:	24 hours
Forced Drying	30 mins at 60°C

Maximum chemical resistance: After 7 days

**Recommended coats:** One crossed coats.

**Thickness<sup>2</sup>:** 40-50 µm

**Theoretic Yield<sup>3</sup>:** 10 m<sup>2</sup>/kg

**Pot-Life at 20°C:** 4 hours at 20°C. At higher temperatures, pot-life decreases.

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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- Repainting:** After minimum 12 hours. After the complete hardening of the film, 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.

<sup>2</sup> *Considering a dry film.*

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