

Name **BINDER PU IND.SEMIGLOSS STRUCTURED**  
 Definition: **Industrial polyurethane enamel**  
 Code: **6C.6.K2**

Category: **Top Coat**  
 V.O.C (ready to use): **435 g/l**  
 V.O.C. limit :**500 g/l**  
 Product according to 2004/42/CE

### NATURE OF THE PRODUCT

Top coat based on alkyl resins and isocyanate adducts able to give an orange peel or embossed effect

### GENERAL USES

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

### 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 shows direct adhesion on metals<sup>1</sup> without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before.

Eventual suggested primers for this product are: Acrylic Primer, Epoxy primer 21.3,..

- **Ferrous surfaces.** SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- **Aluminum.** Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.
- **Galvanized sheet.** Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the application of the selected primer and then the top coat.

### PREPARATION OF THE PRODUCT

	<u>code</u>	<u>name</u>	<u>By Weight</u>	<u>By Volume</u>
Comp.A	6C.6.K2 (TINTED)	Binder PU Ind. S. Gloss	100 parts	100 parts
Component B	0A.013	Activator PU Embossed	20 parts	27 parts
alternative	0A.014 <sup>2</sup>	Activator Standard	33 parts	45 parts

Mixing accurately the mixture before the application. Dilute with our polyurethane thinner 0G.013 (for a temperature of more than 25°C use 0G.030 thinner) in a percent of 10-20% until a viscosity of 18-25" Ford 4 at 20° C to have a final smooth surface; not dilute or maximum dilute 5% for embossed or orange-peel effect. We suggest to apply a first smooth coat and then, after 2 hours, the embossed-orange peel coat.

### APPLICATION

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

Roller or brush<sup>3</sup>: Only for small surfaces

Airless. nozzle 0,09 inches, 120-150 bar

<sup>1</sup> If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

<sup>2</sup> 0A.012 Slow hardener for external at 33% in weight. If necessary dilute with slow PU thinner 0G.030 in place of 0G.013.

<sup>3</sup> You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tool

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## **TECHNICAL DATA**

**PRODUCT TYPE:** Two pack

**FILM APPEARANCE (ASTM D 523):** Semi matt or matt depending on the dilution

**COLOURS:** By request (the binder .6C.6.K2 has to be used in a ratio 80/20 with the tint metric system tinters)

**SPECIFIC WEIGHT (ISO 2811):** 1,33 kg/l. ( $\pm 0,10$ )

**SUPPLY VISCOSITY:** 200 Ps  $\pm$  20 at 20°C

**SOLID ON VOLUME:** A+B 54 $\pm$ 3%

**SOLIDS CONTENT:** A + B 65.5% ( $\pm$ 3%)

**DRYING AT 20°C** Dust dry: 20-30' Touch dry: 4-6 hours  
Total hardening: 24 hours Forced drying 30' at 60°C

Maximum chemical resistance: After 7 days

**RECOMMENDED COATS:** One crossed coat diluted 10-20% plus a crossed coat not diluted for embossed effect after minimum 30'

**THICKNESS<sup>4</sup>:** 60-90  $\mu$ m

**THEORETIC YIELD<sup>5</sup>:** 6 m<sup>2</sup>/kg.

**POT-LIFE AT 20°C:** 3 hours at temperature of 20°C. At higher temperatures, pot-life decreases

**REPAINTING:** Within minimum 12 hours. After 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>4</sup> Considering a dry film.

<sup>5</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.