

## Industrial Coatings

EU SF 1.27.

Aqueous white glossy two-pack PU topcoat, fast drying, good hardness,  
based on Bayhydrol A 2470 / Bayhydur 304

|         | Raw Material  | Supplier | % by wt.      |
|---------|---|----------|---------------|
| Comp. 1 | 1. Bayhydrol A 2470, 45% in water / solvents          | (1)      | 42.60         |
|         | 2. Surfynol 104 BC                                    | (2)      | 0.70          |
|         | 3. Borch <sup>®</sup> Gel Thix 921                    | (3)      | 0.14          |
|         | 4. Borch <sup>®</sup> Gol LA 200, 10% in butyl glycol | (3)      | 0.88          |
|         | 5. Borch <sup>®</sup> Gol LA 50                       | (3)      | 0.30          |
|         | 6. Borch <sup>®</sup> Gen SN 95                       | (3)      | 2.24          |
|         | 7. Sachtleben R-KB-4                                  | (4)      | 28.04         |
|         | 8. Water  |          | 5.59          |
|         | <i>Total</i>  |          | <i>80.49</i>  |
| Comp. 2 | 9. Bayhydur 304, 100%                                 | (1)      | 15.61         |
|         | 10. Butoxyl   |          | 3.90          |
|         | <i>Total</i>  |          | <i>100.00</i> |

### Application

Spraying using HVLP-pneumatic flow cup spray gun  
(nozzle 1.4mm /air pressure: approx. 1.9 bar)

(Before application add approx. 20% water for adjusting the  
spray viscosity.)

Technical data

|  |   |
|--|---|
| NCO : OH - ratio   | 1.5 : 1                                       |
| Mixing ratio (comp. 1 : comp. 2)                                   | 100 : 24                                      |
| Pigment : Binder - ratio   | 0.8 : 1                                       |
| Spray viscosity, DIN 53211-cup 4 mm, at 23 °C                      | approx. 20 s                                  |
| VOC (calculated acc. Directive 1999/13/EC)                         | approx. 165 g/l                               |
| Solid content on application                                       | approx. 57 %                                  |
| Drying time (DIN 53150; TG 1 / TG 3)                               | 0,5 h / 2 h                                   |
| Gloss 20° / 60° / Haze (DIN EN ISO 2813; on steel)                 | 80 / 89 / 22                                  |
| Film Hardness (pendulum hardness tester-König;<br>DIN EN ISO 1522) | after 1 day at 23 °C after<br>7 days at 23 °C |
|  | 115 s<br>160 s                                |

Suppliers

- (1) Covestro ([www.covestro.com](http://www.covestro.com))
- (2) BASF ([www.basf.com](http://www.basf.com))
- (3) Milliken ([www.milliken.com](http://www.milliken.com))
- (4) Venator ([www.venatorcorp.com](http://www.venatorcorp.com))

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