

## Industrial Coatings

## US SF 1.2.

2K PU red topcoat, based on Bayhydrol A 145 / Bayhydur 304

Component 1	Raw Material	Supplier	% By Weight
	Bayhydrol A 145	(1)	93.6
	Borchi® Gen 0851	(2)	2.1
	Borchi® Gel PW 25	(2)	0.3
	Surfynol 104 BC	(3)	2.0
	Irgazin® Red L 3660 HD	(4)	2.0
	<i>Dispersion: 60 min, on Skandex BAS-20, in 250 ml screw-top jar with 200 g Zr-silicate grinding beads</i>		
	<b>Total</b>		<b>100.0</b>

Component 2	Bayhydur 304	(1)	27.7
	Dipropylene glycol dimethyl ether	(5)	4.8
	<b>Total</b>		<b>32.5</b>
	<i>Incorporation: stir for approx. 5 min in a dissolver</i>		

Suggested Application Methods: spray

### Formulation Parameters

NCO : OH - ratio	1.5 : 1
Ratio Comp. 1 : 2	3.1 : 1
Thinning with water	approx. 15 %

### Properties

Spray viscosity (DIN 53211-cup 4mm, at 23 °C)	approx. 30 s
Pot life	approx. 2 h
Drying (dust free)	approx. 30 min
Drying (tack free)	approx. 3 h
Haze (DIN 67530)	20
Gloss (20° angle) (ISO 2813)	86

### Suppliers

- (1) Covestro ([www.covestro.com](http://www.covestro.com))
- (2) Milliken ([www.milliken.com](http://www.milliken.com))
- (3) Evonik ([www.evonik.com](http://www.evonik.com))
- (4) BASF ([www.basf.com](http://www.basf.com))
- (5) Clariant ([www.clariant.com](http://www.clariant.com))

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