

## 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; DIN EN ISO 1522)	after 1 day at 23 °C after 7 days at 23 °C
	115 s 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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