

BILACRYL® PU D34

2C-PUR Top Coat, Metallic satin matt

Product range

BILACRYL® PU D34	Metallic coarse
BILACRYL® PU D44	Metallic fine

Product Description

High quality, 2-component top coat with metallic effect. Excellent resistance to effects of weather and industrial atmospheres. Very good colour and chalking resistance, as well as mechanical resistance. Sustained thermal resistance up to 120 °C dry heat.

Areas of Application

Top coat for light-fast and weather-resistant objects such as vehicle and metal construction parts.

Application and Thinning

Conventional spraying.

Do not apply at temperatures below + 5 °C. Surface temperature must be at least 3°C above dew point to prevent condensation during application.

Can be recoated with Bilacryl PU D34/D44, Duoplast U265/U265 after 16 hours at 20 °C or after 4 days at the latest.

Application method	Thinning	Nozzle	Pressure
Conventional spraying	with 5-10 % V2, V109 to 18 - 22" DIN 4	1.5 - 1.8 mm	3 - 4 bar

Depending on application method, variations in colour can arise with metallic paints. The dilution strength and choice of thinner, as well as other parameters in application related to the equipment, can significantly affect the gloss and the colour. Excessively wet spraying can cause an unsightly effect and cloudiness. If necessary, the paint for the final coat can be heavily diluted and atomized to achieve a lighter shade.

Special Notes

H2 Hardener is **moisture-sensitive**.

Our data are based on a dry coat thickness of approx. 60 µm in the case of primers, and approx. 40 µm in the case of top coatings, standard climate 23/50 DIN 50014.

The information contained in this technical data sheet is based on general technical standards and is meant for specialists. Any changes in the recommended operating procedures or specified environmental conditions may influence the results significantly. Our guarantee covers only the quality of the material delivered. We do not undertake any responsibility for the application. In case of doubt, we recommend contacting our Technical Service. Our products are under constant development. Therefore please note date of issue of our technical data sheet and ask for latest edition.

Safety Measures

Bilacryl PU D34/D44 contains solvents and is combustible, therefore protect from heat and keep away from naked flames. Sufficient air circulation must be provided. Do not inhale vapours. All regulations regarding work hygiene and operational measures must be observed.

Technical Data

Binder	2-C Acrylate-Isocyanate
Finish	Satin matt
Colour	RAL 9006, RAL 9007 and samples
Substrate	2-component primers, e.g. - Duopol EP C100 - Biladur EP C90 - Vernit EP C400 - Bilacryl PU C160 - Duopol EP D253 (intermediate coat) - Amerlock 400 AL + Color The surface must be dry and free of grease and dust.
Thinner	V2, V109 Use of other thinners can lead to defects and loss of quality.
Packaging	Pigment: 5 / 10 kg disposable containers Hardener: 1 / 2 kg disposable containers
Storage	Pigment components 12 months, hardener 6 months in original, unopened containers at 20 °C.
Waste disposal	Residues and expired material are considered as special refuse and are to be taken to the toxic waste disposal unit, VeVa-code 08 01 11.

Components Hardener	2 H2
Mixing ratio	5 : 1 wt.-parts
Potlife	approx. 4 hrs at 20 °C
Drying (23 °C)	Dust-dry approx. 30 min. Dry to touch approx. 4 hours Transportable approx. 24 hours Drying times depend on film thickness, substrate and air temperatures.

Solids content	By weight: approx. 60 %
Density (20 °C)	By volume: approx. 51% } mixture, silver approx. 1.2 kg/l } RAL 9006
Theoretical consumption	approx. 95 g/m ² @ 40 µm

	Bilacryl PU D34/D44	Hardener H2	Thinner V2	Thinner V109
Flash point	25 °C	40 °C	- 4 °C	27 °C
UN-No.	UN-free	1263	1263	1263
Danger class RID/ADR	free	3 III	3 II	3 III
VOC content	42 %	44 %	100 %	100 %

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