

BILACRYL® PU D11/D31/D41

2C-PUR Top Coat

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| Product range | |
| Bilacryl PU D11 | Gloss |
| Bilacryl PU D31 | Satin gloss |
| Bilacryl PU D41 | Satin matt / matt |

Product Description

High quality lead and chromate free 2-pack top coat with very good color and gloss retention as well as chalking resistance. Resistant to water, diluted acids and chemicals. Excellent abrasion and impact resistance and flexural strength. Sustained thermal resistance up to 120 °C dry heat.

Areas of Application

Top coat for light-fast and weather-resistant coatings on steel constructions, vehicles (lorries), cable cars, rail vehicles, machinery, apparatus and instruments.

Application and Thinning

Conventional, electrostatic and airless spraying. Brushing of smaller areas is possible.

For better spray mist absorption when applying to large areas, the use of V109 thinner is recommended.

Environmental conditions:

Air temperature 0 - 50 °C

Surface temperature 0 - 60 °C

Surface temperature must be at least 3 °C above dew point to prevent condensation on the surface.

Can be recoated with Bilacryl after 6 hours at 20 °C. If allowed to dry out completely (over 4 days) the first coat will need superficial sanding.

| Application Method | Thinning | Nozzle | Pressure |
|------------------------|-------------------------------------|---------------------|-----------|
| Conventional spraying | approx. 20 % V2 to 20 - 25" DIN 4 | 1.5 - 1.8 mm | 3 - 4 bar |
| Electrostatic spraying | approx. 20 % V109 to 20 - 25" DIN 4 | depending on object | |
| Airless | up to 5 % V2 | Narrow | 211 |
| | | Medium | 411 |
| | | Wide | 611 |

Special Notes

Hardeners H2 and H3 are **moisture-sensitive**.

Our instructions are referring to normal climate 23/50. 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 have a significant impact on the results. Our guarantee covers only the quality of the material supplied. We do not accept any responsibility for the application. In case of doubt, we recommend to contact our Technical Service. Our products are under constant development. Therefore, please note the date of issue of our technical data sheet and ask for latest edition (also available directly from our website).

Safety Measures

Bilacryl contains solvents and is combustible. Protect from heat and keep away from naked flames. Ensure that ventilation is adequate. Do not inhale vapours. The Safety Data Sheet as well as the general regulations regarding work hygiene and operational measures must be observed.

Technical Data

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| Binder | 2C Acrylate-Isocyanate |
| Finish | from matt to glosse |
| Color | Shade cards RAL, NCS or sample |
| Substrate | 2-component primers, e.g. - Duopol Steelguard C80 - Biladur EP C90 - Bilacryl PU C160 - Duopol EP D253 (intermediate coat) The substrate must be dry and free of grease and dust. To achieve a good coverage property with the lead free yellow, orange and red colors, we recommend the use of a white primer. |
| Thinner | V2, V109 The use of other thinners can lead to defects and loss of quality. |
| Packaging | Pigment: 5 / 10 kg disposable cont. Hardener: 1 / 2 kg disposable cont. |
| 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. |

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| Components Hardener | 2 D11 H3 D31 / D41 H2 |
| Mixing ratio Potlife | 5 : 1 wt.-parts D11 approx. 8 hrs at 20 °C D31 / D41 approx. 4 hrs at 20 °C Dust-dry approx. 30 min. |
| Drying (23 °C) | Dry to touch approx. 4 hours Transportable approx. 24 hours |
| Forced drying | Drying times depend on film thickness, substrate and air temperatures. Possible after 10 min. flash-off time, e.g. 30 min. @ 80 °C |

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| Solids content | By weight: approx. 64 % By volume: approx. 53 % approx. 1,2 kg/l | } mixture red } RAL 3000 |
| Density (20 °C) | | |
| Theoretical consumption | approx. 93 g/m ² @ 40 µm | |

| | Bilacryl | H2 | H3 | V2 | V109 |
|------------------|----------|------|--------|-------|-------|
| VOC value | 32,5 % | 44 % | 27,5 % | 100 % | 100 % |

(replaces issue 08.17)

03.23