

BILACRYL® PU D611

PUR Top Coat water-dilutable gloss

Product Description

High quality 2-component top coat with very good colour and gloss retention as well as chalking resistance. All colours are lead and chromate free. Resistant to diluted acids and chemicals. Excellent abrasion and impact resistance and flexural strength. Comparable to equivalent conventional 2C-PUR paints.

Areas of Application

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

Application and Thinning

Conventional and airless spraying.

Application at temperatures of min. + 10 °C until max. + 40 °C. Surface temperature must be at least 3 °C above dew point to prevent condensation during application. Relative humidity of > 15 % until max. 80 %.

The hardener is easy to stir. The use of a mixer / a drill fastens to get a homogenous result. The exceed of potlife causes a loss of gloss.

Can be recoated with Bilacryl PU D611 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	25 - 30% water to 20 - 25 " DIN 4	1.2 - 1.4 mm	3 bar
Airless	up to 10 % water	narrow 211 medium 411 wide 611	

Cleaning of Equipment

Empty remaining paint from application equipment and rinse thoroughly with a little water (use for dilution). Repeat if necessary and then rinse with V120 Cleaner or cleaning thinner.

Special Notes

Bilacryl PU D611 is **frost-sensitive**.
H631 Hardener is **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).

Technical Data

Binder	2-Component Polyurethane
Finish	Gloss
Color	Color cards RAL, NCS or sample
Substrate	2-component primers, e.g. - Duopol Steelguard C80 - Biladur EP C90 - Bilacryl PU C180 - Neolin F700 The substrate must be dry and free of grease and dust.
Thinner	Water
Packaging	Pigment: 9 kg disposable container Hardener: 4,5 kg disposable container
Storage	Pigment components 6 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 H631
Mixing ratio	2 : 1 wt.-parts
Potlife	diluted approx. 3 hrs at 20 °C
Drying (23 °C)	Dust-dry approx. 2 hrs Dry to touch approx. 5 hrs Transportable approx. 16 hrs
	Drying times depend on film thickness, substrate, air temperatures and air humidity.
Forced drying	Possible after 60 min. flash off time, e.g. 30 - 60 min. @ 80 °C

Solids content	By weight: approx. 51 %	} mixture, white
Density (20 °C)	By volume: approx. 49 % Approx. 1.1 kg/l	
Minimum film thickness according to SN 555001	30 µm	
Theoretical consumption	approx. 65 g/m ² @ 30 µm	

	Bilacryl PU D611	Hardener H631
VOC value	7.5 %	0 %

(replacing version 07.17)

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Safety measures

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.