

BILACRYL® PU HS

2C-PUR High Solid Top coat

Product range

Bilacryl® PU HS D311	Gloss
Bilacryl® PU HS D331	Satin gloss
Bilacryl® PU HS D341	Satin mat

Product Description

Excellent 2-component PUR High Solid Top Coat with good gloss stability, excellent color and chalking resistance. Resistant against water, diluted acids and chemicals. Excellent abrasion, impact and flexural strength. Fulfilling with a COV value of < 380 g/l in ready to use condition the present solvent regulations.

Areas of application

Top coat as fade and weather-resistant paint on steel constructions, commercial vehicles and machines as well as for equipments and housings.

Coating systems according to DIN/EN/ISO 12944

C3 h	180 µm	1 x 120 µm 1 x 60 µm	Duopol EP C80 Steelguard Bilacryl PU HS
C4 h	240 µm	1 x 180 µm 1 x 60 µm	Duopol EP C80 Steelguard Bilacryl PU HS
C5 h	260 µm	1 x 100 µm 1 x 100 µm 1 x 60 µm	Duopol EP C80 Steelguard Duopol EP D253 Bilacryl PU HS

Application and dilution

Wet-in-wet application possible with Bilacryl C160 possible after 6 hours, depending on the film thickness. Very good ca. 60 µm at 20 °C. Temperature of object (+ 10 °C until + 35 °C) must be at least 3 °C above dew point, in order to prevent condensation during application.

Application type	Thinning / Regulation	Nozzle
Conventional spraying	V2, V109 25 - 30 " DIN 4	1.4 – 1.6 mm
Electrostatic spraying	V2, V109 25 - 30 " DIN 4	depending on object
Airless spraying	0 – 5 % V2, V109 ca. 60 " DIN 4	depending on object, e.g. medium 411
Brushing, rolling	V109 if necessary	

Special Notes

Hardener H310 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).

Safety measures

Bilacryl PU HS 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

Binder	2C-Polyurethane High Solid
Finish	Gloss, Satin gloss, Satin mat
Colors	Shade cards RAL, NCS or sample
Substrate	2C-primers and 2C-micaceous (see coating systems) Direct adhesion on the following substrates: - swept galvanizing - chromated aluminium To obtain a good coverage of lead-free yellow, orange and red tones, we recommend the use of pale-colored primer. Substrate must be dry and free of grease and dust.
Thinner	V2, V109 The use of other thinners can lead to defects and loss of quality.
Packaging (see mixing ratio)	Pigment 5 / 10 kg, resp. 3,5 / 7 / 14 kg Hardener 0,5 / 1 kg, resp. 0,5 / 1 / 2 kg
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 H310
Mixing ratio	7 : 1 wgt.-parts Gloss 10 : 1 wgt.-parts Satin gloss 10 : 1 wgt.-parts Satin matt
Potlife	ca. 4 hrs at 20 °C
Drying (23°C)	Dust-dry ca. 60 minutes Dry to touch ca. 8 hours Transportable ca. 24 - 36 hours Drying times depend on film thickness, substrate and air temperatures.
Forced drying	Possible after 30 min. flash-off time, e.g. 30 min. @ 80 °C

Solids content wgt.-%	ca. 75 %	} mixture } light grey
Solids by volume	ca. 60 %	
Density (20°C)	ca. 1,25 kg/l	
Theoretical consumption	ca. 110 g/m² @ 60 µm	
Theoretical VOC (with ca. 10 % V109)	ca. 32 % (light grey)	

	Bilacryl PU HS D311/D331/D341	Hard. H310	V109	V2
VOC value	20 - 25 %	10 %	100 %	100 %

(replaces edition 03.13)

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