

# BILADUR® EP D255

2C-EP Clear Coat gloss,  
satin gloss, texture

## Product Description

2-component epoxy clear coat for interior use, with good chemical and mechanical properties. Resistant to alkaline and acid solutions, sweat from hands, water, oils and chemicals. The hardened coating is very abrasion-resistant. Sustained thermal resistance up to 140 °C dry heat.

## Areas of Application

Top coat for repainting light metals for interior use.

## Application and Addition of Thinner

Conventional and airless spraying.

Do not apply at temperatures below + 10 °C. Surface temperature must be at least 3 °C above dew point to prevent condensation during application.

Can be recoated with Biladur EP D255 after 15 hours at 20 °C. If allowed to dry out completely (over 4 days) the first coat will need superficial sanding.

Application Method	Thinning	Nozzle
Conventional spraying	with 0.5 - 10 % V2 to 20 - 25 sec. DIN 4	1.5 - 1.8 mm
Airless spraying	with 0 - 5% V2 to ca. 50 - 60 sec. DIN 4	narrow 211 medium 411 wide 615
Electrostatic spraying	with 0,5 - 10 % V2 to 20 – 25 sec. DIN 4	depending on object

## Special Notes

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 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

Biladur EP D255 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

<b>Binder</b>	2-component Epoxy resin
<b>Finish</b>	Gloss, satin gloss
<b>Color</b>	Colorless
<b>Substrate</b>	Light metals and metallic coatings. The surface must be dry and free of grease and dust.
<b>Thinner</b>	V2 Use of other thinners can lead to defects and loss of quality.
<b>Packaging (disposable container)</b>	Pigment 3 / 9 kg Hardener A: 1.5 / 4.5 kg Hardener B: 3 / 9 kg
<b>Storage</b>	Pigment components 12 months, hardener 6 months in original, unopened containers at 20 °C.
<b>Waste disposal</b>	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.

<b>Komponenten</b>	2
<b>Hardener and Mixing Ratio (MR)</b>	Hardener A: MR 2:1 gloss Hardener B: MR 3:4 satin gloss + Texture
<b>Pot duration</b>	approx. 24 hrs. at 20 °C
<b>Drying (23 °C)</b>	Dust-dry approx. 2 hours Dry to touch approx. 4 - 6 hours Transportable approx. 24 hours Drying times depend on film thickness, and substrate and air temperatures.
<b>Forced drying</b>	possible, e.g. 30 min. @ 80 °C

<b>Solids content Mixture</b>	By weight: approx. 51 % with Hardener A approx. 64 % with Hardener B By volume: approx. 48 % mixture Hardener A
<b>Density (20 °C)</b>	approx. 1 kg/l mixture Hardener A
<b>Theoretical consumption</b>	approx. 85 g/m <sup>2</sup> @ 40 µm

	Biladur EP D255	Hardener A	Hardener B	V2
<b>VOC value</b>	48 %	63 %	32 %	100 %

(replaces issue 10.08)

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