

# DUOPLAST® U550

Plastic Filler  
Water-dilutable

## Product Description

High quality, water-dilutable two-pack filler, specially developed as a coating for synthetics. Very good chemical properties.

## Areas of Application

Filler for high quality synthetic products which must satisfy the highest demands, such as machine parts, casings, shower cubicles, bathroom fittings, office furniture, car accessories, vehicle components.

## Application

Conventional spraying or with a pressure tank

Hardener should be added in a stirrer.

Important for application and drying:

- air temperature ideal 20 - 25 °C / min. 10 °C
- air humidity ideal 40 - 60 % / max. 80 %
- object temperature above + 10 °C
- air velocity 0.4 - 0.8 m/s

To obtain an optimal surface and thorough drying, sufficient air circulation must be provided.

Mould release agents must be removed with suitable cleaners.

Can be sanded after 6 hours.

Can be over-coated with Duoplast after 6 hours at 20 °C.

## Addition of Water

Pressure tank and conventional spraying 15 - 20 % water (wt.-%)

## Cleaning of Equipment

Remove remaining paint from equipment and rinse thoroughly with little water. Repeat if necessary and then rinse with special cleaner V121.

## Special Notes

Hardener H631 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

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-pack Polyurethane
<b>Finish</b>	Matt
<b>Color</b>	White Other colors on request
<b>Substrate</b>	Plastics such as PUR-hard foam. Mould release agents <b>must</b> be removed. The surface must be dry, and free of grease and dust.
<b>Thinner</b>	Water
<b>Packaging</b>	Pigment: 20 kg disposable container Hardener: 2 kg disposable container
<b>Storage</b>	Pigment components and hardener 6 months in original, unopened containers stored at 20 °C
<b>Waste disposal</b>	Residues and expired material are considered as special refuse and must be taken to the toxic waste disposal unit, VeVa-code 08 01 11.

<b>Components</b>	2
<b>Hardener</b>	H631
<b>Mixing ratio</b>	10 : 1 wt.-parts
<b>Potlife</b>	approx. 2 hours at 20 °C
<b>Drying (23 °C)</b>	Dust-free approx. 1 hour Dry to touch approx. 2 - 3 hours Thoroughly dry approx. 20 hours Drying times depend on film thickness, surface and air temperatures.
<b>Forced Drying</b>	possible, e.g. 30 minutes @ 80 °C

<b>Solids content weight-%</b>	approx. 64 %	} Mixture, white
<b>Solids volume</b>	approx. 50 %	
<b>Density (20 °C)</b>	approx. 1,4 kg/l	
<b>Recommended film thickness</b>	40 µm	
<b>Theoretical consumption</b>	approx. 135 g/m <sup>2</sup> at 40 µm	

	<b>Duoplast U550</b>	<b>Hardener H631</b>
<b>VOC value</b>	2 %	0 %

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