Technical Data Sheet

DUOPOL® PU D81 / D84

2C-PUR Top coat

Product range

Duopol PU D81	Satin gloss
Duopol PU D84	Metallic

Product Description

Cost-effective 2-component PUR top coat with quick drying properties, excellent chalking resistance and color retention, and high mechanical stability. Can be applied in one operation up to 100 µm dry film thickness. Sustained thermal resistance up to 120 °C. Very good adhesion on degreased Zincor plates.

Coating systems in accordance with DIN EN ISO 12944

C3 h	**180 µm**	1 x 120 µm 1 x 60 µm	Duopol Steelguard C80 Duopol PU D81
C4 h	**240 µm**	1 x 180 µm 1 x 60 µm	Duopol Steelguard C80 Duopol PU D81
C5 h	**260 µm**	1 x 100 µm 1 x 100 µm 1 x 60 µm	Duopol Z60 Duopol Steelguard C80 Duopol PU D81

Application

Airless, airmix , pressure tank or electrostatic.

Duopol PU D81/D84 is suitable for 2C mixing systems. Temperature of object 5 °C - 35 °C.

Surface temperature must be at least 3 °C above dew point, in order to prevent condensation during application.

Application type	Thinning	Nozzle
Pressure tank	5 – 15 % V109 or V2	1.3 - 1.8 mm
Airless	0 – 5 % V109 or V2	narrow 211 medium 411 wide 611
Electrostatic Spraying	5 – 15 % V109	depending on object

Special Notes

Hardener H8 is **moisture-sensitive**.

Our indications are based on 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 significantly influence the results. Our guarantee covers only the quality of the material delivered. We do not accept 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 (also available directly from our website).

Safety Measures

Duopol PU D81/D84 contains solvents and is combustible. Protect from heat and keep away from naked flames. Ensure that ventilation is adequate. Do not inhale vapours. The Safeta Data Sheet as well as the general regulations regarding work hygiene and operational measures must be observed.

Technical Data

Binder	Acryl-Polyurethane
Finish	Satin gloss
Color	Shade cards RAL, NCS or sample
Substrate	2-component primers - Bilacryl PU C160 - Duopol Steelguard C80 - Duopol Z60 - Duopol EP D253 (intermediate coat) Direct adhesion on Zincor Surface must be dry and free of grease and dust. For good coverage of lead-free yellow, orange and red tones, we recommend the use of pale-colored primer.
Thinner	V109 (better spray mist absorption) or V2 The use of other thinners can lead to defects and loss of quality.
Packaging **D81**	Pigment 8 kg / 16 kg disposable containers Hardener 1 kg / 2 kg disposable containers
D84	Pigment 7 kg / 14 kg disposable containers Hardener 1 kg / 2 kg disposable containers
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	2	
Hardener	H8	
Mixing ratio	8 : 1 wgt.-parts 7 : 1 wgt.-parts	D81 satin gloss D84 metallic
Potlife	ca. 4 hrs at 20 °C	
Drying (23°C)	Dust-dry Dry to touch Transportable	ca. 30 minutes ca. 5 hours ca. 24 hours
	Drying times depend on film thickness, substrate and air temperatures.	

Solids content wgt.-%	ca. 74 - 78 %	white / RAL 9007
Solids by volume	ca. 61 - 63 %	
Density (20°C)	ca. 1.36 - 1.67 kg/l	
Theoretical consumption	D81 white D84 RAL 9007	ca. 135 g/m² @ 60 µm ca. 160 g/m² @ 60 µm

	Duopol PU D81 / D84	**Hardener H8**	**Thinner V109**	**Thinner V2**
VOC value	29 % / 24 %	27.5 %	100 %	100 %

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Monopol AG
Oberrohrdorferstrasse 51, CH-5442 Fislisbach
Telefon +41 56 484 77 77, Fax +41 56 484 77 99
info@monopol-colors.ch, www.monopol-colors.ch