

Water thinnable red mat/glossy stoving structure lacquer, based on Bayhydrol U 241

		A mat	B glossy	
Raw Material	Supplier	% by wt.	% by wt.	
Mill base formulation	Bayhydrol U 241	(1)	32.70	32.70
	Water		10.40	11.77
	DMEA, 10% in water		2.70	2.70
	Aerosil 200	(2)	2.00	—
	Borchi® Gel 0621	(3)	—	0.63
	Finntalc M 05	(4)	6.50	6.50
	Sicotan Yellow 1912	(5)	6.90	6.90
	Sicotan Red 3855	(5)	2.70	2.70
	Bayferrox 130 M	(6)	1.70	1.70
	Sachtleben R-KB-4	(7)	1.70	1.70
	Total		67.30	67.30
	<i>Place Bayhydrol U 241 and add the additives under mixing. Then disperse 30 min. in bead mill.</i>			
	Let down	Bayhydrol U 241	(1)	23.10
Cymel 327		(8)	9.60	9.60
Total			100.00	100.00
Incorporation: stir for approx. 5 min in a dissolver				

DMEA = dimethyl ethanolamine

Application

Compressed-air spraying

1. layer - application of a smooth layer

Spray application: 1.5 mm-nozzle; air pressure 2.5 bar

Dry film thickness: 25 – 30 µm

Drying: 6 min deaeration at room temperature; 4 min at 60 °C

2. layer - application of the structured layer

The appearance of the applied film could be varied from fine to rough by using a nozzle size from 1.8 to 4 mm.

Spray application: air pressure 0.8 - 1.0 bar

Drying: 10 min deaeration at room temperature; 15 min at 150 °C

Data	A		B	
	mat		glossy	
Bayhydrol / Amin resin - ratio	70 : 30			
Binder / Pigment - ratio	1 : 0.67			
Solids content on application	ap. 51.5 %		ap. 47.5 %	
Co-solvent content on application	ap. 3.8 %		ap. 3.6 %	
Amin content on application	ap. 0.7 %		ap. 0.7 %	
Thinning (water)	ap. 8 %		ap. 15 %	
Spray viscosity, DIN 53211-cup 4mm, at 23 °C	ap. 25 s		ap. 27 s	
Sagging of applied film	< 75 µm		175 µm	
Gloss (60°/ 85° angle), DIN 67530 / ISO 2813 (100 µm on ABS plate)	10 / 27		68 / 93	
Colour values (L / a / b)	46.6/38.2/24.6		41.9/43.9/31.7	
Adhesion (cross-cut test) on aluminium / steel	GT 0		GT 0	

Suppliers

- (1) Covestro (www.covestro.com)
- (2) Evonik Degussa (www.aerosil.com)
- (3) Borchers (www.borchers.com)
- (4) Omya (www.omya.com)
- (5) BASF (www.basf.com)
- (6) Lanxess (www.bayferrox.de)
- (7) Sachtleben (www.sachtleben.de)
- (8) Cytec Surface Specialities (www.cytec.com)

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Borchers GmbH

Berghausener Str. 100 / 40764 Langenfeld / Telephone: +49 (0) 2173 – 39 26 666
 Fax: +49 (0) 2173 – 39 26 999 / Internet: www.borchers.com / E-Mail: info.info@borchers.com

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