

**Aqueous white glossy two-pack PU topcoat, fast drying, good hardness, based on Bayhydrol A 2470 / Bayhydur 304**

	Raw Material	Supplier	% by wt.
<b>Comp. 1</b>	1. Bayhydrol A 2470, 45% in water / solvents mixture	(1)	42.60
	2. Surfynol 104 BC	(2)	0.70
	3. <b>Borchi® Gel Thix 921</b>	(3)	0.14
	4. <b>Borchi® Gol LA 200</b> , 10% in butyl glycol	(3)	0.88
	5. <b>Borchi® Gol LA 50</b>	(3)	0.30
	6. <b>Borchi® Gen SN 95</b>	(3)	2.24
	7. Sachtleben R-KB-4	(4)	28.04
	8. Water		5.59
	<b>Total</b>		<b>80.49</b>
<b>Comp. 2</b>	9. Bayhydur 304, 100%	(1)	15.61
	10. Butoxyl		3.90
	<b>Total</b>		<b>100.00</b>

## Production indications

### **Formulation Topcoat Comp. 1**

Place const. 1. in a vessel. Stir in successively const. 2.-6. (5 min at 2000 rpm). Add gradually const. 7. under stirring at approx. 2000 rpm. Then pre-disperse for 10 min at approx. 2000 rpm and further disperse for 60 min in the mill base ( $T \leq 30^{\circ}\text{C}$ ) until reaching particle size  $\leq 10\mu\text{m}$ . Add gradually const. 8. under stirring. Afterwards filtrate.  
**Leave to deaerate for one day.**

### **Formulation Hardner Comp. 2**

Add Butoxyl into Bayhydur 304 for thinning and homogenize.

Mix Comp. 1 and Comp. 2 and homogenize.

## Application

Spraying using HVLP-pneumatic flow cup spray gun (nozzle 1.4mm /air pressure: approx. 1.9 bar)

(Before application add approx. 20% water for adjusting the spray viscosity.)

## Technical data

NCO : OH - ratio	1.5 : 1
Mixing ratio (comp. 1 : comp. 2)	100 : 24
Pigment : Binder - ratio	0.8 : 1
Spray viscosity, DIN 53211-cup 4 mm, at 23 °C	approx. 20 s
VOC (calculated acc. Directive 1999/13/EC)	approx. 165 g/l
Solid content on application	approx. 57 %
Drying time (DIN 53150; <b>TG 1 / TG 3</b> )	0,5 h / 2 h
Gloss 20° / 60° / Haze (DIN EN ISO 2813; on steel)	80 / 89 / 22
Film Hardness (pendulum hardness tester-König; DIN EN ISO 1522)	after 1 day at 23 °C after 7 days at 23 °C
	115 s 160 s

## Suppliers

- (1) Covestro ([www.covestro.com](http://www.covestro.com))
- (2) Air Products ([www.airproducts.com](http://www.airproducts.com))
- (3) Borchers ([www.borchers.com](http://www.borchers.com))
- (4) Sachtleben ([www.sachtleben.de](http://www.sachtleben.de))

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