

Water thinnable two-pack PU clear coat / top coat (white), based on Bayhydrol A 145 and Bayhydur 304

		A	B	
		clear coat	white coat	
Raw Material	Supplier	% by wt	% by wt	
Component 1	Bayhydrol A 145	(1)	48.30	40.20
	Surfynol 104 BC	(2)	1.10	0.90
	Borchi® Gel 0620	(3)	0.13	0.13
	Borchi® Gol LA 50	(3)	1.00	1.00
	Borchi® Gol LA 200 (7:3) , 10% in butyl glycol			
	Borchi® Gen 0851	(3)	—	2.00
	Sachtleben R-KB-4	(4)	—	24.90
Total			50.60	69.20
<i>Weigh in Bayhydrol A 145, add the additives under stirring and mix for about 10 min. at 2000 rpm; then disperse the pigment. Subsequently leave to rest one day for defoaming.</i>				
Component 2	Bayhydur 304	(1)	15.10	12.60
	Dipropylene glycol dimethyl ether	(5)	3.80	3.10
	Total		18.90	15.70
Water (for thinning)			30.57	15.17
Total			100.00	100.00
<i>Incorporation: about 5 min in a dissolver</i>				

Application Compressed-air spraying

Data	A	B
	clear coat	white coat
NCO : OH - ratio	1,5 : 1	1,5 : 1
Spray viscosity, DIN 53211-cup 4mm, at 23 °C	ap. 25 s	ap. 30 s
Solids content, 1,5 h / 110 °C	39 %	53 %
Density, at 20 °C	1.03 g/cm ³	1.24 g/cm ³
VOC-content, DIN ISO 11890-1	< 187 g/l	< 130 g/l
Pot life	> 7 h	> 6 h
Drying at room temperature forced at 60 °C	24 h 30 min	24 h 30 min
Pendulum hardness, (König method) DIN EN ISO 1522 (100 µm on glass) after 1 day after 3 days after 7 days	 152 s 159 s 167 s	 58 s 100 s 122 s
Haze and Gloss (60° angle), DIN 67530 / ISO 2813 (100 µm on glass)	18 / 79	24 / 86

Suppliers

- (1) Covestro (www.covestro.com)
- (2) Air Products (www.airproducts.com)
- (3) Borchers (www.borchers.com)
- (4) Sachtleben (www.sachtleben.de)
- (5) Clariant (www.clariant.com)

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