

**Aqueous two-pack PU clear coat,
based on Bayhydrol U XP 2766 / Bayhydur XP 2655**

Component 1	Raw Material	Supplier	% by wt
	1. Bayhydrol U XP 2766	(1)	64.10
	2. Borchi®Gol LA 2	(2)	0.13
	3. Borchi®Gol LA 50	(2)	0.17
	4. Borchi Gol LA 200	(2)	0,13
	5. Water		8.50
	<i>Total</i>		<i>73.03</i>

Component 2	6. Bayhydur XP 2655, 100%	(1)	17.84
	7. Tinuvin 384-2, 50% in Butoxyl	(3)	1.31
	8. Tinuvin 292 , 50% in Butoxyl	(3)	0.87
	9. Butoxyl (methoxy butyl acetate)	(4)	6.95
	<i>Total</i>		<i>100.00</i>

Production indications**Formulation comp. 1**

Place const. 1. in the mixing vessel. Stir in successively const. 2.-4. (5 min at 2000 rpm). Add gradually const. 5. under stirring at approx. 2000 rpm. Leave to deaerate for one day.

Formulation hardener

Stir in successively const. 6.-9. at approx. 2000 rpm.

*Mix components 1 and 2 for 2 minutes at 1000 rpm.
Add water to adjust the application viscosity.*

Technical data

NCO : OH - ratio	1.5 : 1
Solid content on application (at 30 s application viscosity)	ap. 45 %
Spray viscosity, DIN 53211-cup 4 mm, at 23 °C component 1 + component 2 + approx. 10 % water	25 s
VOC (calculated acc. Directive 1999/13/EC)	164 g/l
Gloss 20° / 60° (DIN EN ISO 2813) on ABS (Bayfoil)	92 / 95
Drying time (DIN 53150; at RT; TG 1 / TG 2 / TG 3)	0.5 / 3 / 4 h
Film Hardness (pendulum hardness tester-König; DIN EN ISO 1522) (after 30 min 80 °C)	219 s

Suppliers

- (1) Covestro (www.covestro.com)
- (2) Borchers (www.borchers.com)
- (3) Ciba Speciality Chemicals (www.cibasc.com)
- (4) Celanese (www.celanese.com)

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