

Water thinnable two-pack PU clear coat, based on Bayhydrol A 145 and Bayhydur 304

	Raw Material	Supplier	% by wt.
Component 1	1. Bayhydrol A 145, 45%	(1)	48.3
	2. Surfynol 104 BC	(2)	1.1
	3. Borchi® Gel THIX 921	(3)	0.2
	4. Borchi® Gol LA 200 / Borchi® Gol LA 50 (3/7), 10%ig in BG	(3)	1.0
	Total		50.6
<i>Place const. 1. in the mixing vessel. Add under mixing const. 2.-4.; Mix further for 30 min. at 2000 rpm. Let rest 1 day for deaeration</i>			
Component 2	5. Bayhydur 304	(1)	15.1
	6. Butoxyl (Methoxy butyl acetate)		3.8
	Total		18.9
	Water (for thinning)*		30.5
	* to adjust the spray viscosity		
	Total		100.0
Incorporation: stir for approx. 10 min in a dissolver			

Data	
NCO : OH -ratio	1.5 : 1
Spray viscosity, DIN 53211-cup 4mm, at 23 °C	approx. 20 s
Pendulum hardness König method – DIN EN ISO 1522 (100 µm wet film thickness on glass) after: 1 day / 3 days / 7 days	120/150/160
Haze and Gloss (20°/60°angle), DIN 67530 / ISO2813 (100 µm wet film thickness on ABS)	16 / 83 / 88

Suppliers	(1) Covestro (www.covestro.com)
	(2) Air Products (www.airproducts.com)
	(3) Borchers (www.borchers.com)

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