



# PE 33

## Technical Data Sheet

### Description:

Self-priming polyurethane paint 2in1.

### Usage:

Fast-drying two-component primer and top-coat (2 in 1). Suitable for coatings of steel constructions, halls, containers, conveyors, production lines, machinery and equipments, containers, pipes and wood. Very high color fastness, adhesion, mechanical and chemical resistance. It is resistant against increased humidity, petroleum substances, oils, grease, alcohol and common cleaning products. Applicable by airless- or airmix-spraying, a brush or a roller. The second layer apply 45 minutes after the first layer, for brush/roller is recommended to apply the second layer after 16 hours

### Substrate:

Steel, zinc, wood, mineral substrates

### Colours:

RAL, VIT

### Specific gravity: ( SN EN ISO 2811-1)

1,24 g/cm<sup>3</sup>

### Solids: ( SN EN ISO 3251)

by weight 66 %

by volume 52 %

### Mixing ratio:

by weight 10 : 1 hardener PH 93

by volume 8 : 1 hardener PH 93

### Theoretical spreading rate: ( SN EN ISO 23811)

undiluted paint			
40 µm DFT	10,5 m <sup>2</sup> /kg	13,0 m <sup>2</sup> /liter	95,0 g/m <sup>2</sup>
80 µm DFT	5,3 m <sup>2</sup> /kg	6,5 m <sup>2</sup> /liter	190,0 g/m <sup>2</sup>

To reach 40 µm DFT apply 77 µm undiluted paint. Practical spreading rate depends on application method and conditions, shape and roughness of the surface.

### Drying: ( SN 673052)

120 µm WFT, temperature 23 ± 2°C, relative humidity 50 ± 5%, outflow time 60s, ISO outflow cup 6 mm	surface dry (grade 1)	to touch (grade 3)	to manipulation (grade 4)
	45 minutes	6 hours	8 hours

Drying and recoatability time strongly depend on wet film thickness, temperature, humidity, ventilation and paint colour. Fully load and measure the coated film after 7 days, laboratory testing after 3 weeks of drying under the above conditions.





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### Pot life: ( SN EN ISO 9514)

2,5 h., temperature  $23 \pm 2^{\circ}\text{C}$ , outflow time 60s, ISO outflow cup 6 mm

Pot life strongly depends on the paint temperature. At temperatures of  $30\text{-}40^{\circ}\text{C}$  it can be half, at temperatures of  $5\text{-}10^{\circ}\text{C}$  it can be several times longer.

### Gloss: ( SN ISO 2813)

Semi-matt 30 GU, angle-wise  $60^{\circ}$ , outflow time 60s, ISO outflow cup 6 mm

### Supply viscosity:

Thixotropic liquid unmeasurable by ISO outflow cup

### Recommended dilution: ( SN 673032)

	airless	brush/roller
thinner	PT 03	PT 03
by weight	7 %	8 %
by volume	10 %	11 %

### Sagging: ( SN EN ISO 16862)

temperature $23 \pm 2^{\circ}\text{C}$ , relative humidity $50 \pm 5\%$	
outflow time 60s, ISO outflow cup 6 mm	no sagging 300 $\mu\text{m}$ WFT

### Application conditions:

The surface must be dry. The air, surface and paint temperature cannot decrease below  $+5^{\circ}\text{C}$  during application and drying. Relative humidity cannot exceed 80%. The surface temperature must be at least  $3^{\circ}\text{C}$  above the dew point.

### Surface preparation:

Remove oil, grease, salt and other contamination from the surface with a suitable detergent according to SN EN ISO 12944-4. Use thinner or the highly effective ecological cleaner CL 07.

Steel surfaces: Abrasive blast-cleaning to Sa 21, alternatively manual or mechanical cleaning to min. St 3 corresponding to SN EN ISO 8501-1.

Galvanized surfaces: For reaching the required adhesion of the paint to the new hot-dip galvanized surfaces, the surface must be treated with a solution of ammonia water, which is prepared by mixing 5l of water, 0,25l of ammonia water (25% concentration) and 25ml of detergent. The surface is washed with the prepared solution until a gray foam is formed. This is followed by washing the foam off with the clean water. The paint can be applied after the surface is completely dry. When using this method the paint can be applied directly to the new hot-dip galvanized surface without a base paint.

For galvanized and older hot-dip galvanized surfaces, the required adhesion of the paint is fixed by manual roughening and subsequent washing with the ecological cleaning agent CL 07.

Aluminium substrate: Appropriate recommended priming coat necessary. This coating material is not intended for a direct application on this type of surface.

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Issued: 12.05.2022



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**Previously painted surfaces:** If the type of old paint is not known, first check the compatibility test. Clean up the oil and grease with thinner or cleaner CL 07, roughen the surface with a grinder. Apply mixed and diluted paint in small area. If the surface is not cracked within 30 minutes, then the coating is completely cured and adherent, the paint can be used for renovation. Treat the corroded places with the recommended primary paint. Observe the compatibility of old and new paints if you are not check the compatibility test.

**Wooden surfaces:** The surface must be dry and cleaned of contamination, wax, grease, flaking and incoherent material. Fill cracks and holes with a stopper on wood. Sand all filled and glossy surfaces. Remove the residual grit by vacuum cleaning. In case of increased risks apply an insecticidal and an antifungal agent. As a renovation coating apply one or two layers of paint, as a priming coat of uncoated wood apply two or three layers according to the structure of wood. For reaching the highest quality gently sand the surface by a sandpaper Nr. 240 after every coat.

**Mineral surfaces:** Remove oil, grease, salt and other contamination from the surface with a suitable detergent, sanding or blast cleaning as needed. Remove the residual grit by brushing or vacuum cleaning. Use RK 975 STOPPER for touch-up repairs, leveling and smoothing of the surface. In case of highly strained systems it is necessary to test the solidity of the mineral surface. Observe the compatibility of preceding and subsequent paints when renovating previously painted surfaces.

### Application method:

Airless spraying, airmix spraying, brush or roller.. For airless spraying use the nozzle orifice of 0.011" - 0.021", nozzle pressure: 120 - 180 bar, adjust the angle of application to the shape of the surface. For spraying use the nozzle orifice of 1.5 - 2 mm, nozzle pressure: 3 - 4 bar. For application by brush/roller select appropriate equipment according to the paint type and viscosity.

### Storage:

in the original unopened packaging at temperatures between +5°C and +25°C

### Packaging in kg:

0,8; 3; 10; 25

### Packaging of base 0100 in kg:

0,784; 2,94; 9,8; 24,5

### Packaging of base 0000 in kg:

0,64; 2,4; 8; 20

### Notes:

DFT - dry film thickness	MS - medium dry matter	GU - Gloss Unit
WFT - wet film thickness	HS - high dry matter	KU - Krebs unit of viscosity

All information given in this technical data sheet are based on our best knowledge, laboratory test results and practical experience to the date specified below. According to the fact that the conditions of the product's use are out of our control, we can only guarantee the product quality itself. As a producer we cannot be responsible for damage arising from the use of the products without following above recommended instructions or for improper purposes. We reserve the right to change above specified information without prior notice. Always request the actual version of the product data sheet. This technical data sheet replaces all previously released. The validity of the data provided here will be terminated automatically after five years.

