PE 73

Technical Data Sheet

Description:

Self-priming high-solid polyurethane paint 2 in 1

Usage:

Fast-drying high-solid 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

Certificates, protocols:

Certificate No. 240018 of National institute of public health for direct contact with all kinds of foodstuffs

Substrate:

Steel, zinc

Colours:

DB

Specific gravity: (ČSN EN ISO 2811-1)

1,66 g/cm3

Solids: (ČSN EN ISO 3251)

by weight	84 ± 2 %
by volume	69 ± 2 %

Mixing ratio:

by weight	12	:	1	hardener	PH 97	8	:	1	hardener	PH 92	8 : 1 hardener PH 95
by volume	9	:	1	hardener	PH 97	6	:	1	hardener	PH 92	6 : 1 hardener PH 95

Theoretical spreading rate: (ČSN EN ISO 23811)

undiluted paint			
40 µm DFT	10,4 m2/kg	17,3 m2/liter	96,0 g/m2
80 µm DFT	5,2 m2/kg	8,6 m2/liter	192,0 g/m2

To reach 40 µm DFT apply 58 µm undiluted paint. Practical spreading rate depends on application method and conditions, shape and roughness of the surface.

Drying: (ČSN 673052)

120 µm WFT, temperature 23 ± 2°C, relative humidity 50 ± 5%, outflow time 70s, ISO outflow cup 6 mm	suface dry (grade 1)	to touch (grade 3)	to manipulation (grade 4)
	50 minutes	5 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: (ČSN EN ISO 9514)

4 h., temperature 23 ± 2°C, outflow time 70s, ISO outflow cup 6 mm

Pot life strongly depends on the paint temperature. At temperatures of 30-40°C it can be half, at temperatures of 5-10°C it can be several times longer.

Gloss: (ČSN ISO 2813)

Semi-gloss 50 GU, angle-wise 60°, outflow time 70s, ISO outflow cup 6 mm

Supply viscosity:

Thixotropic liquid unmeasurable by ISO outflow cup type

Recommended dilution: (ČSN 673032)

	airless	brush/roller
thinner	PT 03	PT 03
by weight	7 %	10 %
by volume	13 %	19 %

Sagging: (ČSN EN ISO 16862)

temperature 23 ± 2°C, relative humidity 50 ± 5%	
outflow time 70s, ISO outflow cup 6 mm	no sagging 250 µm WFT

Application conditions:

The surface must be dry. The air, surface and paint temperature cannot decrease below +5°C during application and drying. Relative humidity cannot exceed 80%. The surface temrepature must be at least 3°C above the dew point.

Surface preparation:

Remove oil, grease, salt and other contamination from the surface with a suitable detergent according to ČSN EN ISO 12944-4.

Steel surfaces: Abrasive blast-cleaning to Sa 2½, alernatively manual or mechanical cleaning to min. St 3 corresponding to ČSN 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% concetration) 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.

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.

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Application method:

Airless spraying, airmix spraying, brush or roller.. For airless spraying use the nozzle size 17 (217, 317, 417), nozzle pressure: 160 bar, adjust the angle of application to the shape of the surface. A visible difference in shade occurs when touch-up coatings are applied with a brush/roller, as well as when airless application parameters are not observed. For airmix 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:

12; 24

Packaging of base 0000 in kg:

10,8; 21,6

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.

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