

DUOPLAST® U231/U241/U251/U261 2C PUR Top Coat

Product range	
Duoplast U231	Matt
Duoplast U241	Satin matt
Duoplast U251	Satin gloss
Duoplast U261	Gloss

Product Description

High quality two-pack top coat, specially developed for painting challenging objects. Very good chemical and mechanical properties. Resistant to hand perspiration, weak acids and chemicals. Good light fastness and partially weather-resistant. The hardened coating is tough, flexible, abrasion-resistant, dirt-repellant and easy to maintain.

Areas of Application

Top coat for high quality items of the plastics and metal working industries, which must fulfil the highest standards, such as machine parts, casings, shower cubicles, bathroom fittings, office furniture, TV and HiFi equipment, car accessories and components.

Application and Thinning

Conventional spraying.

Do not apply at temperatures below + 5 °C.

Metal industry: Thinner V2
Plastic industry: Thinner V101 or V102

Application Method	Thinning	Nozzle	Pressure
Conventional Spraying	with 20 - 25 % V2, V101, V102 on 25 - 30" DIN 4	1.2 - 1.5 mm	3 - 4 bar
Airbrush spraying	with 20 - 25 % V2 on 25 - 30" DIN 4	depending on equipment	
Airless	up to 7 % V2	narrow medium large	211 411 611

Plastics

Mould release agents must be removed with suitable cleaners. For high quality coatings precoat with Bilacryl PU C160.

PVC must be rinsed with Thinner V102 before coating. For painting PVC, Duoplast should be diluted with Thinner V102.

Can be recoated with Duoplast after 6 hours at 20 °C. If allowed to dry out completely (over 4 days), a superficial sanding is necessary.

Special Notes

H3 Hardener is **moisture-sensitive**.

Our indications are based on a dry film thickness of approx. 40 µm Normal climate 23/50. The information contained in this technical data sheet is based on general technical standards and is meant for specialists. Any changes in the recommended operating procedures or specified environmental conditions may influence the results significantly. Our guarantee covers only the quality of the material delivered. We do not undertake any responsibility for the application. In case of doubt, we recommend contacting our Technical Service. Our products are under constant development. Therefore please note date of issue of our technical data sheet and ask for latest issue.

Safety measures

Duoplast contains solvents and is combustible. Protect from heat and keep away from naked flames. Ensure that ventilation is adequate. Do not inhale vapours. The Safety Data Sheet as well as the general regulations regarding work hygiene and operational measures must be observed.

Technical Data

Binder	Two-pack polyurethane
Gloss degree	from matt to gloss
Color	Color cards RAL, NCS or sample
Substrate	2-component primers, e.g.: - Biladur EP C90 - Duopol Steelguard C80 - Bilacryl PU C160 - Amerlock 400 AL + Color Further, plastics such as polyurethane hard foam, polyester, PVC and pretreated polyethylene or polypropylene. Mould release agents must be removed. The surface must be dry and free of grease and dust.
Thinner	V101, V102, V2 (The use of other thinners may lead to defects and loss of quality.)
Packaging	<u>U231 – U251:</u> Pigment: 5, 10, 20 kg disposable cont. Hardener: 1, 2, 4 kg disposable cont. <u>U261:</u> Pigment 4 / 8 / 20 kg disposable cont. Hardener 1 / 2 / 5 kg disposable cont.
Storage	Pigment 12 months, hardener 6 months in original, unopened containers stored at 20 °C.
Waste disposal	Residues and expired material are considered as special refuse and must be taken to the toxic waste disposal unit, VeVa-Code 08 01 11.

Components	2
Hardener	H3
Mixing ratio	U231 – U251 5 : 1 wt.-parts U261 4 : 1 wt.-part
Potlife	U231 – U241 approx. 8 hours at 20 °C U251 – U261 approx. 6 hours at 20 °C
Drying (23 °C)	<u>U231 – U241</u> Dust-dry approx. 50 min. Dry to touch approx. 70 min. Transportable approx. 24 hours <u>U251 – U261</u> Dust-dry approx. 30 min. Dry to touch approx. 7 hours Transportable approx. 24 hours Drying times depend on film thickness, and substrate and air temperatures.
Forced drying	possible, e.g. 30 min. @ 80 °C

Solids content	by weight: approx. 67 % by volume: approx. 57 % approx. 1.25 kg/l	} mixture, white
Density (20 °C)		
Recommended dry film thickness	40 µm	
Theoretical consumption	at 40 µm approx. 90 g/m ²	

	Duoplast	H3	V101	V102	V2
VOC value	34 – 40 %	27,5 %	100 %	100 %	100 %

(replaces issue 06.17)

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