

DUOPLAST® U234/U244/U254/U264

2-C PUR Top Coat Metallic

Product range	
Duoplast U234	Matt
Duoplast U244	Satin matt
Duoplast U254	Satin gloss
Duoplast U264	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, diluted acids and chemicals, as well as lactic acid in the area of household equipment. Good light fastness and weather-resistance. The hardened coating is tough, flexible, abrasion-resistant, dirt-repellant and easy to maintain.

Areas of Application

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

Application

Conventional spraying

Do not apply at temperatures below + 5 °C.

Plastics:

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

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

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

Addition of Thinner

Conventional spraying	up to 30 wt.-%	
	Synthetics:	V101 or V102
	Metal industry:	V2

Depending on application method, variations in colour can arise with metallic paints. The dilution strength and choice of thinner, as well as other parameters in application related to the equipment, can significantly affect the gloss and the colour. Excessively wet spraying can cause an unsightly effect and cloudiness. If necessary, the paint for the final coat can be heavily diluted and atomized to achieve a lighter shade.

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
Finish	from matt to gloss
Color	Metallic based on samples
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>U234 – U254:</u> Pigment: 4 / 8 / 20 kg disposable cont. Hardener: 1 / 2 / 5 kg disposable cont. <u>U264:</u> Pigment: 3 / 9 / 15 kg disposable cont. Hardener: 1 / 3 / 5 kg disposable cont.
Storage	Pigment components 12 months, hardener 6 months in original, unopened containers 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 Hardener	2 H3
Mixing ratio	U234 – U254 4 : 1 wt.-parts U264 3 : 1 wt.-parts
Potlife	approx. 6 hours at 20 °C
Drying (23 °C)	Dust-dry approx. 30 min. Dry to touch approx. 7 hours Transportable approx. 24 hours
Forced drying	Drying times depend on film thickness, substrate and air temperatures. possible, e.g. 30 minutes @ 80 °C

Solids content	By weight: approx. 57 % By volume: approx. 55 %	} mixture, silver } RAL 9006
Density (20 °C)	approx. 1,04 kg/l	
Theoretical consumption	approx. 80 g/m ² @ 40 µm	

	Duoplast	H3	V101	V102	V2
VOC value	47 - 53 %	27,5 %	100 %	100 %	100 %

(replaces edition 07.17)

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