

PolydurColor (ICLA 141.40/01) PC-P380



Product data	
Packaging size	20 kg
Viscosity at delivery DIN 6 mm.	45 ± 5
Solid content in % base material	96 ± 1
Specific weight in kg/l at 20°C	1,4 ± 1%
Shelf life – Original container unopened	at least six months

Preparation of substrates		
	Raw wooden surfaces.	P120, P150, P180
	Exotic wood / woods rich in extractives Wood or MDF in wet rooms	Isolate with Quantum Q-IS160 or Solido S-IS130 before.

Processing	
	Stir thoroughly!
	Caution: When mixing, always keep to the correct order. First, accelerator and thinner are added to the lacquer and stirred until a homogeneous mixture is obtained. The catalyst is thoroughly stirred in in the last step. From this step on, the material is activated and can be applied.

Hardener - Thinner - Additives		
	Hardening of the finished mixture	
	Pot life 20°C, 65% rel. humidity when adding 20% of TPU 9500-F	up to 50 minutes
	Accelerator	2% of AUP 6570 (781.35) by weight 3% of AUP 6570 (781.35) by volume
	Thinner	TUP 9500-F (992.31) fast drying
	Catalyst	2% of HUP 6500 (340.56) by weight 3% of HUP 6500 (340.56) by volume

Application	
Spray pressure (bar)	1.5-3.0
Nozzle size (mm)	2.5-3.0
Thinner to be added (%)	20 - 25
Processing viscosity DIN 6mm (sec.)	18-20
Coverage per application (g/m²)	250 - 350
Coverage (m²/l)	2 -3
Maximum number of coating layers with this product	3
Waiting time before another coat is applied without intermediate sanding (hours)	1
Maximum waiting time before another coat is applied without intermediate sanding (hours)	3

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Drying time @ 20°C	
Dust dry	at least 50 minutes
Touch dry	at least 2 hours
Sandable	at least 14 hours
Flash off time after application	20 minutes

Forced drying	
Rest period at room temperature	20 minutes
Hot air drying at 40°C	30 minutes
Hot air drying at 60°C	30 minutes

Special notes
Do not process and dry PU lacquers below 15° C.
Polyester lacquers can be applied within one working day without any intermediate sanding. After that period of time, intermediate sanding must be made just before further processing, in order to ensure proper adhesion.
Catalyst and accelerator must be stored and transported separate from each other. Mixing these two substances results in an exothermic overreaction. Therefore it is extremely important to thoroughly mix thinner and accelerator with the base material first. The catalyst is added in the last step.
When processing catalyst and accelerator, always follow the safety instructions on the label.
Please, regard the short pot life of polyester systems. Only mix such a quantity of the material that can be processed in the stated period of time. Activated, unused polyester lacquers may cause high reaction heat in spray guns and mixing cups.
Immediately after use, carefully clean the spray gun and the working equipment.
The added amount of catalyst and accelerator is identical. Depending on the ambient temperature, the reaction rate can be adjusted in the range of 1-4%.

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