

## 8004 ACRYLIC PU TOP COAT

<b>Description</b>	Two-component, acrylic, aliphatic, polyurethane coating. Topcoat for metal surfaces after the surface has been treated with two component anticorrosive primer. It presents high gloss and it is non-yellowing. It presents great resistance to industrial and marine environment, color and gloss stability. Recommended for use as a topcoat of all epoxy systems.																		
<b>Technical Information</b>	<table border="0"> <tr> <td>Shade</td> <td>RAL – shades after request</td> </tr> <tr> <td>Gloss</td> <td>Glossy</td> </tr> <tr> <td>Specific Weight</td> <td>1,15±0,10 kg/lt (EN ISO 2811)</td> </tr> <tr> <td>Solids</td> <td>55 % per volume</td> </tr> <tr> <td>Theoretical Coverage</td> <td>9 m<sup>2</sup>/kg (50 μm)</td> </tr> <tr> <td>Temperature Resistance</td> <td>Up to 120°C (service temperature)</td> </tr> <tr> <td>Mixing Ratio</td> <td>A:B-4:1 per weight (3,1-1 by volume)</td> </tr> <tr> <td>Pot life</td> <td>3-4 hrs (25°C)</td> </tr> <tr> <td>VOC*</td> <td>Ready to use maximum (+5% thinner): 495 g/lt EU LIMITS (2010): 500 g/lt Subcategory: j – Two pack reactive performance coatings, anticorrosive finishes, Type SB</td> </tr> </table>	Shade	RAL – shades after request	Gloss	Glossy	Specific Weight	1,15±0,10 kg/lt (EN ISO 2811)	Solids	55 % per volume	Theoretical Coverage	9 m <sup>2</sup> /kg (50 μm)	Temperature Resistance	Up to 120°C (service temperature)	Mixing Ratio	A:B-4:1 per weight (3,1-1 by volume)	Pot life	3-4 hrs (25°C)	VOC*	Ready to use maximum (+5% thinner): 495 g/lt EU LIMITS (2010): 500 g/lt Subcategory: j – Two pack reactive performance coatings, anticorrosive finishes, Type SB
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<b>Drying Time</b> 25 °C, 60% RH, 50 μm	<table border="0"> <tr> <td>Touch Dry</td> <td>2-3 hr</td> </tr> <tr> <td>Drying</td> <td>6-8 hrs</td> </tr> <tr> <td>Full Drying</td> <td>72-96 hrs</td> </tr> </table> <p><i>The above times are indicative and depend on the thinning percentage, the film thickness, the substrate conditions and the weather conditions (e.g., relative humidity, temperature, wind, sunshine).</i></p>	Touch Dry	2-3 hr	Drying	6-8 hrs	Full Drying	72-96 hrs												
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<b>Surface Preparation</b>	It is recommended to use sandblasting minimum Sa 2 ½ on metallic surfaces. If this is not possible then it is necessary to use mechanical means in order to clean and remove rust, dust and other material (e.g., oil, grease). Old layers must be removed. The surface must be treated with a two-component primer (e.g., 812 epoxy primer).																		
<b>Application</b>	<p>Mix A:B-4:1 by weight. Then thinner is added. It is important to stir both around the walls and at the bottom of the mixing container, so the hardener is evenly distributed.</p> <p>It is applied with:          Airless (nozzle 0,38 mm - 0,48 mm, 0,015 in - 0,019 in) after up to 5% thinning with thinner          Air pistol, (diameter: 1,8-2,0 mm) after the thinning of the product with up to 5% thinner</p> <table border="0"> <tr> <td>Suggested film thickness</td> <td>50-100 μm</td> </tr> <tr> <td>Application temperature</td> <td>5-30 °C</td> </tr> <tr> <td>Substrate temperature</td> <td>5-30 °C</td> </tr> <tr> <td>Dew point</td> <td>The substrate temperature must be at least 3 °C higher than the</td> </tr> <tr> <td>Relative humidity</td> <td>dew point. &lt; 70%</td> </tr> <tr> <td>Suggested thinners</td> <td>1115-2540 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact the technical department of our company.</td> </tr> </table> <p>The above conditions must be followed both during the application process and throughout the drying.</p> <p>The surface where the product will be applied must be totally clean and dry. It should not be applied when rain is expected. It is necessary to protect every layer from moisture (&gt;70%) and rain for about 24 hours after the application.</p>	Suggested film thickness	50-100 μm	Application temperature	5-30 °C	Substrate temperature	5-30 °C	Dew point	The substrate temperature must be at least 3 °C higher than the	Relative humidity	dew point. < 70%	Suggested thinners	1115-2540 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact the technical department of our company.						
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<b>Storage</b>	Up to 12 months in a dry and cool place (5-35°C) protected from direct solar radiation and adverse weather conditions, stored in the original unopened containers.
<b>Safety</b>	Please consult the Material Safety Data Sheet. Available upon request.

**This Technical Data Sheet replaces and cancels every previously issued. The information, instructions, recommendations and specifications mentioned in this data sheet, represent the results and experience obtained from testing under controlled or specially adapted conditions. The accuracy and relevance of these results to the actual conditions, in which you apply the product, must be determined and depend only on the purchaser and/or applicator.**