



# zandleven coatings

## POLYFINISH® HS 65-55

polyurethane

A two components high solid polyurethane coating with good weather resistance and colour lightfastness

- Slight dirt attachment and easy to rinse. Easily applicable in thick layers.
- Low-solvent content in accordance with EG regulations of 2007.
- After curing excellent mechanical resistance and elasticity.

**Application** as chemical resistant, impact resistant coating for with polyurethane- or epoxy primer pre-treated steel, galvanised steel and aluminium.

### Product information

Finish	Semi-gloss (55 GU, depending on colour)
Colour	RAL colours
Mass density	approx. 1.35 kg/L (mixed product, depending on colour)
Solids content by volume	approx. 67 volume % (mixed product, depending on colour)
VOC	approx. 290 gr./L (volatile organic compound)
<b>Carbon Footprint</b>	<b>3,02 Kg CO<sub>2</sub> equivalent/litre</b>
Recommended film thickness	70 -120 µm d.f.t. per layer 100 -180 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 70 µm d.f.t. 9.6 m <sup>2</sup> /L At 100 µm d.f.t. 6.7 m <sup>2</sup> /L
Practical spreading rate	Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. A few guiding principles are: Brush/roller 85-90% of the theoretical spreading rate Spraying 50-70% of the theoretical spreading rate
Flashpoint ISO 1523	Base 29°C Hardener 2V6 38°C Thinner JFG 253 28°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

### Drying times

For d.f.t. up to 100 µm

Dust dry

Transportable

Complete hardening

Recoat able:

Minimum interval

Maximum interval \*

30°C	20°C	10°C	5°C
½ hour	1 hour	3 hour	4 hours
10 hours	16 hours	24 hours	48 hours
4 days	7 days	14 days	28 days
8 hours	12 hours	24 hours	40 hours
7 days	14 days	1 month	3 months

\* This period can be extended by cleaning and sanding the coating prior to application of the next layer.

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.



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## Application instructions

Mixing ratio	Volume: Base – hardener 2V6 82,5:17,5 Weight: Base – hardener 2V6 86,5:13,5
Mixing instructions	Base and hardener should be mixed and applied at temperatures above 10°C. At lower temperatures extra thinner is needed, which gives a slighter resistance against sagging and which will delay hardening. The components should be mixed homogeneously, with a mechanical blender. Pay attention to the side and bottom of the can.
Induction time	At 20°C not necessary At 10°C at least 10 minutes
Pot life after mixing	20 litre packing: approx. 6 hours at 10°C approx. 3 hours at 20°C approx. 2 hours at 30°C
Optimal application circumstances	Temperature : 15-25°C Humidity : 40-75%

Technical and esthetical properties can change when the product has been applied under different conditions.

## Usage information

Type of thinner  
Recommended thinner  
(depending on application  
and equipment)  
Nozzle orifice  
Nozzle pressure  
Typical d.f.t.  
Cleaning of equipment

Airless-spray	Airspray	Brush/roller
JFG 253	JFG 253	JFG 253
0 – 15 vol. %	5 – 15 vol. %	0 – 5 vol. %
0.28 – 0.33 mm 0.011 – 0.017 inch	1.5 – 2.0 mm	
130 – 200 bar	3 – 4 bar	
70-100 µm	60-100 µm	50-80 µm
Thinner JFG 253		

## Surface conditions

Steel

New steel:

As primer Acraton HS-U, Monopox Metalcoat ZL 70, Monopox Metalcoat ZL 80, Monopox SF-HB, Monopox ZF-Universal or Acraton HS Premium can be applied.

Repair and maintenance:

Clean the surface thoroughly with a suitable cleaning preparation or by steam cleaning.

Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.

Apply the recommended paint system on a clean surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.



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### Product Characteristics

No coating work shall be carried out when the temperature of the surface is less than 3°C above dew point and when the substrate temperature is below 5°C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

Condensation occurring during or immediately after application may result in a matt and an inferior film.

Colours/Colour stability:

Certain lead-free red and yellow colours may discolour when exposed to chlorine-containing atmosphere. To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in red, orange, yellow and green. Slight discolouration may occur at service temperatures above: 120°C.

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent. Salt to be removed by fresh water hosing.

### Safety description

See safety data sheet

### Ventilation rules

Minimum required quantity of air to comply with:

	MAC	10 % LEL
Polyfinish HS 65-55	1110 m³/L	59 m³/L
Thinner JFG 253	3680 m³/L	149 m³/L

MAC = Maximum Accepted Concentration

LEL = Lower Explosion Limit

Also consult the safety information sheets

### Pretreatment / Labeling / Technical Terms (downloadable from [www.zandleven.com](http://www.zandleven.com))

- A 1 Labeling of paint products in the European Community
- A 2 Physical data
- A 4 General guidelines for steel preservation
- A 6 Pretreatment of construction steel

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because the choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.

The English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.



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