POLYFINISH® HS 65-Aluminium 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	Gloss
Colour	Light- and dark-aluminium
Mass density	approx. 1.05 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)
Recommended film thickness	60 -100 µm d.f.t. per layer 90 -150 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 80 µm d.f.t. 8.4 m²/L At 120 µm d.f.t. 5.6 m²/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	30 °C	20 °C	10 °C	5 °C
Dust dry	½ hour	1 hour	3 hour	4 hours
Transportable	10 hours	16 hours	24 hours	48 hours
Complete hardening	4 days	7 days	10 days	10 days
Recoatable:				
Minimum interval	8 hours	12 hours	24 hours	40 hours
Maximum interval*	10 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.

Application instructions

Mixing ratio	Volume:	Base – hardener 2V6	78:22
	Weight:	Base – hardener 2V6	78:22

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.

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

Application conditions

During application and curing the temperature should be above 5°C, to obtain maximum resistance against chemical and mechanical influences.

Application and hardening at lower temperatures (down to 0°C) is possible, the hardening though will then take considerable more time and complete resistance will be achieve much later.

The surface should remain dry and the temperature of the surface should be at least 3°C above dew point.

During application and hardening in closed and small areas it is necessary to refresh the air continually to remove the solvent vapours, this because of curing, health and safety.

Usage information

	Airless-spray	Airspray	Brush/roller
Type of thinner	JFG 253	JFG 253	JFG 253
Recommended thinner (depending on application and equipment)	0 – 15 vol. %	5 – 15 vol. %	0 – 5 vol. %
Nozzle orifice	0.28 – 0.33 mm 0.011 – 0.017 inch	1.5 – 2.0 mm	
Nozzle pressure	130 – 200 bar	3 – 4 bar	
Maximum attainable d.f.t.	70-100 µm	60-100 µm	50-80 µm
Cleaning of tools	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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Safety description
See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:		
	MAC	10 % LEL
Polyfinish HS 65-Aluminium	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)

A 1 Labeling of paint products in the European Community
A 2 Physical data
A 3 Persistency list for Monopox HB systems
A 4 General guidelines for steelpreservation
A 5 General guidelines for the application of Acraton plastics
A 6 Pretreatment of construction steel