

2K-Derocryl Lack 80 HS Alu

Two component high solid topcoat on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane).
Frei von Blei-, Cadmium- und Chrom VI-Verbindungen

Field of application

- Protection against corrosion for iron and steel
- High Thickness as one-coat paint system with alushine-effect.
- With hardener HL 106 for max. 60 µm DFT.
- Two pack performance coating for specific use according dekopaint directive.
- Recommended repairpaint is Derilux 588 silvergrey (after 2 d grinding)

Product properties

- High Solid
- Industriel uv-resistance
- Good elasticity
- Recoatable with itself

Technical Specification

Colours

depends on application: RAL 9006/9007 at DFT 40-50 µm and darker than RAL 9006/9007 at DFT 100 µm.

Colour deviation (Colour deviations may occur in the range of high temperatures due to the restricted temperature resistance of the pigments)

Flash point

>23 °C

Temperature stability

-20 up to 120 (short-term up to 180) °C

Gloss

Satin glossy, appr. 50 U in 60° angle

Potential dry film thickness in one working process

40 up to 120 µm

Mixing ratio

Hardener HL 401

Hardener HL 402

(Basis:hardener) by weight

8:1

8:1

(Basis:hardener) by volume

6,4:1

6,4:1

Pot life in hours

3

3

Viscosity

Appr. 20 sec running time (DIN 6 mm pot)

Appr. 20 sec running time (DIN 6 mm pot)

Density in kg/l

1,305

1,305

Solid content in %

72

72

Solid volume in %

58

58

Theoretical spreading capacity

- 7,25 m²/l at 80 µm DFT
- 5,56 m²/kg at 80 µm DFT

- 9,67 m²/l at 60 µm DFT
- 7,41 m²/kg at 60 µm DFT

Recommended film thickness

125 µm WFT corresponds to 70 µm DFT

100 µm WFT corresponds to 60 µm DFT

Drying (DIN EN ISO 1517)

80 µm DFT

60 µm DFT

Dust-dry (Tg1)

After 70 min

After 60 min

Touch-dry (Tg4)

After 6 h

After 6 h

Dry (Tg6)

After 15 h

After 15 h

Cured chemically

After 7 days

After 7 days

Accelerated drying

30 min. at 60°C possible, after 10 min. flash-off time

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Interval for overcoating

- after 6 h with itself
- Max. after 7 days without slightly sanding

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- Note
- The specifications are related to the prepared mixture and are based on standard atmospheric conditions 23/50, DIN 50014.
 - Lower temperatures and/or higher humidity will prolong drying and hardening.
 - Application below +5 °C is not possible.

Safety information (See Security Data Sheet)

VOC-level	Appr. 363 g/l	
Solvent content	Appr. 28 % by weight	Appr. 28 % by weight
Aromatic content	Appr. 22 % by weight	

Storage

- Storage
- In dry, cool rooms, if possible frost-proof
 - Ensure good ventilation
- Shelf life
- 6 month from date of delivery when in unopened original containers in cool and dry conditions

Application methods

- Mixing ratio
- Stirr homogeneous, preferably with mechanical stirrer
 - Mix base paint and hardener according to the mixing ratio as specified
- Airless spraying
- Flow pressure 200 bar
 - Nozzle size 0,011 - 0,013 inch (0,28 - 0,33 mm)
 - Spraying angle according to the geometry and size of the object to be laquered
- Compressed air spraying
- Spraying pressure 2 bar
 - Nozzle size 1,3 - 1,8 mm
 - Adjust to spraying viscosity (appr. 30 s DIN 4 mm) adding appr. 10 % Derocrylverdünnung (two component products: after mixing)
- Electrostatic application
- Application is possible provided that the material is diluted
- Dipping
- Can not be applied as delivered
- Other methods
- Roller and brush application is possible in the quality as delivered
- Thinner
- Max. 10% Derocrylverdünnung
- Cleaning
- Rinse immediately with Derocrylverdünnung

Preparation of support

- Shot blasting to a purity according to SA 2½
- Mill scale, welding residues, dust and dirt on the surface which might reduce adhesion have to be carefully and thoroughly removed

General remarks

- During coating and drying the humidity should be min. 30 % / max. 85 %
- During coating and drying the environmental temperature should be min. 5°C / max. 30°C
- Object temperature at least 3° C above dew point.

Example for a system

- Finish coat: 2K-Derocryl Lack 80 HS Alu

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