

2K-Derocryl Hammerschlag Lack

Two component effect finish topcoat on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane)

Field of application

- Protection against corrosion for iron and steel
- Decorative topcoat for higher rust protection requirements.

Product properties

- Contents silicon
- High surface hardness
- Overcoatability: do not overcoat with itself
- Applicable as a topcoat on any solvent resistant primers
- Homogeneous hammer design effect

Technical Specification

Colours	silver-grey, green, blew.
Flash point	>23 °C
Temperature stability	Up to 120 °C
Gloss	Glossy
Mixing ratio	Hardener HL 109
(Basis:hardener) by weight	2,5:1
(Basis:hardener) by volume	2,5:1
Pot life in hours	8
Viscosity	Aprr. 90 sec running time (DIN 4 mm pot)
Density in kg/l	0,96
Solid content in %	45
Solid volume in %	42
Theoretical spreading capacity	<ul style="list-style-type: none"> • 10,5 m²/l at 40 µm DFT • 10,94 m²/kg at 40 µm DFT
Recommended film thickness	75 µm WFT corresponds to 30 µm DFT
Drying (DIN EN ISO 1517)	40 µm DFT
Dust-dry (Tg1)	After 30 min
Touch-dry (Tg4)	After 1 h
Dry (Tg6)	After 24 h
Cured chemically	After 7 days
Note	<ul style="list-style-type: none"> • 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	Aprr. 527 g/l
Solvent content	Aprr. 55 % by weight
Aromatic content	Aprr. 55 % by weight

Storage

Storage	<ul style="list-style-type: none"> • In dry, cool rooms, if possible frost-proof • Ensure good ventilation
Shelf life	<ul style="list-style-type: none"> • 6 month from date of delivery when in unopened original containers in cool and dry conditions

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Application methods

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| Mixing ratio | <ul style="list-style-type: none"> • Stirr homogeneous, preferably with mechanical stirrer • Mix base paint and hardener according to the mixing ratio as specified |
| Airless spraying | <ul style="list-style-type: none"> • Too high pressure and/or too high working viscosity can cause blister which may impair the effect • Flow pressure 130 - 160 bar • Nozzle size 0,011 - 0,015 inch (0,28 - 0,38 mm) • Spraying angle according to the geometry and size of the object to be laquered • If required (two component: after mixing) using 5% Derocrylverdünnung is possible |
| Compressed air spraying | <ul style="list-style-type: none"> • Can be applied as delivered • Spraying pressure 2 bar • Nozzle size 1,6 - 2 mm |
| Electrostatic application | <ul style="list-style-type: none"> • Application is not possible |
| Dipping | <ul style="list-style-type: none"> • Can not be applied as delivered |
| Other methods | <ul style="list-style-type: none"> • Roller and brush application is inadvisable |
| Thinner | <ul style="list-style-type: none"> • Max. 10% Derocrylverdünnung |
| Cleaning | <ul style="list-style-type: none"> • Rinse immediately with Derocrylverdünnung |
| Preparation of support | <ul style="list-style-type: none"> • Shot blasting to a purity according to SA 2½ • If necessary clean with high pressure-cleaner and turbo-cleaner-solution • Mill scale, welding residues, dust and dirt on the surface which might reduce adhesion have to be carefully and thoroughly removed |
| General remarks | <ul style="list-style-type: none"> • During coating and drying the humidity should be min. 10 % / 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 | <ul style="list-style-type: none"> • Primer coat: 2K-Derocryl Haftgrund EE • Finish coat: 2K-Derocryl Hammerschlag Lack |

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