

2K-Derocryl Lack DTM Rapid

Two component high solid topcoat on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane). Free of lead, cadmium and chromium VI compounds.

- Field of application**
- Fast drying anticorrosion system for steel.
 - Certificate ILF (230932) as one-layer coating with 80µm TSD for C3 medium/ C2 high.
 - Easy and smooth in application.

- Product properties**
- High Solid
 - Silicon-free
 - Resistance to mineral oils
 - Industrial uv-resistance
 - Good gloss stability
 - Fast drying
 - Fast curing
 - Recoatable with itself

Technical Specification

Colours	RAL 5010 , RAL-colour chart with exceptions, apart from RAL 9006/9007. Other colours upon request.	
Flash point	>23 °C	
Temperature stability	-20 up to 120 (short-term up to 150) °C	
Gloss	Silky mat, appr. 15 U in 60° angle	
Potential dry film thickness in one working process	80 up to 160 µm	
Mixing ratio	Hardener HL 106	Hardener HL 115
(Basis:hardener) by weight	7:1	11:1
(Basis:hardener) by volume	4,5:1	7,5:1
Pot life in hours	3	3
Viscosity	Thixotrope	Thixotrope
Density in kg/l	1,34	1,38
Solid content in %	68	71
Solid volume in %	51	56
Theoretical spreading capacity	<ul style="list-style-type: none"> • 6,38 m²/l at 80 µm DFT • 4,76 m²/kg at 80 µm DFT 	<ul style="list-style-type: none"> • 7 m²/l at 80 µm DFT • 5,07 m²/kg at 80 µm DFT
Recommended film thickness	150 µm WFT corresponds to 80 µm DFT	150 µm WFT corresponds to 80 µm DFT
Drying (DIN EN ISO 1517)	80 µm DFT	80 µm DFT
Dust-dry (Tg1)	After 45 min	After 30 min
Touch-dry (Tg4)	After 3 h	After 2,5 h
Dry (Tg6)	After 5 h	After 4 h
Cured chemically	After 7 days	After 7 days
Accelerated drying	30 min. at 60°C possible, after 10 min. flash-off time	30 min. at 60°C possible, after 10 min. flash-off time
Interval for overcoating	<ul style="list-style-type: none"> • after 6 h with itself 	<ul style="list-style-type: none"> • after 6 h with itself

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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	Apr. 400 g/l	
Solvent content	Apr. 32 % by weight	Apr. 29 % by weight
Aromatic content	Apr. 12 % 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
- Risk of spray dust due to very fast drying
 - Flow pressure 210 bar
 - Nozzle size 0,013 - 0,017 inch (0,33 - 0,43 mm)
 - Spraying angle according to the geometry and size of the object to be laquered
 - If required (two component: after mixing) using 3% Derocrylverdünnung is possible
- Compressed air spraying
- Spraying pressure 2 bar
 - Nozzle size 1,6 - 2 mm
 - Adjust to spraying viscosity (appr. 45 s DIN 4 mm) adding appr. 10 % Derocrylverdünnung (two component products: after mixing)
- Electrostatic application
- Application is possible provided that the material is diluted
 - Conductance of the material: 800 kOhm
- Dipping
- Can not be applied as delivered
- Other methods
- Roller and brush application for repair work is possible
- 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 DTM Rapid

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Product group: PD4470