

## 2K-Derocryl finish GL

Glossy two component topcoat on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane)

- Field of application**
- Topcoat for rust protection requirements with high quality optics
- Product properties**
- High Solid
  - Scratch resistance
  - Good UV-stability
  - Good elasticity
  - Fast drying

### Technical Specification

Colours **RAL 5010**, RAL-colour chart with exceptions, apart from RAL 9006/9007.

Flash point >23 °C

Temperature stability -20 up to 120 °C

Gloss High glossy, appr. 90 U in 20° angle

Potential dry film thickness in one working process 20 up to 60 µm

Mixing ratio	<b>Hardener HL 105</b>	<b>Hardener HL 116</b>
(Basis:hardener) by weight	5:1	4:1
(Basis:hardener) by volume	4:1	3:1
Pot life in hours	3	3
Viscosity	Appr. 20 sec running time (DIN 4 mm pot)	Appr. 20 sec running time (DIN 4 mm pot)
Density in kg/l	1,204	1,207
Solid content in %	64	67
Solid volume in %	50	54
Theoretical spreading capacity	<ul style="list-style-type: none"> <li>• 12,5 m<sup>2</sup>/l at 40 µm DFT</li> <li>• 10,38 m<sup>2</sup>/kg at 40 µm DFT</li> </ul>	<ul style="list-style-type: none"> <li>• 13,5 m<sup>2</sup>/l at 40 µm DFT</li> <li>• 11,18 m<sup>2</sup>/kg at 40 µm DFT</li> </ul>
Recommended film thickness	75 µm WFT corresponds to 40 µm DFT	75 µm WFT corresponds to 40 µm DFT
Drying (DIN EN ISO 1517)	40 µm DFT	40 µm DFT
Dust-dry (Tg1)	After 45 min	After 2 h
Touch-dry (Tg4)	After 7 h	After 7 h
Dry (Tg6)	After 14 h	After 14 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"> <li>• after 3 h with itself</li> <li>• Max. after 48 h without slightly sanding</li> </ul>	<ul style="list-style-type: none"> <li>• after 3 h with itself</li> <li>• Max. after 48 h without slightly sanding</li> </ul>
Note	<ul style="list-style-type: none"> <li>• The specifications are related to the prepared mixture and are based on standard atmospheric conditions 23/50, DIN 50014.</li> <li>• Lower temperatures and/or higher humidity will prolong drying and hardening.</li> <li>• Application below +5 °C is not possible.</li> </ul>	
<b>Safety information</b> (See Security Data Sheet)		
VOC-level	Appr. 420 g/l	
Solvent content	Appr. 36 % by weight	Appr. 33 % by weight

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Aromatic content	Appr. 15 % by weight
<b>Storage</b>	
Storage	<ul style="list-style-type: none"> <li>• In dry, cool rooms, if possible frost-proof</li> <li>• Ensure good ventilation</li> </ul>
Shelf life	<ul style="list-style-type: none"> <li>• 6 month from date of delivery when in unopened original containers in cool and dry conditions</li> </ul>
<b>Application methods</b>	
Mixing ratio	<ul style="list-style-type: none"> <li>• Stirr homogeneous, preferably with mechanical stirrer</li> <li>• Mix base paint and hardener according to the mixing ratio as specified</li> </ul>
Airless spraying	<ul style="list-style-type: none"> <li>• Firstly apply a mist layer with diluted material</li> <li>• Flow pressure 150 - 210 bar</li> <li>• Nozzle size 0,009 - 0,013 inch (0,23 - 0,33 mm)</li> <li>• Spraying angle according to the geometry and size of the object to be laquered</li> <li>• If required (two component: after mixing) using 5% Derocryl-Verdünnung is possible</li> <li>• Do not exceed wetfilm thickness of 100 µm (blistering)</li> </ul>
Compressed air spraying	<ul style="list-style-type: none"> <li>• Can be applied as delivered</li> <li>• Spraying pressure 2 bar</li> <li>• Nozzle size 1,3 - 1,6 mm</li> <li>• Adjust to spraying viscosity (appr. 20 s DIN 4 mm) adding appr. 5 % Derocryl-Verdünnung (two component products: after mixing)</li> </ul>
Electrostatic application	<ul style="list-style-type: none"> <li>• Can be applied as delivered</li> <li>• Conductance of the material: 800 kOhm</li> </ul>
Dipping	<ul style="list-style-type: none"> <li>• Can not be applied as delivered</li> </ul>
Other methods	<ul style="list-style-type: none"> <li>• Roller and brush application for repair work is possible</li> </ul>
Thinner	<ul style="list-style-type: none"> <li>• Max. 10% Derocryl-Verdünnung</li> </ul>
Cleaning	<ul style="list-style-type: none"> <li>• Rinse immediately with Derocryl-Verdünnung</li> </ul>
<b>Preparation of support</b>	<ul style="list-style-type: none"> <li>• If necessary clean with high pressure-cleaner and turbo-cleaner-solution</li> <li>• Mill scale, welding residues, dust, soluble residues from chemical pretreatments and zinc reaction products which might reduce adhesion have to be carefully and thoroughly removed</li> <li>• Clean primer of the coating system</li> </ul>
<b>General remarks</b>	<ul style="list-style-type: none"> <li>• During coating and drying the humidity should be min. 30 % / max. 85 %</li> <li>• During coating and drying the environmental temperature should be min. 5°C / max. 30°C</li> <li>• Object temperature at least 3° C above dew point.</li> </ul>
<b>Example for a system</b>	<ul style="list-style-type: none"> <li>• Primer coat: 2K-Derocryl Haftgrund HS</li> <li>• Finish coat: 2K-Derocryl finish GL</li> </ul>

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Product group: PD0492