

2K-Derocryl Haftgrund HS

Two component high solid primer with anti-corrosive pigments (zinc-phosphate) on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane)

Field of application

- Protection against corrosion for iron and steel
- Adherence primer for aluminium and zinc surfaces
- Fulfills the deco paint directive for the field of car repairs.

Product properties

- High Solid
- Silicon-free
- Resistance to light acids
- Resistance to mineral oils
- Fast drying
- Fast recoatability

Technical Specification

Colours	light beige , light grey. Other colours upon request.	
Flash point	>23 °C	
Temperature stability	-20 up to 120 °C	
Gloss	Silky mat	
Potential dry film thickness in one working process	60 up to 100 µm	
Mixing ratio	Hardener HL 115	Hardener HL 106
(Basis:hardener) by weight	12:1	7:1
(Basis:hardener) by volume	8:1	4,6:1
Pot life in hours	3	2
Viscosity	Appr. 60 sec running time (DIN 4 mm pot)	Appr. 45 sec running time (DIN 4 mm pot)
Density in kg/l	1,47	1,41
Solid content in %	73	69
Solid volume in %	54	50
Theoretical spreading capacity	<ul style="list-style-type: none"> • 6,75 m²/l at 80 µm DFT • 4,59 m²/kg at 80 µm DFT 	<ul style="list-style-type: none"> • 6,25 m²/l at 80 µm DFT • 4,43 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 45 min
Touch-dry (Tg4)	After 2,5 h	After 2,5 h
Dry (Tg6)	After 3 h	After 3 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 3 h with two component Derocryl topcoats 	<ul style="list-style-type: none"> • after 3 h with two component Derocryl topcoats
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. 	

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Safety information (See Security Data Sheet)

VOC-level	Appr. 400 g/l	
Solvent content	Appr. 27 % by weight	Appr. 31 % by weight
Aromatic content	Appr. 24 % 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

Application methods

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"> Flow pressure 210 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
Compressed air spraying	<ul style="list-style-type: none"> Spraying pressure 2 bar Nozzle size 1,3 - 1,6 mm Adjust to spraying viscosity (appr. 40 s DIN 4 mm) adding appr. 10 % Derocrylverdünnung (two component products: after mixing)
Electrostatic application	<ul style="list-style-type: none"> Application is possible provided that the material is diluted Conductance of the material: 800 kOhm
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 for repair work is possible
Thinner	<ul style="list-style-type: none"> Max. 15% Derocrylverdünnung
Cleaning	<ul style="list-style-type: none"> Rinse immediately with Derocrylverdünnung Residues are dissolvable 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 Sweeping for zinced supports 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
General remarks	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> Primer coat: 2K-Derocryl Haftgrund HS Finish coat:

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Product group: PG4199150700