

Application manual for mixing PU 2K Paint System Products

- Material Data:** For main characteristics refer to Data Sheet DS 970
- MSDS:** Note MSDA Data Sheets for Paint, Hardener and Primer.
- Safety and Handling:** Usual precautionary measures for handling chemicals must be followed. Ensure good ventilation at workplace.
Avoid material contact with eyes and skin.
- Application Rate:** PU-S 2K for spray gun 0,7 Kg/m² for 200µm layer
PU-B 2K for brush painting +33% = 0,93 Kg/m² for 200µm layer
PE Primer X for spray gun 18 m²/Liter
PE Primer X for brush painting 12 m²/Liter
- Mixing Ratio:** Paint : Hardener ratio 5:1 in weight or 4:1 in volume

Application:

1. Clean thermoplastic pipe by using PE-Cleaner with Methylalkohol 99,8% (or Butylacetat or Aceton) to get the thermoplastic pipe free of dust and oil
2. For perfect longtime bonding, napp full surface slightly by using sand paper >150
3. Mix PU 2K Paint System in ratio 5:1 in weight or 4:1 in volume by using a stirrer and keep a pre-reaction time of at least 10 minutes
4. Apply PE Primer X in full thin layer (20µm) and let it dry for at least 2 minutes (up to 6 hours)
5. Apply the paint system (For PU-S 2K see spray gun recommendation) or for PU-B 2K by brush in layer of 200-250µm.
6. Keep drying period of min. 1 hour (depending on ambient temperature) before applying a second layer of 200-250µm.
7. Keep final drying period of at least 6 hours
8. Keep final reaction period of at least 2 days before operation

Equipment Cleaning: Cleaning by using dilution.

Spray Gun application: 2,5 mm nozzle, 3-5 bar, dilution max 10%

Airless application: 0,028-0,031 inch, 100-120 bar, dilution max 5

Storage Time: Used drums:

**If cans are well closed directly after opening, stocking time of
1 week for paint and hardener should be achievable.**

Pot Life Storage Time: Minimum of 6 month at stocking temperature of 15-23°C.