

# SPECIFICATIONS

Prepared on:  
March 16, 2005



Updated on:  
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## Product name: APP Color MIX 2:1

A high-quality, quick-drying, binary acrylic lacquer for industrial applications. The product is designed for the lacquering of utility vehicles, buses, tank trucks, visible and heavily loaded machine parts and structural components. It is characterised by a very high resistance to mechanical impact, blows, scratching, and chemical factors: low-concentration acids and bases, fats and petrol/naphtha.

Container:	Lacquer - 1.00 kg, 3.00 kg, 10.0 kg; hardener - 0.5 l, 5.00 l.	
Product and additives:	APP Color MIX 2:1; APP 2K Harter LHN250; APP 2K Harter LHS100; APP 2K Acryl Verdunnung AVN APP 2K Acryl Verdunnung AVS.	
Special additives:	APP 2K Elastic; APP Anti-Silikon.	
Basic components:	APP Color MIX 2:1 - poly-acrylic resin; APP 2K Harter - isocyanate hardener.	
Colour:	Colour:	RAL, NCS
	Base:	poly-acrylic system
	Solid components content:	53 - 60% by weight
	Viscosity (DIN 53211):	140 - 160 s 4 mm DIN
	Specific gravity (DIN 61757):	1.15 - 1.28 kg/l
	Gloss (DIN 67530):	> 80%/60°C (high gloss)
Output:	6-8 m <sup>2</sup> /l. Caution! In practice the output depends on certain factors including: object shape, roughness of the base, method of application and working conditions.	
<u>Usage:</u>	<ul style="list-style-type: none"><li>• electrostatic application possible;</li><li>• high resistance to UV radiation and weather conditions;</li><li>• excellent resistance to water;</li><li>• good resistance to solvents;</li><li>• high resistance to mechanical damage;</li><li>• exceptional thermal resistance:<ul style="list-style-type: none"><li>continuous exposure: 150°C;</li><li>momentary exposure: 180°C.</li></ul></li><li>• adhesion test (DIN 53151):<ul style="list-style-type: none"><li>steel: Gt 0 (very good).</li></ul></li></ul>	

The above information complies with current knowledge on our products and their possible applications. This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

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### Base

Proper base types:

Polished factory-made coats.

Surfaces pre-coated with:

- epoxy primers, e.g. APP 2K Grund EP;
- reactive primers, e.g. APP 1K Haftgrund;
- filling primers, e.g. APP 2K Acrylfiller 5:1;
- unary fillers, e.g. APP 1K Filler.

Base preparation:

Thoroughly remove all corrosion centres.



Existing finish - even up dry by machine polishing, using P320-P360 abrasive paper.

Surfaces covered with factory-made lacquer coats and primers - polish wet using P600-P800 abrasive paper.



- Iron, steel: clean, possibly sand blast (remove all traces of rust, scale, oxides, and rolling residues), and degrease using W900 silicone remover.
- Zinc: clean with basic ammonia-based agent, e.g.: 10 l of water + 0.5 l of ammonia + 25 ml of detergent.
- Aluminium: clean, sand blast, and degrease using W900 silicone remover.



Before spraying the lacquer, remove any dust from the treated surface and degrease it using W900 remover.

### Application

Mixing ratio(s):

A) Mixing ratio by volume:

2 volumes	APP Color MIX 2:1
1 volume	APP 2K Harter LHN/LHS
10-15%	APP 2K Acryl Verdunnung AVS



B) Mixing ratio by weight:

3 parts	APP Color MIX 2:1
1 part	APP 2K Harter LHN/LHS
10-15%	APP 2K Acryl Verdunnung AVS

Caution!

Use APP 2K Harter LHN/LHS hardener only.

Never exceed the recommended hardener dose.

If necessary, add from 2 to 5% of the APP Anti-Silikon.

If needed (plastics), add the APP 2K Elastic elasticity improving agent before admixing the hardener. Proceed according to the mixing chart.

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### Applying:



- A) Pneumatic spraying:  
Apply using a spray gun equipped with a  $\phi 1.3$ - $\phi 1.5$  mm nozzle at an air pressure ranging from 3.0 to 5.0 bar.
- B) Hydrodynamic spraying:  
When applying the lacquer using the hydrodynamic (airless) spraying method, use the mixture without a thinner and a 0.28-0.33 mm (65°-95°) nozzle at a pressure ranging from 120 to 150 bar.

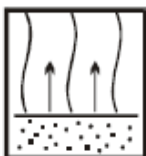


- Number of layers:
- 2-4 for pneumatic spraying
  - 1 for hydrodynamic spraying

Coat thickness: 50-60  $\mu\text{m}$ .

Recommended working conditions:

- minimum temperature: +10°C;
- maximum relative humidity: 80%.



Evaporation time between successive layers at a temperature of +20°C: from 5 to 10 minutes.

Usability time for a ready-to-use lacquer mixture: 6-8 hours.

### Drying:



At a temperature of +20°C:

- Dust dryness: 25-30 minutes.  
Handling possible: 6-8 hours.  
Full hardening: 20 hours.

At a temperature of +60°C:

- Dust dryness: 5 minutes.  
Handling possible: 30 minutes.  
Full hardening: 50-60 minutes.

The coat becomes fully mature after 5-6 days at a temperature of approximately +20°C.

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### Polishing:



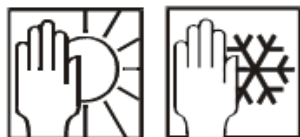
After complete hardening, that is after 20 - 24 hours, it is possible to remove defects and inclusions using abrasive materials:

- wet polishing by hand with P1500-P2500 (5000) abrasive paper;
- wet machine polishing with P1200-P5000 abrasive paper;
- dry machine polishing with P800-P1500 abrasive paper.

### Equipment cleaning:

Nitrocellulose solvent.

### Storage:



Store in original, closed containers in a dry and well-ventilated room.  
Protect against freezing.

### Industrial safety regulations:



For professional use only.

See: information on product labels and/or in Hazardous Material Safety Data Sheet.

Users should observe all industrial safety regulations applicable in their countries.

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