Technical Data Sheet

Edition dated: 05.02.08

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Data sheet Nr. 5393/PC

AVKOTE PC

Product description		Especially fast drying, silk gloss 2 pack with very good weathering characteristics and good resistance to chemicals and mechanical abrasion. The paint film meets the DIN 68861 standard, 1 B, is hardly flammable to Austrian standard B3800, Part 1, B 2. The paint is hardly inflammable to DIN 4102-1 cl. B1.
Binding Agent		2-K polyurethane resin
Areas of Application		High-quality top-coat for Metal surfaces, Plastic Coated Steel and PVCu.
Form of Supply	Colours	RAL and BS colour cards Other Colours available on request
	Gloss Level	Silk (30 - 40 gloss levels at 60 °)
Hardener		Avkote Hardener 279
Packing	Coating	1, 3 and 5 Litre disposable containers
	Hardener	1 Litre disposable containers

Technical Data

The data is valid for Avkote PC white 80. The values can change for other colours.

	Coating	**Hardener**	**Mixture**
Specific Gravity (23 ºC)	1.2 g/cm³	1.0 g/cm³	1.17 g/cm³
Solids content	52 ± 2 Weight-%	46 ± 2 Weight-%	Appr 51 Weight-%
Organic Solvent Content.	48 ± 2 Weight-%	54 ± 2 Weight-%	Appr 49 Weight-%
VOC Content (CH / EU)	57 % 570 g/lt	56 % 560 g/lt	57 % 569 g/lt
Shelf life at 20 °C	12 Months	6 Months in well shut containers	
Theoretical Coverage	96 g/m² 10.4 m²/kg for 30 µm dry layer thickness		

Safety Data	**Coating**	**Hardener**
Flash point	27 ºC	0 ºC
Transport ADR/RID	Class: 3 VP: III	Class: 3 VP: III
Poison classification (EU)		
VVS disposal code (EU/CH)	08, 08 01, 08 01 11	08, 08 01, 08 01 11

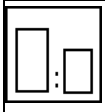
Application Recommendations

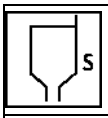
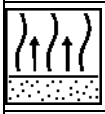
Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
HPF2 Plastisol sheet for the refurb of industrial building	1 x Top Coat	Avkote PC	30-50 µm	5393/PC
Plastic coated steel cladding	1 x Top Coat	Avkote PC	30-50 µm	5393/PC
PVCu Profiles	1 x Top Coat	Avkote PC	30-50 µm	5393/PC
Corroded Steel	1 x Primer	Prime corroded areas with Avkote 8048 Primer		8048
		Avkote 2250 Primer or	40 - 60 µm	EA9000
	1 x Primer	Aquakote AK Primer	30 - 50 µm	7106
	1 x Top Coat	Avkote PC	30-50 µm	5393/PC
Aluminium and galvanised	1 x Primer	Avkote 2250 Primer or	40-60 µm	EA9000
		Aqukoate AK Primer	30 - 50 µm	7106
substrates	1 x Top Coat	Avkote PC	30-50 µm	5393/PC
Old coats of paint (solvent-resistant)	1 x Top Coat	Avkote PC	30 - 50 µm	5393/PC
	For further application proposals please ask our technical department.			

Preparation

	**Substrate**	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	HPF2 Plastisol sheet	Pressure wash substrate thoroughly. Apply Avkote PC.
	Plastic coated steel cladding	Pressure wash substrate thoroughly. Apply Avkote PC.
	Old Coatings	Sand off, clean, prime as necessary.
	Corroded Steel	Pressure wash substrate thoroughly. Remove loose steel from surface. Apply Avkote 8048 Primer to corroded areas. Apply Avkote PC.
	Aluminium and galvanised substrates	Pressure wash substrate thoroughly. Remove any loose debris from surface. Apply 2250 Primer. Apply Avkote PC.

Processing

	**Preventative measures**	We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. 539300PC and 279H00.
	**Stir**	Before use ensure contents are stirred together well with hardener if applicable.
	**Mixing Ratio**	10 : 1 by volume with Avkote 279 hardener Add up to 4:1 Avkote 279 hardener to increase gloss level
	Pot life at 20 °C	Minimum 8 hr. according to tone

	**Thinners**	Dilute with thinners 550 (slow) for use in high temperatures or 95 (fast) for use in cold temperatures to application viscosity according to the table shown below.				
	**brush**	Not recommended				
	**Roll**	4:1 by volume with 279 hardener. Avkote PC to be mixed with 550 thinners.				
		Viscosity DIN-4	**Thinners**	**Nozzle**	**Pressure**	**Spray coats**
	**Gravity Feed Spray-gun**	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	**Suction-spray-gun**	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	**Airless-(Airmix)-Spray**	22 - 25" secs	25 %	06/09	3 – 4 bar	1 - 2
	**HVLP paint gun**	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	**Evaporation time**	Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes.				
	**Drying time**	For 50 µm dry coating at 65 % of relative humidity				
	At 20 °C	Tack-Dry	after:	5	Minutes	
		Touch – Dry	after:	10	Minutes	
		Dried (Can be sanded)	after:	1	Hour	
		Suitable for re-coating	after:	2	Hours	
		Completely Dry	after:	7	days	

Important references

Specific restrictions	Relative humidity max. 80 %		
Minimum application- and drying temperature	15	°C	Do not apply at temperatures below the dew point
Coating removal	Sand blast and/or paint stripper		
Equipment cleaning	Clean immediately after use with Gun Wash Thinners.		

Important Recommendations

	For buildings situated near the sea or in a heavily polluted area or city a clear coat must be applied to protect against the influence of salt air and pollution.
	For pastel coloured coating of surfaces subject to heavy use, such as structural elements, working surfaces etc., it is recommended to clear coat with an Avkote 1483, 1485 or 1495 Lacquer to improve resistance to marking.
	Please observe our Material Safety Data Sheets for all products used as well as the instructions on the tin label.