

DESCRIPTION

Double Coat is a high gloss two component finish based on saturated polyester resins and modified aliphatic isocyanate hardeners.

PRINCIPAL CHARACTERISTICS

- Excellent levelling, easy application by brush, roller or spray;
- Good resistance to various chemicals;
- Excellent scratch and mar resistance;
- Excellent gloss and colour retention;
- Good adhesion to various materials (even without the use of primers);
- Suitable as finishing coat in two component paint systems for properly pre-treated wood, steel, aluminium, epoxy, GRP, ABS, etc.;
- Not suitable for surfaces permanently exposed to water.

COLOURS AND GLOSS

29 standard colours, transparent and metallic, other colours on request - High gloss

BASIC PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,2 g/cm ³ (depending on colour)
Solid content	: approx. 52 % (volume)
Recommended d.f.t.	: 35 - 70 µm (dry), depending on application, see additional information
Dust dry after	: approx. 2 hours
Full cure after	: approx. 5 days, see additional information
Recoating interval	: min. 24 hours, see additional information max. unlimited, provided gritpapered, clean and dry
Shelf life	: separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	: Double Coat base component 44 °C Double Coat hardener 45 °C

SPREADING RATE

At 35 µm (d.f.t.)	: 12,3 m ² /kg (14,8 m ² /l)
At 50 µm (d.f.t.)	: 8,6 m ² /kg (10,4 m ² /l)
At 70 µm (d.f.t.)	: 6,2 m ² /kg (7,4 m ² /l)

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

SUBSTRATE CONDITION AND TEMPERATURE

Steel	: properly derusted (ISO Sa 2 1/2), pre-treated with IJmopox ZF primer/IJmopox HB coating and sanded with grit paper P180-220;
Aluminium	: clean and dry, in good condition, free from any contamination and loose particles, degreased with Double Coat Degreaser and pre-treated with IJmopox ZF primer/IJmopox HB coating and sanded with grit paper P180-220;
Wood	: moisture content maximum 12%, pre-treated with Variopox Injection resin and sanded with grit paper P120;
GRP	: dry, sanded with grit paper P220-280 and degreased with Double Coat Degreaser;
Previous two component coatings	: clean and dry, in good condition, free from any contamination and loose particles, sanded with grit paper P120-180 and degreased with Double Coat Degreaser. Double Coat Dubbel is not suitable for painting on top of a (traditional) one-component paint;

Other substrates : clean and dry, in good condition, free from any contamination and loose particles, pre-treated with IJmopox ZF primer or Variopox Injection resin and sanded with grit paper P180-220.

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly.

Mixing ratio : 67,0 base : 33,0 hardener (by weight)
The mixing ratio by volume depends on colour.
Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : 30 minutes at 20 °C
Pot life : 2 hours at 25 °C (depending on colour)
3 hours at 20 °C (depending on colour)
4 hours at 15 °C (depending on colour)

Application with :

	Brush/roller	Air spray	Airless spray
Type thinner	Brush thinner	Spray thinner	Spray thinner
% of thinner	3 - 5 %	5 - 15 %	0 - 5 %
Nozzle orifice	n.a.	1.2 - 1.4 mm	0.009 - 0.011 inch
Nozzle pressure	n.a.	2 - 3 bar	160 Bar
Cleaning	Brush thinner	Spray thinner	Spray thinner

ADDITIONAL INFORMATION

- Recoating and curing of Double Coat

	15 °C	20 °C	25 °C
Minimum	32 hours	24 hours	16 hours
Maximum, with Double Coat, without sanding	3 days	2 days	1 day
Maximum, after sanding with grit paper P320-P400	unlimited	unlimited	unlimited
Fully cured after	10 days	5 days	3 days

- Recommended filmthickness

The recommended filmthickness in this datasheet is for each separate layer and depends on application method. How many layers are recommended depends on the field of application, the exposure conditions and type of substrate. The total necessary number of layers can be found in the paint system recommendation.

- Application of Double Coat by brush or roller

- Adjust the viscosity with Double Coat Brush thinner to 50 to 55 s DIN 4 after the induction time.
- Use oval brushes or solvent resistant mohair or moltoprene rollers.

- Application of Double Coat by air spray

- Application of Double Coat by air spray is only recommended for professional users only.
- Adjust the viscosity with Double Coat Spraythinner to 18 to 20 s DIN 4 after the induction time.
- Apply a mist coat first, followed by a full cross layer after 15 minutes.
- Depending on size and shape of the to be sprayed object and temperature, Double Coat Spraythinner may be replaced with Double Coat Spraythinner 60. Double Coat Spraythinner 60 is a slow evaporation thinner, improving levelling and reducing overspray.

- Application of Double Coat by airless spray
 - Application of Double Coat by airless spray is only recommended for professional users only.
 - Adjust the viscosity with approx. 5% Double Coat Spraythinner to 50 s DIN 4 after the induction time.
 - Good results may be obtained with a Wagner Cobra 40/10 with a material pressure of 4 Bar (160 Bar using a 40:1 pump).
 - Use a nozzle of 0.011 or 0.009 inch and angle of 40 to 60°.
 - Depending on size and shape of the to be sprayed object and temperature, Double Coat Spraythinner may be replaced with Double Coat Spraythinner 60. Double Coat Spraythinner 60 is a slow evaporation thinner, improving levelling and reducing overspray.
- Application of Double Coat by airmix or aircoat spray
 - Application of Double Coat by airless spray is only recommended for professional users only.
 - Adjust the viscosity with approx. 8% Double Coat Spraythinner to 45 s DIN 4 after the induction time.
 - Good results may be obtained with a Wagner Cobra 40/10 with a material pressure of 4 Bar (160 Bar using a 40:1 pump).
 - Use a nozzle of 0.011 inch and angle of 40°.
 - Depending on size and shape of the to be sprayed object and temperature, Double Coat Spraythinner may be replaced with Double Coat Spraythinner 60. Double Coat Spraythinner 60 is a slow evaporation thinner, improving levelling and reducing overspray.
- Sanding Double Coat

The best adhesion and gloss is achieved by sanding Double Coat between each coat. Use for every layer a finer grit paper, starting from P240-P320-P360-P400. When a dark shade is chosen as final coat (i.e. DC 855, DC 854, RAL 5011, etc.) we recommend to grit paper the previous coat with P600.
- Metallic effect

It is possible to obtain a metallic effect with Double Coat. Apply first a coat of Double Coat in the required base colour. Follow with one coat of Double Coat metallic. To obtain additional protection this coat may be finished with Double Coat transparent. Apply Double Coat metallic by spray to large areas. Smaller areas, such as striping and waterlines, may be applied by brush or roller.

SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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Disclaimer

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