

DESCRIPTION

Tweecolor is a two component base coat based on saturated polyester resins and modified isocyanate hardeners.

PRINCIPAL CHARACTERISTICS

- Excellent levelling, easy application by brush, roller or spray;
- Good resistance to various chemicals;
- Excellent scratch and mar resistance;
- High gloss;
- Suitable as coating system for moulds for pre-fabricated concrete parts;
- Suitable as fast curing base coat in the Double Coat paint system;
- May be recoated with Double Coat.

COLOURS AND GLOSS

803 Ivory or 811 Light grey- High gloss

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

Density	: approx. 1,3 g/cm ³
Solid content	: approx. 42 % (volume)
Recommended d.f.t.	: 35 - 70 µm (dry), depending on application, see additional information
Dust dry after	: approx. 20 minutes
Full cure after	: approx. 3 days, see additional information
Recoating interval	: min. 2 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)	: base component 44 °C hardener 28 °C

SPREADING RATE

At 35 µm (d.f.t.)	: 12,0 m ² /l
At 50 µm (d.f.t.)	: 8,4 m ² /l
At 70 µm (d.f.t.)	: 6,0 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.

During application and curing a minimum temperature of 10 °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 : 50,0 base : 50,0 hardener (by volume)
Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : none
Pot life : 2 hours at 25 °C (depending on colour)
3 hours at 20 °C (depending on colour)
5 hours at 15 °C (depending on colour)

Application with :

	Brush/roller	Air spray	Airless spray
Type thinner	Brush thinner	Spray thinner	See additional information
% of thinner	3 - 5 %	5 - 15 %	
Nozzle orifice	n.a.	1,4 – 1,6 mm	
Nozzle pressure	n.a.	2 - 3 bar	
Cleaning	Brush thinner	Spray thinner	

ADDITIONAL INFORMATION

- Recoating and curing of Tweecolor

	10 °C	20 °C	25 °C
Minimum	4 hours	2 hours	2 hours
Maximum, without sanding	3 days	2 days	1 day
Maximum, after sanding with grit paper P320-P400	unlimited	unlimited	unlimited
Fully cured after	5 days	3 days	2 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 Tweecolor by brush or roller
 - Adjust the viscosity with Double Coat Brush thinner to 50 to 55 s DIN 4.
 - Use oval brushes or solvent resistant mohair or moltoprene rollers.
- Application of Tweecolor by spray
 - Application of Tweecolor by spray is only recommended for professional users only;
 - Adjust the viscosity with Double Coat Spray thinner to 18 to 20 s DIN 4.
- Application of Tweecolor by airless spray
 - Tweecolor can be applied without adding additional solvent using a Wagner Cobra 40/10.
 - Use a material pressure of 2 ½ Bar (100 Bar with a pump ratio of 40:1).
 - Use a nozzle of 0,013 inch with angle 40 or 60°.
- Sanding Tweecolor
Tweecolor can be sanded 2 hours after application.
- Tweecolor in paint systems
Tweecolor is recommended as base coat for Double Coat for those applications where a rapid curing and rapid sanding is required. Tweecolor is not recommended to be applied directly to epoxy fillers. IJmopox HB coating or IJmopox ZF primer are more suitable for this application.

- Resistance to yellowing
Tweecolor contains aromatic isocyanates. When exposed to direct UV light, yellowing may occur.

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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