

TECHNICAL INFORMATION

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07.12.2021



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Modular Industrial Line

Product name: acrylic polyurethane topcoat with gloss
APP Lack AY/PUR 30-100 Gloss 2:1.
APP No.: 0270110.

Two-component acrylic-polyurethane smooth finish with high gloss. Designed for painting commercial vehicles, buses, tractor cabs, trams. Highly resistant to mechanical influences, impacts and scratches, as well as chemical agents: acids and alkalis in low concentrations, grease and petrol.

Product and accessories.	APP Lack AY/PUR 30-100 Gloss, APP Hardener PUR 30-710, APP Thinner Universal 30-810.
Basic ingredients.	APP Lack AY/PUR 30-100 Gloss – polyurethane/acrylic binder, pigment paste and additives, APP Hardener PUR 30-710 – isocyanate hardener: fast/FAST, standard/STANDARD and slow/SLOW APP Thinner Universal 30-810 – universal thinner.
Colour.	High-gloss colours made according to formulas included in APP Modular Industrial Line. Two pigmentation ratios possible for APP 0270110: <ul style="list-style-type: none">• 20 + 80 (pigment paste + binder),• 30 + 70 (pigment paste + binder).
Surface texture.	Smooth.
Gloss.	>92 for 60°, 90 for 20°
Specific weight.	1.0 kg/L at 20°C
Binder solids content.	53-57% (by weight) 51-55% (by volume)
Solids content of ready-to-use lacquer without thinner.	49-54% (by weight) 50-55% (by volume)
Resistance.	<ul style="list-style-type: none">• 480 h – salt chamber test,• 1440 h – humidity chamber test for environment C5.

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Theoretical efficiency.	For binder: <ul style="list-style-type: none">• 800-1100 m²/L for 1 µm dry layer. For ready-to-use paint without thinner: <ul style="list-style-type: none">• 450-500 m²/L for 1 µm dry layer. Note! In practice, efficiency depends on factors, such as the shape of the object, the roughness of the substrate, the application method and the working conditions.
Corrosion protection class according to ISO 12944.	For APP Primer EP 30-620 + APP Lack AY/PUR 30-100 Gloss (240µm + 60µm): <ul style="list-style-type: none">• for corrosion class C5, durability M (7 to 15 years). For APP Primer EP 30-620 + APP Lack AY/PUR 30-100 Gloss (100µm + 45µm): <ul style="list-style-type: none">• for corrosion class C3, durability L (up to 7 years).
Application.	Designed for painting commercial vehicles, buses, tractor cabs, trams.
<u>Advantages</u>	<ul style="list-style-type: none">• High gloss, mechanical resistance and rich colours.• Very good quality finish and good weather and UV resistance.• Ideal for finishes in commercial vehicles, where a high-quality finish is an important requirement.• It has a high chemical resistance to engine oil, diesel and H₂SO₄, NaOH and HCl solutions in low concentrations.
<u>Substrate</u>	Pre-sanded factory coatings. Surfaces coated with: <ul style="list-style-type: none">• epoxy primers, e.g. APP Primer EP 30-620, APP Grund EP, APP Grund EP Spray,• polyurethane primers, e.g. APP Primer PUR 30-630,• insulating and adhesive primers, e.g. APP Sealer PUR 30-640,• acrylic primers, e.g. APP Acrylfiller 401, APP Acrylfiller 501, APP Acrylfiller Rapid, APP Acrylfiller Compact,• single-component fillers, e.g. APP Primer Filler, APP Primer Filler Spray• insulating and filling primer APP Smart Primer Spray,• adhesion primers, e.g. APP Kunststoff Primer.

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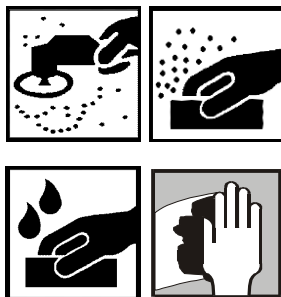
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Substrate preparation.



Existing finishes.

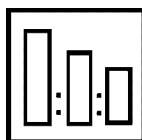
- Dry sand with P320-P360 abrasive paper. Hand sanding finish with sandpaper on a P500-P600 sponge.
- Sand by hand with P600-P800 waterproof sandpaper.

Before spraying APP Lack AY/PUR 30-100 Gloss, clean the lacquered surface of dust and degrease it with APP WB910, APP W911 or APP W900 remover using APP Premium cleaner.

For final dust removal, use APP SAS or APP SAS Aqua dust-absorbing cloths. Optionally, dry sand the APP Primer EP 30-620 and APP Primer PUR 30-630 primers with P320 machine.

Application

Mixing ratios.

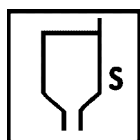


Volume mixing ratios for temperatures of 18-25°C:

- | | |
|-----------|---|
| 2 volumes | APP Lack AY/PUR 30-100 Gloss |
| 1 volume | APP Hardener PUR 30-710 |
| | <ul style="list-style-type: none">• small surfaces – FAST• large surfaces – STANDARD |
| 10-20% | APP Thinner Universal 30-810 |

Volume mixing ratios for temperatures >25°C:

- | | |
|-----------|--|
| 2 volumes | APP Lack AY/PUR 30-100 Gloss |
| 1 volume | APP Hardener PUR 30-710 |
| | <ul style="list-style-type: none">• small surfaces – STANDARD• large surfaces – slow/SLOW |
| 10-20% | APP Thinner Universal 30-810 |



Spray viscosity at +20°C: 20-23 s F/4.

Note!

Use only APP Hardener PUR 30-710.

Do not exceed the recommended hardener amount.

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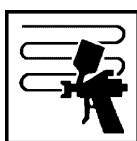
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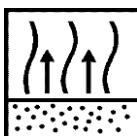
Application.



Apply with a spray gun equipped with a $\varnothing 1.3\text{-}\varnothing 1.5$ mm nozzle at an air pressure of 2.0 to 3.0 bar.

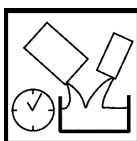


Number of layers: 2 x 1.
Dry coating thickness: 40-50 μm .



Evaporation time between coats at +20°C:

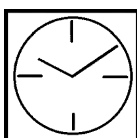
- 10 minutes.



Shelf life of ready-to-use paint mixture:

- 8 hours.

Drying.



At +20°C:
Manipulability: 6 h.
Cross-slip hardening: 12 h.

At +60°C:
Cross-slip hardening: 30 min.



IR radiator: 15-25 min.

The coating achieves its full performance properties after a seasoning period, i.e. after 10 to 15 days at 18-22°C.

Sanding.



After 24 hours at +20°C it is possible to polish and remove defects and inclusions with abrasives:

- by hand, wet with P1500-5000 abrasive,
- by machine using P1500-5000 abrasive.

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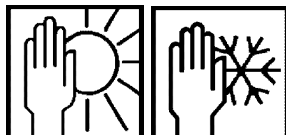
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Equipment cleaning.

Nitrocellulose, PUR or acrylic solvent.

Storage



Store in closed original packaging in a dry and well-ventilated room, at +5°C to + 30°C.

Protect from frost and direct sunlight.

OHS regulations



For professional use only.

See text on product labels or SDS.

The user must comply with the OHS regulations in force in the country concerned.

VOC

VOC in g/L: 2004/42/EC – II A (j) (500)

Permissible VOC content in g/L in the ready-to-use product:

500 g/L for APP Lack AY/PUR 30-100 Gloss.

Maximum VOC content in g/L in the ready-to-use product with 20% thinner addition:

<500 g/L for APP Lack AY/PUR 30-100 Gloss.

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