

## TECHNICAL INFORMATION

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07.12.2021



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### **Modular Industrial Line** **Product name: polyurethane primer with gloss** **APP Lack PUR DTM 30-220 Gloss 4:1. APP No.: 0270130.**

Two-component, high-gloss, smooth polyurethane primer containing anti-corrosive pigments. Intended for the coating of commercial vehicles, tractor frames and semi-trailers, agricultural machinery, tanks, machine parts and steel constructions as a one-coat system giving a topcoat finish and corrosion protection. 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 PUR DTM 30-220 Gloss,  
APP Hardener PUR 30-710,  
APP Thinner Universal 30-810.

Basic ingredients. APP Lack PUR DTM 30-220 Gloss – polyurethane 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.  
APP 0270130 – 20 + 80 (pigment paste + binder)

Surface texture. Smooth.

Gloss. >90 for 60°, 70-80 for 20°

Adjustment of gloss by mixing APP Lack PUR DTM 30-220 Gloss with APP Lack PUR DTM 30-220 Matt.

Lack PUR DTM 30-220 Gloss	Lack PUR DTM 30-220 Matt	Hardener PUR 30-710	Gloss 60°	Category
100	0	4:1	> 90	Gloss
75	25	4:1	70-90	Semi-Gloss
50	50	4:1	40-70	Satin
25	75	4:1	20-40	Satin
0	100	4:1	< 20	Matt

The degree of gloss/matt depends on the colour, amount of thinner, dry layer thickness, substrate and drying temperature.

Specific weight. 1.0-1.1 kg/L at 20°C

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Binder solids content.	52-58% (by weight) 42-48% (by volume)
Solids content of ready-to-use lacquer without thinner.	48-57% (by weight) 38-43% (by volume)
Resistance.	<ul style="list-style-type: none"><li>• 240 h for 60µm of dry layer APP Lack PUR DTM 30-220 Gloss – salt chamber test.</li></ul>
Theoretical efficiency.	For binder: <ul style="list-style-type: none"><li>• 420-480 m<sup>2</sup>/L for 1 µm dry layer.</li></ul> For ready-to-use paint without thinner: <ul style="list-style-type: none"><li>• 380-430 m<sup>2</sup>/L for 1 µm dry layer.</li></ul> 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 (140µm + 60µm) APP Primer EP 30-620 + APP Lack PUR DTM 30-220 Gloss: <ul style="list-style-type: none"><li>• for corrosion class C5, durability M (7 to 15 years).</li></ul> For (130µm) APP Lack PUR DTM 30-220 Gloss: <ul style="list-style-type: none"><li>• for corrosion class C4, durability L (up to 7 years).</li></ul>
Application.	Intended for the coating of commercial vehicles, tractor frames and semi-trailers, agricultural machinery, tanks, machine parts and steel constructions as a one-coat system giving a topcoat finish and corrosion protection.
<u>Advantages</u>	<ul style="list-style-type: none"><li>• Direct adhesion to iron, stainless steel, galvanised steel, cast iron, aluminium, ABS and PVC, methacrylate and gelcoat.</li><li>• Gloss, good mechanical resistance, hardness and elasticity.</li><li>• For the desired gloss level, it is miscible with Lack PUR DTM 30-220 Matt.</li></ul>

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#### Advantages

- Coat with corrosion protection.
- Reaction to fire  
CLASS B-s1, d0 (UNE-EN 13501-1:2007+A1:2010)
- Easy preparation and application.
- As an alternative to classic primer + lacquer coatings, recommended for a wide range of industrial applications.
- It has a high chemical resistance to engine oil, diesel and H<sub>2</sub>SO<sub>4</sub>, NaOH and HCl solutions in low concentrations.

#### Substrate

Direct adhesion to iron, stainless steel, galvanised steel, cast iron, aluminium, ABS and PVC, methacrylate and gelcoat.  
Pre-sanded factory coatings.

Surfaces coated with:

- 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.

#### Substrate preparation. Steel.



- Blasting treatment to a cleanliness grade of Sa 2½.
- Manual or mechanical cleaning to St 3.

The treated surface should be free of rust, scale, oil, grease, loose old coating, dust and other contaminants. It should have a uniform metallic sheen.



Galvanised steel and aluminium.

- Dry sand with P240-P320 abrasive paper.
- Very gentle blasting treatment.

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Substrate preparation.



Existing finishes, polyester laminates, PVC and ABS.

- 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.

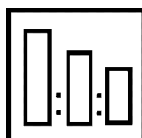
Before spraying APP Lack PUR DTM 30-220 Gloss, clean the lacquered surface of dust and degrease it with APP WB910, APP W911 or APP W900 remover using APP Premium cleaner.

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:

4 volumes APP Lack PUR DTM 30-220 Gloss

1 volume APP Hardener PUR 30-710:

- small surfaces – FAST/STANDARD,
- large surfaces – STANDARD.

10-20% APP Thinner Universal 30-810  
max 30%

Volume mixing ratios for temperatures >25°C:

4 volumes APP Lack PUR DTM 30-220 Gloss

1 volume APP Hardener PUR 30-710:

- small surfaces – STANDARD,
- large surfaces – slow/SLOW.

10-20% APP Thinner Universal 30-810  
max 30%

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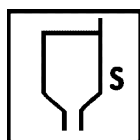
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Spray viscosity at +20°C: 20-23 s F/4.

Note!

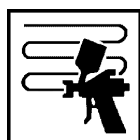
Use only APP Hardener PUR 30-710.

Do not exceed the recommended hardener amount.

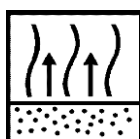
Application.



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

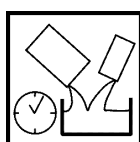


Number of layers: 2 x 1.  
Dry coating thickness: 60-70  $\mu\text{m}$ .



Evaporation time between coats at +20°C:

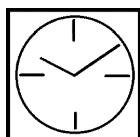
- 10 minutes.



Shelf life of ready-to-use paint mixture:

- 5 hours.

Drying.



At +20°C:  
Manipulability: 4-4 h and 30 min.  
Cross-slip hardening: 8 h – 10 h.

At +60°C:  
Cross-slip hardening: 40 min.



IR radiator: 20-30 min.

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

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#### Sanding.

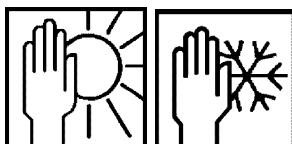


After 24 hours at +20°C it is possible to polish and remove defects and inclusions with abrasives:

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

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 PUR DTM 30-220 Gloss.

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

>500 g/L for APP Lack PUR DTM 30-220 Gloss.

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