



# BITHANE 2K TOPCOAT

## PRODUCT DESCRIPTION

A high performance automotive finishing coating.

## PRODUCT FEATURES

- Excellent gloss, flow & colour retention
- High mechanical & chemical resistance
- Resistant to weathering
- Excellent adhesion
- Good scratch resistance
- Good stain resistance
- Easy to maintain

## TECHNICAL INFORMATION

Colour: White, Black & Clear  
Appearance: High gloss  
Generic type: Iso-cyanate cured acrylic  
S.G.: 1.18 – 1.21  
Viscosity: 82ku  
Spreading rate: 10m<sup>2</sup>/litre at 40 microns DFT  
Solvent: Hydrocarbon true solvent blend  
Total solids: 50 – 52 %  
Recommended DFT: 40 microns  
Opacity at 80 microns wet film: Contrast ratio 0.98  
Mix ratio: 2 parts A, 1 part B  
Packaging: 1 & 5 litre base component  
1 & 5 litre Curing agent  
Pot life: 4 hours at 25°C

## SURFACE PREPARATION

All surfaces are to be clean, dry, free of dust, grease, oil, dirt & old paint. BITHANE 2K should always be applied to a suitably primed & or intermediate coat adhering to the over coating Times as specified. (Suitable primers are Etch Primer, Corpro 200, Corpro 500 & BITHANE MS Primer)

## APPLICATION

Stir contents of base component with a flat paddle, prior to adding the curing agent. After adding the base & curing agent together, mix with a flat paddle until homogenous.

Airless spray: Nozzle pressure: 120 -150 bar  
Nozzle orifice: 0.015:

Conventional spray: Gravity feed air pressure: 4 – 5 bar  
Nozzle orifice: 1.3 – 1.5 mm

Suction feed air pressure: 4 – 5 bar  
Nozzle orifice: 1.7 mm

Brush and Roller: Not recommended

Clean up: Do not allow to dry on or in equipment. Wash immediately with 2K thinners.

When spraying BITHANE 2K, it is essential that it be done in a well ventilated area & an AIR FED HOOD BE WORN.

## ENVIRONMENT

For best performance, confine application to the following:

Surface temperature: Min. 20°C Max. 28°C

Ambient temperature: Min. 20°C Max. 28°C

Relative humidity: Min.0% Max.70%

Or at least 3°C above Dew point

Do not leave the container open, as solvent loss will result.

## DRYING TIME

Substrate Temp	Touch Dry	Hard Dry
20°C	40 minutes	18 hours
25°C	25 minutes	12 hours

## OVERCOATING TIMES

20°C: 8 hours

25°C: 4 hours

Full cure: 7 days at 25°C

## STORAGE AND HANDLING

Store away from direct sunlight & severe cold.

Shelf life : 1 year in original sealed containers.

Flash point: 11°C for both base & curing agent.

## LIMITATIONS

BITHANE 2K contains iso-cyanates & should be handled with care. Gloves, eye protection & an air fed mask are required when spraying. The above are given as guidelines & can not be assumed to be absolute, as variances will result from different film thickness, environment & surface temperatures.

## SAFETY PRECAUTIONS

This product contains flammable solvents. Keep away from sparks, open flames & ensure that no smoking is permitted in the area.

Ensure good ventilation during painting and drying.

KEEPOUTOFREACHOFCHILDREN.

Information Provided is based on Laboratory evaluations and data believed to be reliable.  
Recommendations are given in good faith but without warranty. It is the user's responsibility to determine the suitability for their own use.  
It is not to be considered a guarantee of the products properties.

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