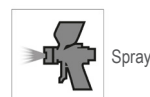


1818 POLIURETANICO EXTRA LUCIDO

TWO-PACK POLYURETHANE TOP COAT



Description and Use

Gloss polyurethane finishing coat based on polyester resin and isocyanate adduct. Recommended for painting cycles where high gloss and weathering resistance are requested. Product also suitable for nautical use. It can be coloured using the ADVANCE HT tinting system.

Substrate preparation

IRON SURFACES:

- Remove any trace of rust, iron scale, grease and moisture by sand-blasting SA2.5 grade; otherwise, carry out a careful mechanical cleaning followed by solvent degreasing.
- Then apply the primer FONDO R.E. code 1827 or FONDO EPOX code 1806.

GALVANIZED STEEL:

- Carefully clean off any debris and oxidation, degrease thoroughly with organic solvents and apply EPOX UNDERCOAT P/N 1806.

ALUMINIUM AND LIGHT ALLOYS:

- Chromatising or phosphochromatising treatment; otherwise, slight matting with sandpaper followed by organic solvent degreasing. Next, apply FONDO EPOX code 1806.

Application

Application method:

- air mix spray gun with nozzle Ø 1.2-1.5 mm and pressure of 3-4 bar.
- airmix: do not diluite, nozzle Ø 0.009", exit pressure of the product 130 – 140 bar, auxiliary air pressure 2.5 –3.0 bar

Product preparation:

Stir thoroughly the product to achieve even colour and consistency.
Then add the suitable hardener in the following ratio:

	By weight	By volume
PRODUCT 1818 POLIURETANICO EXTRA LUCIDO	100	100
HARDENER 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALLENTE RAPIDO	50	55
THINNER 1611 DILUENTE EXTRA PU or 1653 DILUENTE PER ACRILICI or 1624 DILUENTE LENTO UNIVERSALE IND	max 5	max 5

Recommended thicknesses:

40-50 µm dry film, waiting 5-10 minutes between coats.

How to prepare intermediate matte finishes:

To obtain intermediate levels of mat effect, the product can be mixed with 18180000 CONVERTER POLIURETANICO EXTRA LUCIDO according to the quantity in the following table:

INTERMEDIATE MATTE TABLE WITH 1818	95 gloss	70-80 gloss	50-60 gloss	20-30 gloss	5-10 gloss
18180000 CONVERTER PU EXTRA LUCIDO	100	30	20	10	0
18440000 CONVERTER PU OPACO HT	0	70	80	90	100
1873 INDURITORE	50	30	30	25	25

Code 1844 and code 1818 percentages are referring to converter as is, not yet tinted, and are expressed as percentages in weight.

Hardener code 1873 amount is referred to the colored converter, and is expressed in weight.

The intermediate levels of matt, which can be achieved through mixing the two converter are purely indicative, since they can vary due to the tint, the thickness and to drying speed.

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 12 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with current legislation.

Technical features

Colour	see price list
Appearance of the dry film	glossy
Type of product	two component
Pot-life	4 hours. At higher temperatures pot-life decreases.
Viscosity **	80-110 seconds ISO-DIN Cup 6
Practical cover rate *	5-6 m ² /kg per two coats
Air drying (20°C and 65% R.H.)	20-30 minutes, dust free
	5-6 hours, touch dry
	24 hours, through drying
Oven drying (60°C)	5-10 minutes, flash off
	30-60 minutes, through drying
Maximum chemical resistance	after 7 days
AFNOR NF T 36-005 classification	Family I - Category 6c
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
** May change according to the colour.	
The data are measured at a temperature of 20°C.	

Warnings

- During application, it is recommended to follow the thicknesses specified for each single coat. Otherwise, and especially in case of high environment temperature, blisters may come up on the film surface.
- Do not apply the product after the specified pot life, as the film that forms may have poor adhesion to the substrate.
- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always refer to the safety data sheet for the relevant products.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market and the tinting of the product can lead to slight deviations in the declared values, in the colour and in the aesthetic effects obtained. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.technica@impa.it.