

**Industrial coating****2K Hydro soft feel lacquer, black****Bayhydrol U 2698//UH 340/1 and Desmodur ultra N 3600//Bayhydur ultra 2655****Basis** Polyurethane

	Guide Formulation of Covestro		PCO SF 0042-TC
Component A	Bayhydrol U 2698	(1)	26.2
	Bayhydrol UH 340/1	(1)	34.0
	Demineralized water		18.2
	Lucrafoam DNE 01	(2)	0.2
	Byk-348	(3)	0.5
	Tego-Wet KL 245, 50 % in water	(4)	0.3
	Aquacer 535	(3)	1.3
	SILLITIN Z 86	(5)	4.6
	Microtalc IT Extra	(6)	3.7
	Kremer Color Paste – Lamp Black	(7)	3.9
Acematt 3300	(8)	2.5	
Component B	Desmodur ultra N 3600 / Bayhydur ultra 2655 (70:30)	(1)	4.6
	75 % in 1-methoxy-2-propylacetate		
	Total % by weight		100.0

Mixing

The raw materials of Component A (except Acematt 3300) are predispersed in a dissolver in the order in which they are given in this formulation. Then they are ground in a laboratory shaker ('Red Devil') for max. 25 min. The temperature of the Bayhydrol component should not exceed 40°C. Then Acematt 3300 is stirred in for approx. 10 min.

After mixing component A and B, the formulation is thinned for spraying application to an efflux time of approx. 30 s (5 mm flow cup, DIN EN ISO 2431).

Composition in % (approx.)	Binder	30.7
	Water	53.7
	Co-solvent	1.1
	Pigment / Filler	12.4
	Additives	2.1



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Technical Data	NCO / OH	approx. 1.5
	Pot life	approx. 60 min
	pH	7.5

Recommended drying:
10 min flash-off time, 30 min 80°C + 16 h 60°C (or 72 h at room temperature)

Suppliers	(1)	Covestro
	(2)	Levaco
	(3)	Byk Chemie
	(4)	Evonik Tego Chemie
	(5)	HOFFMANN MINERAL
	(6)	Elementis
	(7)	Kremer Pigmente
	(8)	Evonik Industries

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