



Industrial coating
1K Stoving soft feel lacquer, gray, matte
Desmophen 1652 and Desmodur BL 3175

Basis Polyurethane

Guide Formulation of Deuteron (equal to RR 6837 of Covestro)		RR 87
Grinding stage	Desmophen 1652	(1) 301.0
	Kronos 2160	(2) 86.5
	Heucodur Yellow 5R	(3) 4.3
	Heucodur Blue 4G	(3) 0.6
	Special Black 4	(4) 0.5
	SILLITIN Z 86	(5) 24.9
	CAB-531-1 10 % in Solvesso 200 / butyl diglycol (2:1)	(6) 62.2
	Acronal 4 F 50 % in Solvesso 200	(7) 12.4
	Bentone 38 10 % swelling)*	(8) 24.9
	Solvesso 200	(8) 182.7

disperse by bead mill to a fineness of grind < 5 µm

Let-down stage	Desmodur BL 3175 SN	(1) 107.5
	Dibutyl-tin-dilaurate, 10 %	12.4
	Lanco TF 1778	(9) 19.6
	Deuteron MK	(10) 36.5
	Acematt OK 412	(11) 14.7
	Solvesso 200	(8) 109.3
	Total parts by weight	1000.0

)* 10 % Bentone swelling:

Bentone 38	10.0	(12)
Anti-Terra-U	5.0	(13)
Solvesso 200	85.0	(8)

prepare by stirring (15 m/s, 10 min)

Note The combination of CAB-531-1 and Acronal 4 F ensures good deaeration and flow properties.
 Without dibutyl-tin-dilaurate as a catalyst, a significantly increased PMT is necessary.



RR 87

Composition in % (approx.)	Binder	38.2
	Pigment	11.7
	Additives	2.0
	Matting agents	7.1
	Solvents	41.0

Technical Data	NCO / OH	1 : 1
	Ratio pigment / binder	0.31 : 1
	Solids content (% by weight)	approx. 59 %
	Viscosity	23°C, DIN EN ISO 2431, 5 mm approx. 100 s
	Stoving conditions	PMT (peak metal temperature) 232°C
	Gloss 60°	approx. 4 GU

Suppliers	(1) Covestro
	(2) Kronos International
	(3) Heubach
	(4) Orion Engineered Carbons
	(5) HOFFMANN MINERAL
	(6) Eastman Chemical Company
	(7) BASF
	(8) ExxonMobil
	(9) Lubrizol Coating Additives
	(10) Deuteron
	(11) Evonik Industries
	(12) Elementis
	(13) Byk Chemie

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