

TECHNICAL DATA SHEET

supersedes previous issue dated 12/10/05

PU 6019
EXTRA CLEAR POLYESTER BASECOAT

Areas of use:	Flat parts, turned parts, profiles.		
Method of use:	Normal spray to be used with double suction pumps		
Mixing Procedure:		by Weight	by Volume
	Part A	PU 6019	100
	Part B (accelerator)	PH 888	2
	Part C (catalyst)	PH 999	2
	Thinner	DX 1131	5-10

Technical characteristics

Solid content % (w/w):	84 ± 3
Specific gravity:	1.055 + 0.030
Viscosity (DIN 6 at 20°C):	23" + 2"

General characteristics

Pot -life:	16'-18'
Number of coats:	from 1 to 3 according to requirements
Interval between coats:	Min. 20' - Max. 35'
Recommended application weight (g/m ²):	200 ÷ 250 per coat
Drying at 20°C:	from 24 to 48 hours
Sanding:	wait at least 24 hours
Shelf-life:	6 months

High build, ease of application, good sandability, high elasticity, with an extremely clear film. It can be applied in more than one coat with wet -on-wet system with an interval of 20'-30' between the coats to enable gelling of previous coat.

Warning

If accelerator and peroxide (such as PH 888 and PH 999) come into direct contact they can cause a violent chemical reaction which can constitute a hazard for the operator. For this reason, first mix PH 888 thoroughly with PU 6019 and only then mix with PH 999.

Special instructions

Being a PE coating, it should not be used at temperatures below 15°C and on items with relative humidity exceeding 14%. Actually, under these conditions, final drying may be affected. The mixing procedure with PH 888 at 2% and PH 999 at 2% refers to winter. During summer, or in tropical areas, PH 888 should be reduced to 1% to avoid stratification. In wintertime the quantity of PH 888 can be increased by 1%.

To extend pot -life to some 45' PH 666 can be used at 4% instead of PH 999, although drying is slower.

For a pinkish film we recommend using PH 777 non-greenish activator at 2%, although drying is slower and pot -life is shorter (approx. 5').