

# 1800 PU OPACO HT

TWO-PACK POLYURETHANE TOP COAT



Industry



Two-component



Spray

## Description and Use

Matt polyurethane finishing coat based on polyester resin and isocyanate adduct.

Recommended for painting cycles when excellent outdoors weathering resistance is required, together with high surface spreadability and ease of application.

Product for general use in industrial cycles as for structural steel, metal furniture, machine tools.

It can be coloured using the ADVANCE HT tinting system.

## Substrate preparation

### IRON SURFACES:

- Take off 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.

### Product preparation:

Stir thoroughly the product to achieve even colour and consistency.

Then add in the following ratio:

	By weight
<b>PRODUCT</b> 1800 PU OPACO HT	100
<b>HARDENER</b> 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE	25
<b>THINNER</b> 1611 DILUENTE EXTRA PU or 1653 DILUENTE PER ACRILICI	10-20

**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:

<b>INTERMEDIATE MATT LEVELS with code 1818</b>	<b>15 gloss</b>	<b>20 gloss</b>	<b>35 gloss</b>	<b>65 gloss</b>
18000000 CONVERTER PU OPACO HT	90	85	80	75
18180000 CONVERTER PU EXTRA LUCIDO	10	15	20	25
1873 INDURITORE	25	25	30	30

**Code 1800 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 lot shown on the packaging. The lot number comprises 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

Color	see price list
Appearance of the dry film	matt
Gloss	5-10 gloss (Gardner 60°)
Type of product	two component
Pot-life	2.5 hours. At higher temperatures pot-life decreases.
Viscosity **	5500-7500 mPa.s Brookfield rpm 20 s 4
Practical cover rate *	4-5 m <sup>2</sup> /kg (2 layers)
Air drying	20-30 minutes, dust free
	4-6 hours, handling
	24 hours, through drying
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 and 65% R.H.	

## 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.
- Thicker layers produce more polished finish.
- By speeding up the drying in oven (with the same thickness), more lucid films are obtained.
- Tint variations that are obtained by transforming the same color formula from glossy to matt, are to be considered entirely normal.
- 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 read the safety datasheet before use.
- Dispose of contents / container 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](mailto:assistenza.technica@impa.it).