

# 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:

- 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 the suitable hardener in the following ratio:

	By weight	By volume
<b>PRODUCT</b> 1818 POLIURETANICO EXTRA LUCIDO	100	100
<b>HARDENER</b> 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALLENTE RAPIDO or 1874 INDURITORE PER POLIURETANICI PER ESTERNO	50	55
<b>THINNER</b> 1611 DILUENTE EXTRA PU or 1653 DILUENTE PER ACRILICI	max 5	max 5

**Recommended thicknesses:**  
40-50 µm dry film, waiting 5-10 minutes between coats.

## Storage life

12 months in its original packing.

## Technical features

Color	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 <sup>2</sup> /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
* 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 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 job from 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 lots of the same material are used in the same job/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).