

PEACOPOUR RC FINISH

Product Code: 6537

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PRODUCT INTRODUCTION

- Two components recoatable Polyurethane acrylic HB finish
- Used as finish coat with excellent colour, gloss retention and weather resistance
- Non chalking and non-yellowing
- Resistant to splash of mild chemicals
- Air dry or bake dry at low temperature. Cured at temperature down to -5°C

PHYSICAL PROPERTIES

Colours and gloss	colours – gloss, semi-gloss & matt
Mass density	approx. 1.1-1.25g/cm ³
Solids content (by volume)	Colour: approx. 60% Metallic: approx. 50%
VOC	395-420 g/litre
Recommended dry film thickness	Colour: 40-70 μm Metallic: 25-50 μm
Theoretical spreading rate (based on 60% solid content)	15 m ² /l for 40 μm 12 m ² /l for 50 μm 8.6 m ² /l for 70 μm
Touch dry (at 20^oC)	20 mins
Bake dry	20 mins at 80 $^{\circ}\text{C}$
Overcoating interval	4 hours at 20 $^{\circ}\text{C}$
Fully Cured	7 days
Pot Life	4 hours at 20 $^{\circ}\text{C}$
Shelf life(cool and dry place)	at least 12 months
Flash point	base 25 $^{\circ}\text{C}$, hardener 25 $^{\circ}\text{C}$

APPLICATION CONDITIONS AND TEMPERATURE

- Previous coat; dry and free from any contamination and sufficiently roughened if necessary
- Substrate temperature should be at least 3^oC above dew point
- Maximum relative humidity during application and curing is 85%

APPLICATION INSTRUCTION

Mixing ratio

base to hardener 5.2:1 *by volume*

- Too much solvent results in lower sag resistance and slower cure
- Thinner should be added after mixing the components
- For metallic finish, multi-applications by spray will be necessary to achieve the required metallic sheen appearance. Air spray is always recommended.
- For matt finish, spraying method is always recommended. Different gloss appearance will be resulted by different application methods.
- For light colour, 2-3 application will be necessary to hide the underneath coats.
- The coverage will be varied respect to different colours.

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CURING TABLE

	AIR SPRAY	AIRLESS SPRAY	substrate temperature	dry to handle	full cure
Recommended thinner	Thinner 014 (flash point 25 °C)	Thinner 014 (flash point 25 °C)	-5 ⁰ C	48 hours	22 days
Volume of thinner - for 50 μm	~15%	~10%	0 ⁰ C	24 hours	18 days
Nozzle orifice	1-1.5 mm	0.33 mm	10 ⁰ C	12 hours	10 days
Nozzle pressure	0.3-0.4 MPa (approx. 3-4 AT; 43-57 P.S.I.)	15MPa (approx. 150 AT; 2100 P.S.I.)	20 ⁰ C	6 hours	7 days
			30 ⁰ C	4 hour	4 days
			40 ⁰ C	3 hour	3 days
BRUSH AND ROLLER					
Recommended thinner	Thinner 014		10 ⁰ C	5 hours	
Volume of thinner	<5%		20 ⁰ C	4 hours	-
			30 ⁰ C	3 hours	-
			40 ⁰ C	2 hours	-
CLEANING SOLVENT					
Thinner 068 (flash point 30 °C)					

	POT LIFE(AT APPLICATION VISCOSITY)	INDUCTION TIME
10 ⁰ C	5 hours	
20 ⁰ C	4 hours	-
30 ⁰ C	3 hours	-
40 ⁰ C	2 hours	-

OVERCOATING TABLE

substrate temperature (°C)	-5	0	10	20	30	40
minimum interval (hours)	36	24	12	4	3	2
maximum interval	no limitation, surface should be dry and free from any contamination					



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