

# ONECOAT

## Two component polyurethane paint with very high solids content

### NATURE AND USE

Aliphatic polyurethane non-yellowing product of great fullness and brightness, excellent as to elasticity, surface hardness and resistance even in aggressive industrial atmospheres; it has excellent direct adhesion to various substrates such as steel, aluminum and fiberglass duly prepared or other substrates pretreated with undercoats or appropriate primers.

Onecoat is used as a top-coat or "One pass" product of initials coating systems and maintenance of industrial equipment, fiberglass constructions, heavy carpentry, tanks, pilings, etc.

### TECHNICAL DATA



<b>Type of Binder:</b>	Aliphatic Polyurethane non-yellowing
<b>Specific Gravity A+B</b>	Kg/l 1,25 ± 0,10 (depending on the colour) @ +20°C
<b>Solids by Weight:</b>	% 98 ± 2 % A+B
<b>Solids by Volume</b>	% 97 ± 2 % A+B
<b>Mixing Ratio by Weight:</b>	100 parts of Base / 40 parts of Hardener
<b>**Pot life @ +20°C:</b>	~45 minutes
<b>Colour:</b>	RAL Colours
<b>Applied product appearance:</b>	Glossy

### SUBSTRATE PREPARATION:

**All kind of steel substrates:** Cleaned, degreased, decontaminated, roughened and perfectly dust free. Substrates must always be completely humidity free.

**Steel:** Steel blast cleaned to SA 2,5 according to ISO 8501/1, roughness profile of 40-50 µm. When sandblasting is not possible (only painting coating systems not designated for off-shore or submerged structures in exercise), the substrate must always be accurately cleaned, dry, degreased, rust or calamine free, mechanically abraded to minimum ST3 degree according to ISO 8501/1 and treated with suitable primer.

**New galvanized steel:** Dry, perfectly degreased, lightly roughened (wire wool), pickled or seasoned.

**Galvanized steel already painted (with two component coating system):** Mechanically abraded to remove all rust traces and previous coating not well adhering.

**Gelcoat:** Dry sandpapering with abrasive paper P120-P180. Before to apply Onecoat verify that the substrate is perfectly dry (R.H. ≤ 0,8%).

**Wood:** Dry sandpapering with abrasive paper P120. Before to apply Onecoat verify that the substrate is perfectly dry (R.H. ≤ 15%).

**Cement:** Clean (free from oils, detaching greases and any contaminant), free from detaching particles and any Efflorescence, completely dry (less than 4% of internal humidity), and seasoned: 28 days at least for ordinary Portland cement, then perfectly roughened and dust free and treated with suitable primer. Before substrate preparation and product application, verify the total internal absence of actions generated by water presence and due to capillarity and water creeks.

### PRODUCT PREPARATION

Separately stir each component carefully. While the Hardener (component B) is added to the Base (component A) continue mixing to reach the complete homogenization. Let the mix rest for 5 minutes before starting the application. The indicated time can increase or decrease depending on the type of equipment in use for the application.

MTDS 01018/ Page 1 of 3

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\*\* The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.  
Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.\*\*

### APPLICATION DETAILS

<b>Application method:</b>		Standard Airless Spray with compression ratio 30:1 minimum Dual Feed Hot Airless Spray for two component (Bimixer) Airmix application Roller Brush only small areas
<b>Thinner:</b>		Thinner PUR 11
<b>Thinning:</b>	%	ready to use 0 – 5 Max. if necessary
<b>Cleaning:</b>		Thinner PUR11
<b>Hardening @ +25°C:</b>		Dust free 3 – 5 hours Through dry 16 – 24 hours Ready to sandpaper after 36 hours minimum Full cured in 10 days
<b>Overcoating interval @ +20°C:</b>		Minimum 12 / Maximum 36 hours
<b>Application temperature:</b>	°C	Between +5°C and +35°C
<b>Product temperature:</b>		Between +5°C and +35°C
<b>Substrate temperature:</b>		Between +5°C and +35°C and always at least +3°C/+5°C above dew point
<b>Relative humidity:</b>	%	Maximum 80
<b>Suggested Film Thickness per coat:</b>		Min. 100 µm / Max. 300 µm dry (DFT)
<b>Theoretical spreading rate:</b>	sqm/l	~ 9,8 at a dry film thickness of 100 µm DFT

### HANDLING STORAGE AND SAFETY PRECAUTIONS

**Warning:** All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

**Handling:** The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

**Precautions:** When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

MTDS 01018/ Page 2 of 3

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**Storage and transport:** Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

**Shelf life:**            **Base**    **12 months** in the suggested storage conditions (original unopened packaging)  
                              **Hardener** **6 months** in the suggested storage conditions (original unopened packaging)

N.B.: **Product for professional use only and exclusively for the uses not regulated under CE Directive 2004/42/CE.**

**Refer to Material Safety Data Sheet**

MTDS 01018/ Page 3 of 3

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