

# ONECOAT FAST

Two component polyurethane paint with very high solids content and fast drying

## NATURE AND USE

Polyurethane non-yellowing product of great fullness and 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 Fast is used as a top-coat or "One pass" product of initial coating systems and maintenance of industrial equipment, fiberglass constructions, heavy carpentry, tanks, pilings, etc.

## TECHNICAL DATA



Type of Binder:	Polyurethane
Specific Gravity A+B	Kg/l 1,350 ± 0,10 (depending on the colour) @ +20°C
Solids by Weight:	% 96 ± 2 % A+B
Solids by Volume	% 94 ± 2 % A+B
Mixing Ratio by Weight:	100 parts of Base / 20 parts of Hardener
**Pot life @ +20°C:	~10 minutes
Colour:	RAL Colours
Applied product appearance:	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.

**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 applying Onecoat Fast verify that the substrate is perfectly dry (R.H. ≤ 0,8%).

**Wood:** Dry sandpapering with abrasive paper P120. Before applying Onecoat Fast 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. Transfer each of the two components in the dedicated storage tank of the Bi-mixer. Heat up to the perfect atomization of the product during spray application.

\*\* 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.\*\*

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## APPLICATION DETAILS

<b>Application method:</b>	Dual Feed Hot Airless Spray for two component (Bi-mixer) with Compression ratio 45:1 minimum Automatic pre-mixing of the components at the spray nozzle
	It is allowed the separate pre-heating of each component as well as of the substrate
<b>Nozzle diameter:</b>	0.018 ÷ 0.028 inches (mm0,45 – mm 0,71) (indicative data)
<b>Nozzle pressure:</b>	180 - 250 Kg/sqcm (indicative data)
<b>Thinning:</b>	% None. Do not thin
<b>Cleaning:</b>	Thinner PUR11 Wash the whole application equipment got in contact with the catalysed product immediately after use.
<b>Hardening @ +25°C:</b>	Dust free ~ 5 – 30 minutes Touch dry 2 – 4 hours Full cured in 7 - 10 days
<b>Overcoating interval @ +20°C:</b>	Minimum 30 / Maximum 120minutes According to the substrate to coat and its temperature
<b>Indicative Preheating temperature:</b>	+30/+50°C (Base) / +20/+35°C (Hardener)
<b>Temperature of the substrate:</b>	> +5 / +65°C always at least +3 /5°C above dew point
<b>Relative humidity:</b>	% < 80 %
<b>Suggested Film Thickness per coat:</b>	Min. 200 µm / Max. 800-1000 µm dry (DFT)
<b>Theoretical spreading rate:</b>	sqm/kg ~ 1,4 at a dry film thickness of 500 µm dry (DFT)

More info by writing to [sales@industri brunostoppa nipa nts.com](mailto:sales@industri brunostoppa nipa nts.com) or by calling +39 030 9745116

## 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.

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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



Access catalogues, data sheets and company presentations

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