

STOPCOAT 660 HS

Acryl Polyurethane two-component Finish with orange peel effect

NATURE AND USE

Two-component product providing excellent elasticity, hardness and resistance in industrial and marine environment. The coating forms a typical "orange peel" film, suitable to hide superficial defects and to reduce the reflection on wide flat substrates. Thanks to these characteristics, the product is suitable for the coating of plants exposed in marine environment, industrial machinery and plants where the resistance to fair aggressive chemicals is required. Excellent resistance to washing with detergent.

TECHNICAL DATA



Type of binder:	Acryl – Polyurethane
Specific Gravity A+B:	kg/l 1,25 ± 0,10 @ +20°C
Solids by Weight:	% 73 ± 2% A+B
Solids by Volume:	% 61 ± 2% A+B
Mixing Ratio by Weight:	100 parts of Base / 50 parts of Hardener
**Pot life @ +20°C:	≥ 4 hours
Colour:	RAL
Appearance:	Glossy orange peel effect

SUBSTRATE PREPARATION:

Steel: Steel blast cleaned to SA 2,5 (Rz DIN 30-40 µm) apply 1 coat of zinc based epoxy Stopcoat 71 or suitable epoxy undercoat. After 24 hours apply a second coat of epoxy undercoat. Finish with Stopcoat 660 HS.

Aluminium and light alloys: Remove the superficial oxidized coat with wire brush or grinding disk. Remove dust and brushing residuals, degrease the substrate with Epothinner and apply 1 coat of Stopcoat 305. Finish with Stopcoat 660 HS.

Substrates already painted: Verify the adhesion compatibility with the already applied material, the areas to be coated must be free from any surface contaminant and must be perfectly dry with no trace of humidity.

All Substrates: Clean, duly prepared and treated with suitable primer, perfectly dry.

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.

** 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

Application method:	Airmix Conventional Spray
Thinner:	Ready to use Possible thinning with Thinner PUR11
Thinning:	% 0 - 10
Cleaning:	Thinner PUR11

MTDS 01018/ Page 1 of 2

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Hardening @ +25°C:	Dust dry 2 – 3 hours
Overcoating interval @ +20°C:	Minimum 12 / Maximum 24 hours
Application Ambient Temperature:	Between +5°C and +35°C
Suggested Temperature of the product:	+20 ÷ +30°C
Substrate Temperature:	+5 / +40°C always at least +3/5°C above dew point
Relative Humidity:	≤ 80%
Film Thickness per coat:	Minimum 50 µm / Maximum 120 µm dry (DFT)
Theoretical spreading rate:	sqm/l 4,5 – 5,0 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.

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 2 of 2

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