

45-8000

Clearcoat 2K 4:1:3 Bic-Ben

BIC-BEN® 2K 4:1 Topcoat

VERSION

Version 1

Date 30th October, 2020

PRODUCT DESCRIPTION

45-LINE is 2K 4:1 polyurethane Topcoat. It's providing adhesion, Good hardness. Excellent in weathering resistance. It's designed for large area.

KEY CHARACTERISTICS

- 2K 4:1 topcoat
- Good weathering coat

PHYSICAL PROPERTIES

Supply viscosity	50 – 60 second by Ford cup 4
Specific gravity	0.91 – 1.00 g/cm ³
Degree of gloss	80 -100 GU at 60°
Shelf life	1 Year
	Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

APPLICATION PARAMETERS



Part A : Hardener : Thinner

4 : 1 : 1 By Volume

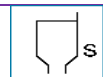
Mixing ratio

Hardener 21-2 [Hardener for 2K Top Coat 4:1:3] or recommended by our technician

Reducer Thinner 2K Thinner # 86-120

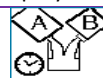
Coverage 10 m² / liter ready to use mixture at dry film 50 micron

By using the recommended application, the theoretical material coverage

Note. The practice material usage depends on many factors i.e. shape of object, roughness of the surface, application techniques, pressure and application circumstances.

Ford cup No. 4 15-18 seconds

Spray viscosity



2– 3 hr. at 25 °C

Pot life



Gravity feed 1.2 – 1.4 mm

Air pressure 1.7 -2.2 bar

Spray condition

28 – 30 psi

HVLP max 0.6 – 0.7 bar (8-10 psi) at the air cap



2 coats

Dry film thickness 50-60 micron.

Number of coats



10 – 15 mins

at 25 – 30 °C

Flash time



Dry time

	20 °C	30 °C	40 °C
Dust free time	30 min	20 mins	10 mins
Dry to handle	9-10 hr.	7-8 hr.	4-5 hr.
Dry to polish	9-10 hr.	7-8 hr.	4-5 hr.

PRECAUTION

Warning

For professional or trained applicator use only. Not for sale or use by the general public. before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep out reach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area.