

## Guiding Formulation

### Waterborne 2K- metallic base coat for low temperature applications based on Bayhydrol XP 2621

Rec. No.                      Date                      Revised:  
75-09005                      26.04.07 /Mi



<u>Component A</u>	<u>p. b. w.</u>	
I. Bayhydrol XP 2621, approx. 40% f.s.	27,07	www.bayer-ls.com
II. Dest. water	17,27	
Butyl glycol	2,97	
Dimethylethanolamine, 10% in water	5,70	
Byk 011, f.s.	1,92	www.byk.com
Byk 347, f.s.	0,34	"
- 10 min. by propeller stirrer, at 5.2 m/s -		
III. Viscalex HV 30, 30% f.s.	2,53	www.cibasc.com
Dest. water	17,27	
- 10 min. by propeller stirrer, at 5.2 m/s -		
IV. Butyl glycol	2,97	
Dest. water	8,60	
- 10 min. by propeller stirrer, at 5.2 m/s -		
V. Metallic-paste (Formulation; see on page 3)	10,65	
- 30 min. by propeller stirrer, at 10.5 m/s -	-----	
	97,29	
 <u>Component B</u>		
VI. Bayhydrol 3100, f.s.	2,71	
- 10 min. by propeller stirrer, at 5.2 m/s -	-----	
	100,00	

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This information is for your advice on conscientiously executed tests. Considering the variety of tests this information is without warranty.

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75-09005

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Revised:

### Coating formulation :

#### Component A :

Take part I and add II, III, IV and V in sequence after stirring times.

#### Component B:

Before application, add comp. B (part VI), after mixing the pH of the base coat should be tested and if necessary, adjusted with a 10% aqueous solution of dimethylethanolamine. Then dest. water should be added to adjust the coating to spray viscosity, finally you have to sieve (for example 56 µm sieve) the base coat.

After mixing with the reactive component B, max. pot life is approx. 3 hours (must be tested).

### Technical data :

Application viscosity, DIN cup, 4 mm	approx. 40s
Thinner	dest. water
pH-value	8.0-8.5
Pot life	approx. 3h
Drying condition	e.g. 30 min. 60 °C
( Re-coatable with for example 1K- or 2K- PUR clear coat. )	

### Binder combination (solid / solid) :

Bayhydrol XP 2621 / Bayhydrol 3100 (80:20)

### Pigments and additives on solid binder :

#### p. b. w.

Metallic-paste	approx. 25,5
Viscalex HV 30	approx. 5,6
Byk 011, f.s.	approx. 14,2
Byk 347, f.s.	approx. 2,5
Butyl glycol	approx. 43,9

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#### Metallic paste

#### p. b. w.

I. Butyl glycol	41,88	
II. Bayhydrol D 270, approx. 70% f.s.	2,89	<a href="http://www.bayer-ls.com">www.bayer-ls.com</a>
III. Additol XL 250, 55% f.s.	4,36	<a href="http://www.cytec.com">www.cytec.com</a>
IV. Stapa Hydrolan 2156 No. 55900/G Aluminium, 60% f.s.	50,64	<a href="http://www.eckart.net">www.eckart.net</a>
V. Dimethylethanolamine, 100% f.s.	0,23	
	-----	
	100,00	

#### **Metallic paste formulation :**

Take I and add II, III, IV and V in sequence, stirring slowly (propeller stirrer), test the pH-value (pH 8.0-8.5) and if necessary, adjust the paste with a 10% aqueous solution of dimethylethanolamine. Then stirring for 30 min. by a propeller stirrer at 10.5 m/s (max. temperature: 50°C).

#### **Metallic paste data :**

pH-value	8.0-8.5
Solid content	approx. 32.4 p.b.w.
Org. volatile content	approx. 64,5 p.b.w.
Aluminium powder content	approx. 28.4 p.b.w.

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