

CHING-HYDRO-PUR-Zwischenbeschichtung HSDD 37











Intended use

Fest-drying, water-based 2C-HYDRO-Intermediate coating based on polyurethane for primed steel, galvanized steel, aluminium, cast aluminum and gray cast iron.

Application

Machinery and equipment manufacturing, vehicle manufacturing, transformer and motor manufacturing

General information

	Color shades	grey, beige, red brown, others on request			
	Gloss	mat			
	Mixing ratio	Hardener	per weight [Paint : Hardener]	per volume [Paint : Hardener]	
		Hardener HD 127	100 : 3	100 : 3,5	
	Pot life	approx. 3 h	NC 23°C/50% End of pot life not visible! Exceeding the pot life causes a reduction of technological values.		
	Stirring / Dilution	Stir the product mechanically before each use. Ready to use after adding hardener. When mechanically stirring in the hardener, the viscosity will increase temporarily. After adding the hardener and adjusting the processing viscosity, allow the mixture to degas for at least 10 minutes. Dilute with deion. Water if necessary.			
	Spraying	Viscosity [DIN 4]	Thinner [%]	Nozzle [mm]	Pressure [bar]
	Cup gun	30 - 50 s	5 - 10	1,5	4 - 5
	Airless (Airmix)	Delivery form	≤ 3	0,28 - 0,45	120 - 200
	Brush application	Delivery form			
	Roller application	Delivery form (multiple application is recommended due to structure formation and minimum layer thicknesses)			
	Flow application	n.a.			
	Substrate preparation	according to DIN EN ISO 12944-4; qualified primer and/or intermediate coating. Surface clean, dry and free of dust, salt, oil and grease			



Viscosity delivery form

35 - 45 DIN-6-seconds



Drying time¹

at 60 µm

Temperature

NC 23/50

Dust-dry

30 min.

Grip resistant

1 - 2 h

Mech. resilient

3 - 4 h

Recoatable²

2 - 3 h³

¹ Based on delivery viscosity! Humidity has a decisive influence on drying!

² with itself (not normally required for top and final coats, except possibly for minimum coat thicknesses)

³ with suitable subsequent coating e.g. HSDD 47 semi-glossy



Other values

Density
[g/cm³]

1,3 ± 0,1

Solids
[Weight. %]

64 ± 3

Solid volume
[%]

52 ± 3

[cm³/kg]

380 ± 20

Efficiency¹
[m²/kg]

6,4

WFF

1,9

DFT²
[µm]

60 - 120

Consume
[g/m²]

160 ± 20

VOC-content
[g/l] (± 20)

100

Temperature resistance³

100°C

These values are imputed values that may vary depending on the color shade and application. Drying times are correspondingly longer for thicker layers. The drying times are shortened by forced drying.

¹ ± 0,5 for 60 µm dry layer thickness (depending on shade)

² With layer thicknesses > µm bubbles may form!

³ Dry heat



Notes

- **Storage**
18 months (in unopened original container. Store cool but frost protected!)
- **Processing conditions**
 - ❖ The air and object temperature should be at +10°C to +40°C (optimally at 15-35 °C) and the relative humidity at max. 80 %. The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air during application.
 - ❖ Sufficient supply and exhaust air must be provided.