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Composition Mixture of pigments in solution of acrylic resin in organic solvents, hardened with aliphatic polyisocyanate.

Characteristics and use The enamel is determined for surface treatment, where there are high requirements for decorative properties of the coating, such as high gloss and perfect flow. The coat is resistant to weather, yellowing, flouing and effects of various chemical substances and humidity. Before use the paint is mixed properly with the hardener in specified ratio.

- ◆ excellent weather resistance
- ◆ excellent gloss
- ◆ colour stability
- ◆ perfect levelling
- ◆ suitable for the tinting system HOSTEMIX

Application area Exterior and interior with medium and higher corrosive stress, mainly where there are high requirements on perfect design.

Shades According to BAL, RAL, NCS, PANTONE and ČSN colour chart and the others according to individual customer requirements.

Physical properties	Flow time	80 - 130 s (cup Ford Ø 4 mm)
	Weight solids	ca 50% (hardened mixture)
	Volume solids	ca 40% (hardened mixture)
	Flash point	> 25 °C
	Density of product	1050 – 1250 kg/m ³
	Density of hardened mixture	1000 - 1200 kg/m ³

Emission limits	VOC: 0.46 – 0.50 kg/kg of hardened mixture	TOC: 0.40 - 0.45 kg/kg of hardened mixture
	This product is for professional use only. Not for DIY.	

Properties of cured coat	Hiding power	degree 1 - 2
	Gloss / 60°	≥ 85
	Pendulum hardness / Persoz	up 20 % in 1 day

Drying time	Surface temperature	15 °C	23 °C
	Dust free	30 min	20 min
	Dry through	6 h	4 h
	Dry film thickness DFT	40 µm	40 µm

Spreading capacity	Wet film thickness WFT	100 µm
	Dry film thickness DFT	40 µm
	Theoretical spreading capacity	8.3 - 10 m ² /kg

Thinning TELSOL PUR 3, U 6003, TELSOL UNI (for higher temperature by application). To thin after hardening.

Hardening Hardener: TELHARD PUR, TELHARD PUR 3, TELHARD PUR 4

Mixing weight ratio: 5 weight parts TELPUR T 360 : 1 weight part TELHARD PUR
 2 weight parts TELPUR T 360 : 1 weight part TELHARD PUR 3
 4 weight parts TELPUR T 360 : 1 weight part TELHARD PUR 4

The pot life of the hardened mixture is 4 hours (20 °C).

Surface preparation For corrosive environment C2, C3 and C4 the surface must be prepared before the prime coat application by blast-cleaning to degree Sa 2 ½ according to EN ISO 8501-1 (welds and edges must be prepared according to EN ISO 8501-3).

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Galvanized and aluminous surfaces must be treated according to EN ISO 12944-4, čl. 12.1. and 12.2. It is necessary to clean, degrease and remove poorly adhering old coats from previously painted surfaces. To ensure compatibility of new coat with old one it is recommended to contact the producer or carry out test reference coating on surface of 1 m².

Application conditions

Stir the paint properly with a mechanical stirrer before use so that there will be no sediment on the bottom and harden. To thin and filter if it necessary.

For coating / spraying outside the suitable weather forecast is necessary. During rain, fog, creation of condensation water, effect of aggressive gases and during wind with strong content of dust the coating work must be suspended and can be restart after absolute drying of surface-treated material. Minimal air temperature for application is 10 °C, temperature of painted surface must be 3 °C above dew point. Temperature and relative humidity must be measured in proximity of painted surface. The surface temperature must not be higher than 40 °C. Relative humidity must not be higher than 75 %. Lower temperature and higher humidity during an application and a drying and high thickness of applied coats markedly slow down drying and hardening of the coat. Imperfectly dried surface can cause problems with adhesion of paint to surface or with adhesion between individual coats. In addition, it can negatively affect overall appearance of the paint film.

Workflow

1. Apply 1 coat of TELPUR P 180 two-component polyurethane primer or TELPOX P 100 S two-component epoxy primer. To prepare an ideal appearance, it is suitable to use TELPUR P 180 hardened with TELHARD PUR P hardener, which is sandable after 10 hours and creates a completely smooth surface.
2. Apply 2 or 3 coats of two-component polyurethane enamel TELPUR T 360. Individual coats of painting system are applied in interval 24 hours at 20 °C or by the system so-called "wet into wet". Optimal thickness of one wet coat is 100 µm (35 – 40 µm DFT).

The paint is applied by cross spraying or in parallel strips to achieve a final uniform layer. First it is necessary to treat problematic places (corners, edges, welds, surface defects).

It is very important to apply each coat in a uniform layer, in a thickness specified by the specific paint system. Consumption of paint must be checked to avoid excessive thickness, to avoid splashing, cracking and solvent retention.

For larger compact areas always use the material from the same batch. Using the same batch can guarantee the same shade of the colour. We recommend mixing the content of the individual cans by homogeneous mixing.

Optimal thickness of system

The optimal thickness and composition of the paint system depends on the aggressivity of atmosphere and on the expected durability of a protective system. The selection of an appropriate system should be in accordance with EN ISO 12944-5: 2018.

Application

Conventional spraying (recommended viscosity 25–30 s / cup Ford Ø 4 mm; 20 - 25 % thinning)
 Airmix spraying (recommended viscosity 20 – 40 s / cup Ford Ø 4 mm; 20 - 25 % thinning)

Application data

Data for conventional spraying

Spraying gun e.g. EST 115, EcoGun 116, EcoGun 246
 Nozzle according to desired capacity 1.2 – 1.4; Air pressure 1.5 – 2 atm

Data for airless spraying AirMix (tested on the device EcoPump VP 55 445, 64:1 gear ratio, in combination with air assist spraying gun EcoGun 2100 (DÜRR))

Device	Nozzle	Pressure on nozzle	Thinning
AirMix	0.007 inch (0.18 mm)	19 Mpa (190 atm) air assist 1.1atm	20 %
AirMix	0.009 inch (0.23 mm)	19 Mpa (190 atm) air assist 1.0 atm	20 %

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Recommended filter of spraying gun yellow 100/149 (mesh/ μm), spraying angel 20 – 60°. It is not recommended using free adjustable nozzle.

Handling	Read the instructions in the Safety Data Sheet before use and follow all safety instructions and regulations. The product contains organic solvents. Follow basic hygiene rules. Do not eat, drink or smoke while using this product. Avoid contact with eyes, skin or clothing. Wear protective gloves, eye protection, protective clothing. Ensure effective ventilation of the workplace.
Packing	10 kg; 1 kg (tinted, not hardened product)
Storability	The product keeps the product qualities 24 months from production date in original closed container. To store in dry storage at the temperature 5 to 25 °C. Flammable liquid II. hazard class.
Disposal of packing and waste	Hand over the used, properly empty packing at the collection point of the packing waste. Dispose the packing with the product rest at the place determined by the town for disposal of hazardous waste or hand over to the person authorized for hazardous waste disposal. Further see the product safety data sheet.

These data are only for information and their accuracy is influenced by the properties of individual materials and unpredictable factors during application. The user is responsible for correct use of the product according to the direction for use and for correct application of painting system, i.e. he must always evaluate all conditions of application, which could influence final quality of the top treatment. Therefore, we always recommend to the user to carry out the test for actual working conditions and type of surface applied. Above mentioned data are data, which influence individual working conditions and therefore they do not establish a legal claim. It is necessary to consult information outside the terms of this catalogue sheet with the producer.

The producer stipulates the right for the change in the catalogue sheets without previous notification.