

Page number: 01



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.
The final properties of coat (including adhesion) are achieved after complete maturing in approximately 7 to 10 days.

- ◆ 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 BALT, 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. | |

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|---------------------------------|----------------------------|------------------|
| 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 | 90 µm |
| | Dry film thickness DFT | 40 µm |
| | Theoretical spreading capacity | 9 - 10 m ² /kg |

Thinning TELSOL PUR 3, BALTECH U6003, TELSOL UNI (for higher temperature by application). To thin after hardening.
Other diluents (especially those containing alcohols) can significantly slow down the curing mechanism of the chemical reaction.

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

Mixing weight ratio: 5 weight parts TELPUR T360 : 1 weight part TELHARD PUR
2 weight parts TELPUR T360 : 1 weight part TELHARD PUR 3
4 weight parts TELPUR T360 : 1 weight part TELHARD PUR 4

Page number: 02



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).

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.

The temperature of the paint itself should be 15-25 °C. If the paint temperature is below 15 °C, a higher dilution is required and this can subsequently cause problems with the formation of a homogeneous paint film and a longer drying time.

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 and can lead to reduced gloss or other irreversible surface defects such as graying and whitish haze. Both the paint and the object to be treated, as well as the surrounding environment, must have a suitable temperature. Condensation that occurs during or just after application can cause a matte finish and poor quality paint film.

If the paint film is prematurely exposed to standing water, the shade may change, especially in dark shades and at low temperature.

Thermal resistance Thermal resistance of the cured coat: up to 120 °C: without restrictions, the hardness of the coating film gradually increases during long-term loading and the flexibility decreases. At temperatures of 120 °C to 150 °C, visual changes, gradual increase in hardness, decrease in flexibility and embrittlement of the coating film may occur.

Workflow

1. Apply 1 coat of TELPUR P180 or TELPUR P150 two-component polyurethane primer or TELPOX P100 S two-component epoxy primer. Drying time 24 hours. To prepare an ideal appearance, it is suitable to use TELPUR P180 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 T360. Individual coats are applied by the system so-called "wet into wet". Optimal thickness of one wet coat is 90 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.

Page number: 03



Application Conventional spraying (recommended viscosity 25–35 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) | 12-18 Mpa (120-180 atm) air assist 1.0-1.6 atm | 20-25 % |
| AirMix | 0.009 inch (0.23 mm) | 12-18 Mpa (120-180 atm) air assist 1.0-1.6 atm | 20-25 % |

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.