



BAJATHANE * TOPCOAT 55210

CURING AGENT 95370

Description: BAJATHANE TOPCOAT 55210 is a two-component, semi-gloss aliphatic acrylic polyurethane coating with good gloss and color retention.

Recommended use: As a finishing coat for protection of structural steel in severely corrosive environment, where light-fastness and gloss retention are required.
Minimum temperature for curing is -10 °C /14°F.

Service temperatures: Maximum, Dry: 120°C/248°F(see REMARKS overleaf).

Approvals: Approved as a low flame spread material by Germany authorities.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	white/10000*	Blue/30840*
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	51±1	49±1
Theoretical spreading rate:	10.4 m ² /litre - 50 micron 417 sq.ft./US gallon- 2 mils	9.8 m ² /litre - 50 micron 393 sq.ft./US gallon- 2 mils
Flash point:	31°C/88°F	31°C/88°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon	1.1 kg/litre - 9.2 lbs/US gallon
Surface dry:	2½ (approx.) hrs at 20°C/68°F (ISO 1517)	2½ (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	8 (approx.) hours at 20°C/68°F	8 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	445 g/litre - 3.7 lbs/US gallon	465 g/litre - 3.9 lbs/US gallon
Shelf life:	1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.	

* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 55210:	Base 55210 : Curing agent 95370 7 : 1 by volume	
Application method:	Airless spray	Brush
Thinner (max.vol.):	See REMARKS overleaf	08080 (5%)
Pot life:	2 hours (20°C/68°F)	
Nozzle orifice:	.017"-.019"	
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 08080 OR 08510	
Indicated film thickness, dry:	50 micron/2 mils	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

Issued: Mar. 2014

2. BAJATHANE TOPCOAT 55210

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10\text{ }^{\circ}\text{C}/14^{\circ}\text{F}$. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX HI-BUILD 45200, BAJAPOX 45141, BAJAPOX 45230 or according to specification.

SUBSEQUENT COAT: None.

REMARKS:

Colours: Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.

SERVICE TEMPERATUR: At service temperature above $100\text{ }^{\circ}\text{C}/212^{\circ}\text{F}$), slight discoloration may be expected.

FILM THICKNESS: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. Normal range is 40-60 micron/1.6-2.4 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local condition.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
The best result is obtained by applying a mist coat of BAJATHANE ENAMEL 55210 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 55210 with 55210	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 95370 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.
BAJATHANE TOPCOAT 55210 is for professional use only.

Safety:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAK Material Safety Data Sheets and follow all local or national safety regulations. This goes for personal protection such as, but not limited to, protection of lungs, eyes and of the skin, medical treatment in case of swallowing the paint or in case of other direct contact with the paint. Take necessary precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas and ensure that adequate forced Ventilation exists when applying paint in confined spaces or when the air is stagnant.

Issued: Mar. 2014