

DESCRIPTION

Double Coat Modellak is a high gloss two component finish based on saturated polyester resins and modified aliphatic isocyanate hardeners, especially developed for models and moulds.

PRINCIPAL CHARACTERISTICS

- Excellent levelling, easy application by spray;
- Good resistance to various chemicals;
- In combination with Double Coat Modellak hardener within 24 hours resistant to gelcoat and styrene, see additional information;
- Excellent scratch and mar resistance;
- Excellent gloss and colour retention;
- Excellent adhesion to GRP, wood, MDF and Poltix fillers;
- Suitable as coating system for models used for the production of moulds for the GRP industry.

COLOURS AND GLOSS

RAL 1001 beige - High gloss

BASIS PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,3 g/cm ³
Solid content	: approx. 59 % (volume)
Recommended d.f.t.	: 35 - 50 µm (dry), depending on application, see additional information
Dust dry after	: approx. 30 minutes
Full cure after	: approx. 7 days, see additional information
Recoating interval	: min. 24 hours, see additional information max. unlimited, provided gritpapered, clean and dry
Shelf life	: separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	: Double Coat Modellak base component 44 °C Double Coat Modellak hardener 1 °C

SPREADING RATE

At 35 µm (d.f.t.) : 12,9 m²/kg (14,8 m²/l)

At 50 µm (d.f.t.) : 8,6 m²/kg (10,4 m²/l)

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

SUBSTRATE CONDITION AND TEMPERATURE

All substrates : clean and dry, in good condition, free from any contamination and loose particles, degreased with Double Coat Degreaser and pre-treated with IJmopox ZF primer/IJmopox HB coating, Poltix Sprayfiller or IJmofix and sanded with grit paper P300-320;

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly.

Mixing ratio : 67,0 base : 33,0 hardener (by weight)

63,0 base : 37,0 hardener (by volume)

Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : none
 Pot life : 3 hours at 25 °C
 4 hours at 20 °C
 5 hours at 15 °C

Application with :

	Brush/roller ¹	Air spray	Airless spray
Type thinner	Spray thinner	Spray thinner	n.a.
% of thinner	3 - 5 %	5 - 15 %	
Nozzle orifice	n.a.	1,4 – 1,6 mm	
Nozzle pressure	n.a.	2 - 3 bar	
Cleaning	Spray thinner	Spray thinner	

¹ Application by brush or roller is only possible for small repairs and touch-up

ADDITIONAL INFORMATION

- Recoating and curing of Double Coat Modellak

	15 °C	20 °C	25 °C
Minimum	32 hours	24 hours	16 hours
Maximum, without sanding	3 days	2 days	1 day
Maximum, after sanding with grit paper P320-P400	unlimited	unlimited	unlimited
Styrene resistant after ²	32 hours	24 hours	16 hours
Styrene resistant after ³			
Fully cured after	10 days	5 days	3 days

² combination of Double Coat Modellak base and Double Modellak hardener

³ combination of Double Coat base with Double Coat hardener

- Recommended filmthickness
 The recommended filmthickness in this datasheet is for each separate layer and depends on application method. How many layers are recommended depends on the field of application, the exposure conditions and type of substrate. The total necessary number of layers can be found in the paint system recommendation.
- Application of Double Coat Modellak by brush or roller
 - Application by brush or roller is only recommended for small repairs and touch-up.
 - For larger surfaces use Double Coat in combination with Double Coat hardener. In that case, wait at least 5 days before making a mould or product on the painted surface.
 - Adjust the viscosity with Double Coat Spray thinner to 50 to 55 s DIN 4 after the induction time.
 - Use oval brushes or solvent resistant mohair or moltoprene rollers.
- Application of Double Coat Modellak by spray
 - Application of Double Coat Modellak by spray is only recommended for professional users only;
 - Clean spray equipment thoroughly with clean Double Coat Spray thinner before start of application. Flush the systems twice with clean Double Coat Spray thinner.
 - Adjust the viscosity with Double Coat Spray thinner to 18 to 20 s DIN 4 after the induction time.
 - Apply a mist coat first, followed by a full cross layer after 15 minutes.
- Sanding Double Coat
 The best adhesion and gloss is achieved by sanding Double Coat between each coat. Use for every layer a finer grit paper, starting from P240-P320-P360-P400.
- Resistance to styrene
 Double Coat Modellak is recommended for models used to produce moulds for the GRP industry. For this specific application it is imperative that all materials used in the paint system for the model

resist styrene. When a component does not resist styrene, this can lead to serious surface defects in model or mould.

SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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Disclaimer

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