

**Data sheet for coating materials by von Höveling Farben GmbH & Co.KG****Date of issue: Dec. 2008****Name of product: DD - Hartlack 208 - coloured - D 83****Type of material - characteristics:**

DD-Hartlack 208 -coloured- is a solvent-containing 2-component polyurethane coating varnish.

DD-Hartlack ist employable for surfaces above water of steel, aluminium-, wood and GRP on boats and yachts.

It is a light-resisting, high-gloss coating, flexible and mechanically resistant with excellent scratch resistance.

DD-Hartlack is a durable coating with good protection and is splash water resistant against sea water and a multitude of salts and oils.

Colour: diverse RAL-hues according to price-list

Gloss: glossy**Coating proposal:****Repair:** DD-Hartlack coloured can be used on cleaned, mat-polished old coating with 1 - 2 coats of paint (approx. 40µm each).**New coating:** Apply 2 coatings on the support pre-treated with **Epoxi-Primer D 53** (approx. 40 µm each).**Technical data**

Density:	1,1-1,3 kg/l	non-volatile matter:	ca. 40	%
th. spread rate:	12 m ² /l	with sensitive dry layer:	40	µm
mean layer	40 µm dry	with brush/roller corr. to approx.:	80	µm wet
thickness:	40 µm dry	with spraying corr. to approx	80	µm wet

The practical spreading rate is calculated from the theoretical spreading rate minus losses due to processing and object geometry (DIN53220)

Preparation of the undercoat:Dull-grind and dedust old coatings. Remove loose components and pretreat the undercoat with **Epoxi-Primer D 53**

The undercoat must be clean, dry and free of fat and dust.

Mixing data

Basic component:	2 Weight %	Prereaction time:	15 Minutes
Hardener:	1 Weight %	Pot life (20° C) :	4-6 Hours
Consistency:	liquid		

Attention: Even if the material stays liquid after 6 hours, it must no longer be used !!!**Application method:** Painting, rolling, spraying**Drying times (at 20° C) :**

touch dry:	1 hour
non-crush:	4 hours
fully cap. of bearing:	7 days

Reworking times (at 20° C) :

reworkable after min.:	8 hours
reworkable up to max.:	48 hours*

The data mentioned above depend on temperature, number of layers, thickness of layers, ventilation and type of stress.

* After exceeding the reworking times, the complete area has to be grinded before renewed coating.

Processing hints:

DD-Hartlack is a 2-component product. Before processing, the basic component has to be thoroughly stirred up and then the adequately measured supplied hardener has to be completely and thoroughly intermixed. This is best done with a mechanical stirrer and a stirring time of 5 minutes. Bottom and border regions have to be included.

The processing must only be done if the temperature of the coating surface is 3° C above the dew point of the surrounding air.

For troublefree drying, the object temperature should be neither below 10° C nor above 30° C. At temperatures below 10° C drying time is considerably prolonged, and the period until the next coating should be a minimum of 48 hours. At temperatures below 5° C a coating is no longer possible.

For airless processing a nozzle diameter of 0.33 - 0.38 mm at the nozzle with a dynamical pressure of approx. 150 - 200 bar is necessary.

For spray treatments a nozzle diameter of 1,2 - 1,4 mm with a spraying pressure of 3 - 5 bar is recommended. The spray viscosity can be set with max. 10% **Thinner 008 D 28**.

For spray treatment areas of difficult access, as e.g. narrow edges, profile backs etc. have to be precoated by brush. During processing the wet layer thickness has to be controlled to avoid harmful over- and undercoatings.

Sufficient ventilation in closed rooms for processing and in the drying phase has to be provided.

Before the following coating, weathered areas have to be cleaned with special care by brushing and washing with Cleaner 350; afterwards roughing by grinding.

After the end of the works the instruments have to be cleaned with **Thinner 008 D 28**.

Safety data:

Flash point: Base: 25° C Hardener: 24° C (DIN 53213)

Further important safety data are to be found in the EU safety data sheet. The safety marks on the shipping drums, valid coating regulations, norms and directives have to be respected.

Tests and expertises:

Packing :

Basic comp. 500ml Hardener: 250ml Total: 750 ml

Storage:

Time from delivery date: 12 months
Storage temperature: from 5° C to 35° C

This product information serves as non-binding planning aid.

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Previous data sheet editions herewith lose their validity.