

SOLVEN-BORNE POLYURETHANE PAINT SYSTEM FOR EXTERIOR WINDOWS AND DOORS

Diccodur Primer **007 1580**
Dicco Flex 30 **752-serie**

Solvent -borne polyurethane system WP29 is elastic paint system for exterior wooden windows and doors. The system is suitable for solid wood windows and hdf-board doors. The system has excellent adhesion and water and humidity resistance.

Diccodur Primer is two-component polyurethane primer for interior and exterior applications. The primer has high solid content, good filling properties and good hiding power.

Dicco Flex 30 is two-component acid catalysed elastic top coat for exterior windows and doors. It is thixotropic easy to spray paint with good filling properties and excellent hiding power.

Typical paint system

Treatment	Product	Application method	Wet film thickness
Priming	1-2 x Diccodur Primer	Spraying	100–150 g/m ²
Top coat	1x Dicco Flex 30	Spraying	100–150 g/m ²

PRODUCT PROPERTIES

Solid Content	44 volume-%, 64 weight-%	(007 1580)
	55 volume-%, 69 weight-%	(752 7221)
Specific gravity	1,4 kg/l	(007 1580)
	1,3 kg/l	(752-s)
Paint hardener mixing ratio	007 1580 : 007 1255	100:20
	752-serie : 006 2098	100:10

Drying times

	100–120 /m ²	+23°C	+50°C
Diccodur Primer	Dry to sand	3–6 h	1–3 h
	Dry to stack	3–6 h	1–3 h
Dicco Flex 30	Dry to sand	24 h	3–4 hours
	Dry to stack	2–3 d	6–8 hours

Stacking temperature below +35°C.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Gloss	Semi-matt	(752 serie)
Colors	Temaspeed Premium tinting	(752 serie)
	White	(007 1580)
Application methods	Airless, air assisted airless and conventional spraying.	
Thinner	Diccodur Primer:	Thinner 1062
	Dicco Flex 30	Thinner 1033 (fast), 1027 (normal)
Cleaning of equipment	Thinner 1062, 1033, 1027	

SURFACE PREPARATION

Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150–240. All sanding dust must be removed before application.

APPLICATION CONDITIONS

During application and drying the temperature of the air, paint and surface should be at least +18°C. The relative humidity should not exceed 70%. Good ventilation is needed during drying process.

APPLICATION

Stir the Diccodur Primer well and add 20% by volume of hardener 007 1255 and mix well again. Thin the paint to the proper application viscosity with thinner 1062. Proper spraying viscosity is 20–30 sec (Din4).

Spray an even coat (wet film thickness about 100-150 g/m²) and let it dry about 3–6 h (in 20–30°C temperature) before sanding. Sand the surface carefully with paper grain size 320 or 400 and remove sanding dust before second application.

If needed apply a second even coat and let it dry about 3–6 hours (in 20–30°C temperature) and sand the surface again and remove sanding dust.

Stir the Dicco Flex 30 well and add 10% by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1033 or 1027. Proper spraying viscosity is 20-30 sec (Din4). Spray an even coat (wet film thickness about 100–150 g/m²) and let it dry about minimum 24 h (in 20–30°C temperature) before further processing.

The drying time depends of film thickness, temperature, relative humidity and the air ventilation.

The right nozzle size is 0,011–0,013" and angle 20 or 40 and the spraying distance from object about 20–25 cm.

MAINTENANCE PAINTING

Wash down the surface with Maalipesu and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Otex primer well and applicate it according the instructions of the paint. Let it dry and sand lightly. Stir Teho oil paint well and applicate according instructions of the paint and let it dry.

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