

PULODUR IMC 1055

Description

PULODUR IMC 1055 is a 2K polyurethane coating with a very high UV and light stability, high gloss level and excellent scratch resistance.

The IMC is sprayable.

After curing, a shiny, smooth surface is created.

Properties

- High UV and light stability
- High gloss level
- Scratch resistant
- Self release with metal moulds
- sprayable
- Good adhesion to epoxy and polyurethane resins
- Flexible

substrate

GRP tools as well as metal or aluminum molds. Heated and/or unheated.

Properties

Property	Unit	
Mix proportion <i>Gravimetric</i>		100 : 25 : 20 Resin : Hardener : Release
Gloss level <i>DIN 67530 and DIN EN ISO 2813</i>		shiny
Viscosity Dispensing time 30 - 50 sec., 4 mm dispensing cup	Sec	45-55
geltime at 20 °C	Min.	30
Density	g/ml	1,11
Solid	%	60
Consumption Theoretically, after hardener addition in delivery form, without application loss	g/m ²	100 – 200µ

Values determined at 20 °C

Components

- PULODUR IMC 1055, Comp. A
 - o Base resin
- PULODUR IMC 0939, Comp. B
 - o Hardener
- EFD Trennmittel / Release
 - o Internal release / diluted

Handling

Moulds: metal moulds or GRP moulds

Both components must be mixed homogeneously (e.g. high-speed mixers).

Repotting and remixing is recommended to avoid mixing errors.

Before and during mixing, it is essential to avoid contact with water and alcohols, even small quantities have an accelerating effect on the hardening process = shortening the processing time.

Spray – air pressure paint gun:

- in delivery form, undiluted
- Nozzle: 1.4 -1.8 mm
- Air pressure: 3 - 4 bar

Thickness:

- 1 x approx. 160-170g/m², thickness 50 µm

Pretreatment

Pretreat molds with a suitable release agent before initial application and after each cleaning.

Drying

Air drying at 20°C, film 50µm, 50% RFF

- **Dust-dry:** 15-20 min.
(Dry degree 1/ DIN 53150)
- **Thoroughly dried:** after 9 days
(Pendulum Damping/ ISO 1522)

Processing Temperature

- **Surface:** 30 to +100 °C
- **Product:** +10 to +25 °C

The application of 2-component products may only be carried out at a relative humidity of less than 85%.

The temperature of the substrate to be treated and the uncured material must be 3 °C above the dew point. See dew point table.

Cleaning of work equipment

Immediately with organic solvents, hardened residues can only be removed mechanically.

Information on occupational health and safety

The usual precautionary measures for ventilation and personal protection during processing must be observed when handling paints. More detailed information on hazardous substances, safety data and

recommendations for health and environmental protection can be found in the corresponding safety data sheet.

Test

All statements are based on standard climate 23/50 DIN 23270.

This information is based on our product knowledge and experience.

We have no influence on the application itself. We are at your disposal for more information.

The information in this data sheet is indicative and does not constitute a specification.

All results were produced on the basis of tests in the laboratory. We are not responsible for the parts manufactured with our product if the specified conditions of use are not met. It is imperative that the user ensures that his application and processes are suitable for the use of this product. We hereby declare the conformity of our products with the above specifications. We cannot be held responsible for any damage caused by the misuse or use of the product for an unsuitable application.