







Technical information (04/2021)

GRAVIHEL PUR TOPCOAT 402

- Two-component acrylic-isocyanate top coat; 3: 1 by volume
- High gloss
- A high-quality top coating with high
 - weather,
 - mechanical,
 - chemical and
 - UV protection.
- Suitable for the most demanding and long term exposures.
- In combination with corresponding primer it is suitable for exposure in aggressive industrial atmosphere.
- Can be applied directly onto galvanized sheet metal without a primer (402-003), however, we recommend a preliminary test of adhesion due to different zinc qualities.
- Filling in spray cans (2K pre-fill spray, index:302210)

	GRAVIHEL EPOXY PRIMER	GRAVIHEL PUR PRIMER	
SUBSTRATE PREPARATION	 P360 – P600	 P360 – P600	GRAVIHEL PUR WOOD PRIMER
	 GRAVIHEL Antisilicone cleaner	 GRAVIHEL Antisilicone cleaner	 P360 – P600
			Dust free

Typ of product: Acryl – isocyanate (polyurethane)
Appearance 402 – 001 DEEP MATT
 402 – 002 SEMI MATT /SATIN
 402 – 003 SEMI GLOSS - can be applied directly to galvanized sheet metal
 402 – 005 HIGH GLOSS

Delivery viscosity: 70 – 90 s
 DIN 53211 Φ 4 / 20°C

Density of component A: 1,068 – 1,149 kg/l

Solid content: By volume: 38%
By weight: 81%

VOC: **402 - 001**
402 - 002
2004/42/II B(e)(840)650
EU limit value VOC for this type of product (category II B (e)) in the form, which is ready for application is 840 g/l. VOC of this product, prepared for use is 650 g/l

402 - 003
2004/42/II B(e)(840)600
EU limit value VOC for this type of product (category II B (e)) in the form, which is ready for application is 840 g/l. VOC of this product, prepared for use is 600 g/l
IT IS ALSO USED TO RENOVATE INDUSTRIAL AND COMMERCIAL VEHICLES

402 - 005
VOC ready to use (g/l)= 550
USE ONLY IN INDUSTRIAL FACILITIES!







Theoretical yield: 7 - 8 m² /lit.

Temperature resistance (dry temperature) Short-term: up to 140 °C
Long-term: up to 80 °C

Processing temperature: +10°C till max. +40°C, max.Humidity 75%

Color shades: GRAVIHEL COLOR TOOLS

	Mixing ratio by Volume:	3:1 + 10 - 15% GRAVIHEL 2K PUR HARDENER SLOW GRAVIHEL 2K PUR THINNER SLOW 3:1 + 10 - 15% GRAVIHEL 2K PUR HARDENER GRAVIHEL 2K PUR THINNER 3:1 + 10 - 15% GRAVIHEL 2K PUR HARDENER FAST GRAVIHEL 2K PUR THINNER FAST
	Pot life of the mixture at 20°:	5 h
	Viscosity (RFU): DIN 53211 φ4 / 20°C	20 - 58 sec. (depending on the gloss)
	Application with spray gun:	1,3 mm 2 - 3 bar
	Number of layers: Film thickness:	2 50 μm

	Flash-off:	10 min. /20°C between coats																																																						
	Drying:	<table border="1"> <thead> <tr> <th>Object temperature</th> <th>at 20°C</th> <th>at 60°C</th> <th>at 20°C</th> <th>at 60°C</th> <th>at 20°C</th> <th>at 60°C</th> <th>at 20°C</th> <th>at 60°C</th> </tr> <tr> <td></td> <td colspan="2">402 – 001</td> <td colspan="2">402 – 002</td> <td colspan="2">402 – 003</td> <td colspan="2">402 - 005</td> </tr> </thead> <tbody> <tr> <td>Powder dry:</td> <td>10 min.</td> <td>-</td> <td>15 min.</td> <td>-</td> <td>20 min.</td> <td>-</td> <td>20 min.</td> <td>-</td> </tr> <tr> <td>Dry to touch:</td> <td>1 h</td> <td>-</td> <td>90 min.</td> <td>-</td> <td>100 min.</td> <td>-</td> <td>2 h</td> <td>-</td> </tr> <tr> <td>Dry to assembly:</td> <td>2 h</td> <td>30 min</td> <td>3 h</td> <td>30 min.</td> <td>4 h</td> <td>30 min.</td> <td>5 – 8h</td> <td>30 min.</td> </tr> <tr> <td>Through dry:</td> <td>5 h</td> <td>30 min</td> <td>5 h</td> <td>30 min.</td> <td>10h</td> <td>30 min.</td> <td>10 h</td> <td>30 min.</td> </tr> </tbody> </table>	Object temperature	at 20°C	at 60°C	at 20°C	at 60°C	at 20°C	at 60°C	at 20°C	at 60°C		402 – 001		402 – 002		402 – 003		402 - 005		Powder dry:	10 min.	-	15 min.	-	20 min.	-	20 min.	-	Dry to touch:	1 h	-	90 min.	-	100 min.	-	2 h	-	Dry to assembly:	2 h	30 min	3 h	30 min.	4 h	30 min.	5 – 8h	30 min.	Through dry:	5 h	30 min	5 h	30 min.	10h	30 min.	10 h	30 min.
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	Drying time (infra-red short-wave):	8 – 12 min. Distance to the object: 70 – 80 cm																																																						
	Application with Airmix:	0 - 10% (depending on the gloss) GRAVIHEL 2K PUR THINNER Nozzle: 0,23 – 0,33 mm Pressure: 80 - 150 bar Flash-off between coats: 5 - 10 min. /20°C (depending on the gloss)																																																						
	Brush application:	Thinner is not needed!																																																						
	Shelf life:	4 years																																																						

FOR PROFESSIONAL USE ONLY - See Safety Data Sheet

2K materials react with humidity; take care that all containers and tools are absolutely dry. While coating, the ambient relative humidity should not exceed 80%.

The data may vary under various conditions.,

Any part of this information may change at any time without notice.

The information was derived from years of experience in the collaboration of Development and Technical Services and is the property of HELIOS Refinish.

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