











Technical information (04/2021)

GRAVIHEL PUR 6:1 TOPCOAT 404

- Two-component acrylic-isocyanate top coat; 6:1 by volume
- Semi / High gloss
- A high-quality top coating with high
 - weather,
 - mechanical,
 - chemical and
 - UV protection.
- Suitable for the 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, 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 Antisilicone cleaner	GRAVIHEL PUR WOOD PRIMER
	 GRAVIHEL Antisilicone cleaner	 GRAVIHEL Antisilicone cleaner	 P220 – P280	 P360 – P600
			 GRAVIHEL Antisilicone cleaner	Dust free

Typ of product: Acryl – isocyanate (polyurethane)
Appearance 404 – 003 SEMI GLOSS
 404 – 005 HIGH GLOSS

Delivery viscosity: Thixotropic
 DIN 53211 Φ4 / 20°C

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Density of component A: 1,213 – 1,36 kg/l

Solid content: By volume: 31%
By weight: 83%

VOC: **404 – 003**
2004/42/IIIB(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

404 – 005
VOC ready to use (g/l)= 560










USE ONLY IN INDUSTRIAL FACILITIES!






Theoretical yield: 5 - 6 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:	 6:1 + 20 - 25% GRAVIHEL 2K PUR HARDENER SLOW GRAVIHEL 2K PUR THINNER SLOW  6:1 + 20 - 25% GRAVIHEL 2K PUR HARDENER GRAVIHEL 2K PUR THINNER  6:1 + 20 - 25% 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	27 - 31 sec.
	Application with spray gun:	1,3 mm 2 – 3 bar
	Number of layers: Film thickness:	2 60 μm
	Flash-off:	10 min. /20°C between coats

	Drying time:	Object temperature <table border="0"> <tr> <td></td> <td>at 20°C</td> <td>at 60°C</td> </tr> <tr> <td>Powder dry:</td> <td>30 min.</td> <td>-</td> </tr> <tr> <td>Dry to touch:</td> <td>2 h</td> <td>-</td> </tr> <tr> <td>Dry to assembly:</td> <td>8-10 h</td> <td>30 min.+ 20 min./20°C</td> </tr> <tr> <td>Through dry:</td> <td>10 - 12 h</td> <td>30 min.+ 30 min./20°C</td> </tr> </table>		at 20°C	at 60°C	Powder dry:	30 min.	-	Dry to touch:	2 h	-	Dry to assembly:	8-10 h	30 min.+ 20 min./20°C	Through dry:	10 - 12 h	30 min.+ 30 min./20°C
	at 20°C	at 60°C															
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Through dry:	10 - 12 h	30 min.+ 30 min./20°C															
	Drying time (infra-red short-wave):	8 – 12 min. Distance to the object: 70 – 80 cm															
	Application with Airmix:	0 - 5% GRAVIHEL 2K PUR THINNER Nozzle: 0,23 – 0,33 mm Pressure: 90 - 150 bar Flash-off between coats: 10 min. /20°C															
	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.

We guarantee that the quality of work carried out according to our instructions delivers results while we disclaim any liability if any other products were used or if other factors influenced the final appearance.

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