





Technical information (04/2021)

GRAVIHEL PUR HS TOPCOAT 450

- Two-component acrylic-isocyanate top coat; 3:1 by volume.
- A high-quality top coating with high weather, mechanical, chemical and UV protection, suitable for the most demanding exposure conditions (commercial vehicles, rail vehicles, vans, etc.).
- VOC compliant

	GRAVIHEL EPOXY PRIMER	GRAVIHEL PUR PRIMER
SUBSTRATE PREPARATION	 P360 – P600	 P360 – P600
	 GRAVIHEL Antisilicone cleaner	 GRAVIHEL Antisilicone cleaner

Typ of product: Acryl – isocyanate (polyurethane)
Appearance 450 – 001 DEEP MATT
 450 – 005 HIGH GLOSS

Delivery viscosity: 45 – 55 s
 DIN 53211 Φ 4 / 20°C

Density of component A: 1,028 – 1,118 kg/l

Solid content: By volume: 51%
 By weight: 73%

VOC: **450 – 001 DEEP MATT**
 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

450 – 005 HIGH GLOSS
 2004/42/II B(d)(420)419
 EU limit value VOC for this type of product (category II B (d)) in the form, which is ready for application is 420 g/l. VOC of this product, prepared for use is 419 g/l

IT IS ALSO USED TO RENOVATE INDUSTRIAL AND COMMERCIAL VEHICLES











Theoretical yield: 10 - 11 m² /lit.

Temperature resistance Short-term: up to 140 °C

(dry temperature) 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:	450 – 005: 3:1+ 10-15% 450 – 001: 5:1 + 5 – 10%																														
		GRAVIHEL 2K PUR HS HARDENER GRAVIHEL 2K PUR THINNER																														
	Pot life of the mixture at 20°:	2 h																														
	Viscosity (RFU): DIN 53211 Φ4 / 20°C	21 - 27 sec. (depending on the gloss)																														
	Application with spray gun:	1,3 mm 2 – 3 bar																														
	Number of layers: Film thickness:	1,5 40 - 60 μm																														
	Flash-off:	10 min. /20°C between coats																														
	Drying time:	<table border="0"> <tr> <td>Object temperature</td> <td>at 20°C</td> <td>at 60°C</td> <td>at 20°C</td> <td>at 60°C</td> </tr> <tr> <td></td> <td>450 – 001</td> <td></td> <td>450 – 005</td> <td></td> </tr> <tr> <td>Powder dry:</td> <td>20 min.</td> <td>-</td> <td>2 h</td> <td>-</td> </tr> <tr> <td>Dry to touch:</td> <td>3 h</td> <td>-</td> <td>5 h</td> <td>-</td> </tr> <tr> <td>Dry to assembly:</td> <td>5 h</td> <td>30 min.+ 20 min./20°C</td> <td>8-10h</td> <td>30 min.+ 1h/20°C</td> </tr> <tr> <td>Through dry:</td> <td>10 - 12 h</td> <td>30 min.+ 3h/20°C</td> <td>12 – 14 h</td> <td>30 min.+ 1h/20°C</td> </tr> </table>	Object temperature	at 20°C	at 60°C	at 20°C	at 60°C		450 – 001		450 – 005		Powder dry:	20 min.	-	2 h	-	Dry to touch:	3 h	-	5 h	-	Dry to assembly:	5 h	30 min.+ 20 min./20°C	8-10h	30 min.+ 1h/20°C	Through dry:	10 - 12 h	30 min.+ 3h/20°C	12 – 14 h	30 min.+ 1h/20°C
Object temperature	at 20°C	at 60°C	at 20°C	at 60°C																												
	450 – 001		450 – 005																													
Powder dry:	20 min.	-	2 h	-																												
Dry to touch:	3 h	-	5 h	-																												
Dry to assembly:	5 h	30 min.+ 20 min./20°C	8-10h	30 min.+ 1h/20°C																												
Through dry:	10 - 12 h	30 min.+ 3h/20°C	12 – 14 h	30 min.+ 1h/20°C																												
	Drying time (infra-red short-wave):	10 - 15 min. Distance to the object: 70 – 80 cm																														
	Application with Airmix:	0 - 5% GRAVIHEL 2K PUR THINNER Nozzle: 0,18 – 0,23 mm Pressure: 60 - 120 bar Flash-off between coats: 10 min. /20°C																														
	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%.

GRAVI HEL

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.

The latest version of TDS supersedes all previous versions. You can obtain the latest version from general distributor in your country.