

## Technical Data Sheet



# [Z] ZowoPlast® 2450

## One Component PUR Coating

### Product Description

Product Type

Waterbased, single component, NMP-, NEP- and TAE free, non hazardous "green" top coat for single-layer coating, designed for excellent weathering and mechanical stability and a smooth surface.

Area of Application

Profiles / elements for windows, doors / building parts made from PVCu and further plastic parts\* for interior and exterior use.

### Technical Data

Base of Binder

Polyurethane

Pigments

Titanium dioxide and organic and inorganic colored pigments

Color

RAL colors, special colors based on [Z] ZowoPlast® 2450 Basis C

Gloss Level

Silk gloss or matt

Density

Ca. 1,04 g/ml

Viscosity

Thixotropic setting

### Processing Instructions

Substrate pretreatment

Apply [Z] ZowoPlast® 1120 Hydro-Cleaner evenly on the surface to be cleaned, eg with a pump spray bottle. Cleaning is carried out using a fine sanding sponge (ca. grit 150). The mild, wet-abrasive cleaning provides mechanical reinforcement of the cleaning effect. We recommend to replace the sanding sponge after about 80 linear meters of window profile, so as not to spread removed grease and dirt residue on the surface. Dry surface after cleaning with a clean, lint-free cloth or pad, in order to remove impurities, which were solved by the cleaner, safely from the surface.

As alternative to the optimized wet sanding process, there are two-step cleaning processes recommended which involves a dry grinding. The surface is grinded with a sanding sponge / -pad of grit 150, abrasive paper 280-320 grit, scotch brites\* or the corresponding grinding brushes. Afterwards the surface is cleaned from sanding dust and activated for coating by means of [Z] ZowoPlast® 1120 or acetone.

\*If scotch brites are used, abrasion process must be followed by acetone wipe.

If required, the surface has to be first pretreated with [Z] ZowoPlast® 1120 or Acetone to remove coarse contaminations before starting sanding.

Individual and customized pre-treatment methods must be agreed with the Application Engineering services of [Z] Zobel Coating Systems.

Generally Information for substrate pretreatment

After the cleaning process, on parts to be coated must be a dry, slightly sanded and matt surface visible. Otherwise paint adhesion can be negatively influenced.

Protect cleaned substrates against fresh contamination (for example dust, silicone on fingers when handling the substrate).

Start coating within 30 minutes after finishing the cleaning process in order to avoid formation of new dust, utilizing the [Z] ZowoPlast® 1120 Hydro-Cleaner's antistatic effect and adhesion promotion of the subsequent [Z] ZowoPlast® coating.

Because of the large variety of substrates on offer, compatibility with cleaner and adhesion of [Z] ZowoPlast® coating always have to be checked individually.

\*[Z] ZowoPlast® 2450 may also be suitable for the coating of plastic substrates other than PVCu. In this case, an adaption of the pre-treatment method might be required. The adhesion and durability characteristics of the composite formed by coating and substrate must be tested individually and must be agreed with the Application Engineering services of [Z] Zobel Coating Systems.

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### Application Method

Spraying, Vakumat

Spraying process	Nozzle [mm]	Pressure [bar]	Atomiser [bar]
Airmix	0,21-0,28	50-80	1,0-2,0
Pressurized cup gun	1,3-2,0	1,5-2,5	./.
Flow cup gun	1,8-2,2	1,5-3,0	./.

### Processing Viscosity Processing Conditions

Can be sprayed up to a wet-film thickness of 175µm\*, recommended wet-film thickness ca. 125µm. Please observe Zobel's steps of coating! Perform a test coating. Check color before use. Subsequent claims cannot be considered.

\*Depending on color and processing conditions, the maximum wet-film thickness may be less in individual cases.

Ready to use. If necessary, can be thinned with max. 5% water

- Substrate must be dry, and free of dust and grease
- Ca. 20 °C for substrate, material und environment, ca. 50% relative air humidity
- Do not process below 18 °C or more than 30 °C
- Stir material well before use; avoid the inclusion of air

### Product Consumption Drying Time (20 °C / 50% relative air humidity)

Ca. 125 ml/m<sup>2</sup> at a wet-film thickness of 125µm (without overspray)

Dust dry after 30 min., can be further processed / stacked after drying over night (at 125µm wet-film thickness). Maximum adhesion and hardness is reached in 7 days at ambient temperatures.

Drying time depends on applied quantity and ambient conditions. Low temperature and high humidity retard drying. Always ensure adequate temperature and air exchange.

### Cleaning of the tools

Immediately after use with water or Zowo-Clean Hydro Cleaner

### Additional Information

#### Minimum Shelf-Life

12 months cool but free of frost in the closed original packaging

#### Compatibility

The compatibility of materials coming into contact with the coating (sealants, tapes, etc.) must be checked by the processor. While Acetone is an excellent cleaner for preparing the surface prior to coating, do not bring Acetone in contact with the coated surface.

#### Safety Instructions

Always read label and product information before use. Please observe the usual precautions during processing and storage. For safety-relevant data and instructions on disposal refer to the Material Safety Data Sheet.