

Turco 2-K maskant

TURCO FORM MASK 6914 G/TURCO FORM MASK 6915

Description

TURCO 2-K MASKANT is a 100% solid, two component, polyurethane based, air curing, hand peelable coating that provides protection to metallic surfaces during mechanical fabrication and chemical processing.

Due to its advanced chemistry, TURCO 2-K MASKANT's rapid cure allows the user to process coated parts much faster than with conventional maskants, both water and solvent based.

Component A	Turco Form Mask 6914 G	
Component B	Turco Form Mask 6915	
Group	Polyurethane spray elastomers	
Application	Temporary protective coating for metal surfaces	
Appearance	Component A	Green very viscous liquid
	Component B	Clear yellow to brown viscous liquid

Characteristics

Advised film thickness:		300-350µm
Material needed to coat 1m ² with film thickness of 300µm:		0,3 kg A+B
Solids content:		100 %
Curing time before scribing/peeling:		60 min
Curing time before etching:		90 min
Mixing ratio (A:B):	by mass	100:83
	by volume	100:70
Spraying temperature:	Component A	90°C

Component B

75°C

Spraying pressure:

200±30 bar

Chemical-Physical properties

Property	Unit	Methode	Polyol (A)	Isocyanat (B)
Specific Gravity	Kg/m ³	KDIA07/B05	935	1115
Viscosity	MPa.s	KDIA08/B03	6000	800
Amine-value	Mg KOH(g) ⁻¹	KDIA04	52	
NCO-value	% NCO	KDIB01		15

System parameters at 23°C (typical value)

Property	Unit	Methode	Minimum	Maximum
Tack-free time	s	KDIV01	16	20

Physical-Mechanical Properties

(Measured on samples prepared under laboratory conditions)

Property	Unit	Methode	Average
Film thickness	µm		300-350
Tensile strength		Din 53504	
- Elongation	%		237
-Tension at 25% elongation	N(mm) ⁻²		2,5
-Tension at 50% elongation	N(mm) ⁻²		3,7
-Tension at 100% elongation	N(mm) ⁻²		5,3
-Tension maximal	N(mm) ⁻²		11,2
Hardness(0-10s, 23°C, Thick 6mm)	Shore A	DIN 53504	78
Tear strength (angle with nick)	N(mm) ⁻¹	DIN 53515	14
Tear strength (angle without nick)	N(mm) ⁻¹	DIN 53515	27

Using instructions

Surface pre-treatment

Surface pre-treatment can be done with a two or three step process.

The two-step process consists of alkaline degreasing and deoxidising.

With a three step process an alkaline etch is used between degreasing and deoxidising.

Application

The product must never be sprayed with standard one or two component equipment. Henkel has developed together with Gusmer a special machine for spraying this two-component coating. This machine is called a Gusmer VR-A unit and must be used together with a GAP micro spray gun. This special equipment is only available through Henkel.

When a film thickness of 300-350µm is applied the coating can be scribed/peeled after 60 minutes. Both manually and laser scribing can be used on the applied coating. The coated substrate can be etched 90 minutes after application, using both type I and II etchants.

Storage conditions

The material should be stored in adequately ventilated premises. The preferred storage conditions are: temperature 21±2°C and out of direct sunlight and rain.

In those cases where the product has been exposed to extreme weather conditions or variations such as freezing or temperatures over 40°C for longer period of time, the physical and chemical properties may have suffered.

Disposal information

Refer to your Turco Material Safety Data Sheet for disposal information.

Note

Before using this product refer to container label and Turco Material Safety Data Sheet for precautionary handling and first aid information.