

2K Test Report

Manufacturer / Material

Test performed by:	H. Mann, R. Jansen, Mr. Vitelli, Mr. Soleo		Date: 21.11.2006
Person in charge at manufacturer	Mr. Vitelli, Mr. Soleo, phone: 0039/69281746		
Base Component A	Mirodur RV 9030	Batch-Nr.	
Hardener(Comp.B)	Mirodur RV 9031	Batch-Nr.	
Thinner	RV 9032	Batch-Nr.	
Temperature (°C)	Temp.of material: 20°C Ambient temp.:20°C		
After heating (in return line):	Comp.A: 61°C	Comp. B: 63°C	
Fillers			
Viscosity	A: high	B: medium	
Potlife (sec/min/h)	15 minutes	at temperature (°C): 60°C	
Description of Material	A: red	B: grey (EP)	
Prescribed Mixing Ratio by volume	2,5 : 1		
Field of application	Coating of tube interiors		

Equipment Specification

Recommended Model	Duomix 333		
Pressure ratio/volume mixing ratio	67:1		
Output (cm ³ /cycle)Material Pump	322cm ³ /DH	A:2 x 115,1	B: 1 x 92
High pressure filter insert (mesh)	Comp. A: 70	Comp. B: 50	
Low pressure heater:Amount/Temp (°C)	Comp. A:1 Temp:85°C	Comp. B: 1	Temp: 85°C
High pressure heater:Amount/Temp (°C)	Comp. A:1 Temp:85°C	Comp. B: 1	Temp: 85°C

Material supply, Comp. A			
Feed pump, Comp. A	375.05		
Material supply, Comp. B			
Feed pump, Comp. B	150.05		
Suction strainer M (mesh)	Comp.A: Dirt collector Comp.B: Dirt collector		

Mixer on frame / External mixer	External mixer		
Static mixer (size)	Size 0		
Hose package consisting of:	electr./water heated		
Material hose, Comp.A (Length / Size)			Temp.:
Material hose, Comp.B (Length / Size)			Temp.:
Spray hose (Length / Size)	7,5m 1/4" isolated		
Spray gun	WIWA 500F		
Reversible tip			
Spray tip (Size) / (Angle)	Spraying Systems 617		

Test Result

Air inlet pressure (bar)			
Stall pressure (bar) (Comp.A/ Comp.B)	Unit: 240	Spray tip: 240	
Spray pressure (bar) (Comp. A/Comp.B)	Unit: 200	Spray tip: 200	
Temperature at Spray Tip (°C)	60°C		
Evaluation of spray pattern	very good		
Film thickness (µm/mm/cm)	75µm, closed film on glas		
General impression	very good		

Notes:	for coating robots automatically electrical heated hose package and 2 - 4 tips		
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