

RoCryl HS Marine

Technical Information

Characteristics: Premium-quality, fast drying two-component clearcoat based on polyacrylate resin with excellent light fastness and filling power as well as high solid content.
A perfect result can only be achieved by carrying out the following instructions.

Area of application: For high-quality and resistant coatings of woods used in ship interior finishing.
RoCryl HS Marine creates high-build, closed-pored surfaces.

Substrates: Perfectly dry, clean and resin-free wood and, in case of stained wood, dry and clean surfaces. The substrate must be sound.

Hardener: **DuoCryl Härter**

Mixing ratio: 2 unit lacquer: 1 unit hardener
+ 10 % **DD-Verdünnung Nr. 25**

Pot life: 2 hours at 20°C/65% relative air humidity.
Attention: The viscosity can increase when exceeding the pot life. This may cause surface defects. Higher temperatures of material and ambience reduce the pot life.

Processing: **RoCryl HS Marine** is applied by spraying (gravity spray gun, Airless, Airmix).

Application:	Airless	Airmix	gravity spray gun
Spray pressure:	120 - 150 bar	60 - 80 bar	----
Air pressure:	----	1.5 – 2.0 bar	2.5 – 3.5 bar
Nozzle size:	0.22 – 0.28 mm	0.22 – 0.28 mm	1.3 – 1.5 mm
Spray viscosity:	approx. 17 - 25 s/4 mm	approx. 17 - 25 s/4 mm	approx. 17 - 25 s/4 mm

Depending on the spray gun in use, deviations concerning spray pressure, air pressure and nozzle size may occur. In case of application by Airmix-/ Airless-devices, it is recommended to check the selected device type for its suitability. The temperature for application should not fall below +18°C. This also applies to the substrate. Protect recently painted surfaces from dust, spray mist and draught. Not suitable for rolling, brushing and flow application.

Thinner: Use the thinner **DD-Verdünnung Nr. 25** to retard the drying.
In order to achieve high-gloss surfaces we recommend using solely **DD-Verdünnung Nr. 25**. Possible quantity of thinner to add: 40%.

Spreading rate: Applied quantity: Approx. 100-110 ml/m²; max. quantity to apply wet on wet 2x 120 g/m²;
max. weight of dried layer: 120 g/m²
Approx. 9-10 m²/l per layer (depending on the absorptivity of the wood and the application method)

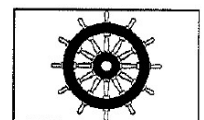
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- Drying time:** Depending on the application method and the applied quantity at room temperature (20°C/65% relative air humidity):
- dust dry after approx. 10 minutes
 - set to touch after approx. 2 hours
 - sandable and recoatable after approx. 3 hours
 - polishable after approx. 16 hours
- Gloss level:** high gloss, 45 = matt
- Primer and topcoat:** **RoCryl HS Marine** can be used as primer as well as topcoat.
- Cleaning of tools:** **Waschlöser Nr. 52** and **PUG Pinsel- u. Gerätereiniger**.
- Storage:** In original unopened containers, **RoCryl HS Marine** is storable for 3 years, the hardener for 2 years.
- Special remarks:** Even if surfaces treated with **RoCryl HS Marine** are dry and stackable after a short time, the required chemical and mechanical resistance is only achieved after a curing time of 5-7 days (20°C/65% relative air humidity).
- For an application as decopaint, use **RoCryl HS Marine** with the hardener **DuoCryl Härter** and the thinner **DD-Verdünnung Nr. 25** (quantity to add 10%).
(cat. A/j: 500 g/l; VOC content of ready-to-use product < 500 g/l).
- Tested according to:
DIN 68861-1 (behaviour at chemical influence): Stress group: **1B**
- RoCryl HS Marine is a Marine coatings of low flammability** according to *SOLAS 74/88 Reg. II-2/3, II-2/5, II-2/6 and II-2/9, latest edition*, according to *IMO MSC.36(63)-(1994 HSC-Code) 7, IMO MSC.97(73)-(2000 HSC-Code) 7, IMO MSC/circ. 1120*.
- EC-Type Examination Certificate: approval no. 116430-02**
- U.S. Coast Guard approval no. 164.112/EC0736/116430-02**
- Important:** **RoCryl HS Marine** can be combined only with other approved and technically suitable products!
The product is sold in accordance to the marine equipment list 2014/90/EU.
- Risk assessment:** The standards applicable to the product **RoCryl HS Marine** (including FTP-Code, Directive 2014/90/EU, Implementing Regulation (EC) 2022/1157, SOLAS 74/88 in particular regulation II-2/3, II-2/5, II-2/6, IMO-Resolution MSC.36(63)-(1994 HSC-Code) 7, IMO-Resolution MSC.97(73)-(2000 HSC-Code) 7, IMO MSC/circular 1120) contain all risks predictable for us.



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Please consider:

The product and the recommendations in this technical data sheet correspond to today's state of the art. Our oral and written application recommendations, that are based on years of experience and provided to the best of knowledge, are non-committal and do not establish a contractual relationship and secondary obligation of the sales contract. They do not release the user from his obligation to verify on his own responsibility the existing substrate and the suitability of our products for the intended purpose. In case of doubt, suitability and spreading rate are to be tested by creating a sample. If our products are combined or intermixed with third-party products we cannot guarantee a perfect surface finish. Our general terms and conditions apply.

The certificate of conformity for this product is supplied with the product. In addition, it is possible to request at any time a copy at Mipa SE, Am Oberen Moos 1, 84051 Essenbach/ Germany or by e-mail to mipa@mipa-paints.com.

This technical data sheet replaces all previous versions.

Edited 01/24