1. Area of application and purpose

This standard applies for Bühler Alzenau as well as all suppliers.

The lacquer of this standard is used for the internal coating of Bühler Alzenau vacuum chambers and containers and their internals. The standard provides technical information on the properties, technical data and processing of the coating.

For coating of surfaces outside the vacuum chamber, the factory standard LHH-N 120.010 is valid.

2. Properties

The CETELON D/D topcoat is a 2-component coating of class 200 and is used as a resistant coating for heavy-duty machinery and equipment. The coating has good resistance properties against damp influences and is highly weather-resistant.

It is highly resistant to high concentrations of acids and alkalis, as well as oils and greases. The lacquer is also very hard, has a smooth surface and is scratch-resistant. The lacquer is also food safe.

3. Technical Data

Basis	Polyurethane isocyanate	
Color	RAL 9002 grey-white, glossy	
Long-term thermal resistance	max. 130°C	
Solid state	approx. 60 weight %	DIN EN ISO 3251
Thickness	approx. 1,1 - 1,2 g/cm3 at 20°C	DIN EN ISO 2811
Delivery viscosity	70 s	
Flashpoint	above 21°C	DIN EN ISO 1523
symbol according to working	A II	DIN EN ISO 1516
substance	not applicable	
Shelf life	6 months	
Manufacturer	CETELON Lackfabrik Boschstraße 1 71254 Ditzingen	

4. Application

The surface should be free of dirt, rust and grease and absolutely dry. Cetelon D/D lacquer is sensitive to water in any form and humidity. This must also be taken into account when storing the lacquer.

Keep tools and spray air dry.

It can be applied by rolling, brushing, spraying or flooding.

Mixing ratio lacquer : hardener	10 : 3 weight proportion
Spray viscosity	17 - 22s, DIN cup 4mm - 20°C
Thinner additive	max. 10%
Drops time	4 - 6 h at 20°C
Work tools	Spray gun e.g. SATA GR/Z or SATA jet
Spray pressure	3-5 bar
Spray nozzle	1,5 mm
Spray application	1,5 to 2 cross coats
Spray distance	approx. 30 cm
Dry layer thickness	30-40 µm
Air curing • **dust dry** • **touch dry** • **completely dry**	 1 h 8 h 24 h
Oven drying • **airing time** • **fully dried**	 20 min 40 min/80°C
Consumption at 40 µm layer thickness	approx. 5 m^2/kg
chemical and physical resilience	after 7 days

5. Vacuum Data

Outgasing of a painted surface	1- 2 x 10^{-6} mbar x l x s^{-1} x cm^{-2}
Pumping time	1 h

6. Description

	Model no.	Item no.	Pack size
Basic lacquer	254/009 002/00	LOAT-11364-001	25 kg
Hardener	065/000 133/00	LOAT-11365-001	10 kg
Thinner	001/000 111/00	LOAT-90165-001	10

7. Information in design documents

The parts or part surfaces to be painted must be marked according to the surface symbols.

Specification: