Incorez
A SIKA COMPANY

Guide Formulations

1K Waterbased PU/Acrylic PVC Coating

Ref: Dispurez CS8108-049

Materials		Supplier	Parts by Weight
PU-Acrylic Hybrid	**Incorez CS8108**	**Incorez**	91.73
Solvent	Dowanol DPnB	DOW	5.21
Substrate Wetting Agent	BYK 348	BYK	0.33
In-can preservative	Mergal K14	Troy	0.08
Anti-blocking agent	LUBA - Print 138/E	Munzing	0.45
UV absorber	Tinuvin 292	BASF	0.26
UV stabiliser	Tinuvin 9945-DW(N)	BASF	0.26
Wetting and dispersing additive	TEGO Dispers 747 W	Evonik	1.14
PU thickener	Rheovis PU1214	BASF	0.25
Co-Solvent	Butyl Diglycol (BdG)	Local	0.28
			100

Manufacturing Instructions

- In a clear dry vessel add Incorez CS8108.
- Add BYK348 (Substrate wetting Agent) and mix for 5 minutes.
- Add slowly the Dowanol DPnB (Solvent) and mix for 5 minutes.
- Add Mergal K14 (In-can preservative) and mix for 5 minutes.
- Add LUBA-print 138/E (Anti-Blocking Agent) and mix for 5 minutes.
- Add Tinuvin 292 and Tinuvin 9945W one after another and allow to mix for 5 minutes.
- Add Tego Disperse 747W (Dispersing Additive) and mix for 5 minutes.
- Premix Rheovis PU1214 (PU Thickener) with Butyl Diglycol. Ensure the premix is evenly mixed before proceeding.
- Add the premix into the above mixture.
- Stir slowly for a further 30 minutes before filling off.

Properties

% Solids	60.08%
Specific Gravity (g/ml)	1.04
pH	8.43
Viscosity (cps)	405

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