

TECHNICAL DATASHEET

**7-538, 7-539
DIRECT TO METAL - GLOSS TOPCOATS**

PRODUCT DESCRIPTION

Selemix Direct Gloss are polyurethane coatings based on a PU 2K technology to be applied direct on substrates giving gloss levels of approximately 80 to 85% @60°.

The product characteristics are:

- One layer system.
- High thickness: up to 160µm wet film.
- Can be sprayed with airless , air assisted airless ,conventional , or HVLP methods
- Good adhesion on various substrates like bare steel , aluminium , galvanised steel, fibre reinforced plastic
- High coverage due to highly concentrated pigment pastes.

Selemix Direct is VOC compliant when using the HS Hardener 9-075 in airless and air assisted airless modes.

(VOC content of ready for use product lower than 420 G/L).

PRODUCTS

2 Binders :

For white and pastel colours:

7-539 Direct Binder GL 80% Light colours

For other colours:

7-538 Direct Binder GL 80%

Note: Gloss levels quoted are within +/- 5% depending upon colour

17 Selemix Tinters

3 Hardeners :

9-070 Direct Hardener

9-080 Acrylic Hardener

9-075 HS Direct Hardener

2 Thinners :

1-480 Direct Thinner

1-470 Extra Slow Thinner

1 Additive :

6-550 Direct Accelerator

1 Accelerated Thinner

1-490 Accelerated direct thinner

SELECTION AND PREPARATION OF SUBSTRATES



Substrate

Cast Iron
Bare steel
Phosphated steel
Galvanized steel
Light alloys
Aluminium
Fiber reinforced plastic

Sand


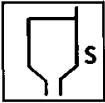


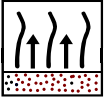
P80-120 (dry)
P80-120(dry) or shot blast
Scotch brite
Scotch brite
P280-320 (dry)
P280-320 (dry)
P240 (dry)

Degrease

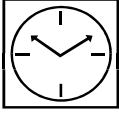
All surfaces should be thoroughly degreased using the appropriate cleaner



APPLICATION GUIDE USING 9-070 or 9-080 HARDENERS

		White and pastel colours		Other Colours			
Tinting Ratio		Binder: 95		Binder: 85			
By weight :		Tinters: 5		Tinters: 15			
		AIRLESS	AIR ASSISTED AIRLESS	CONVENTIONAL			
	Mixing ratio:		Volume Weight	Volume Weight			
		Mixed col.	4 vol.	1000	Mixed col.	4 vol.	1000
		9-070/9-080	1 vol.	200	9-070/9-080	1 vol.	200
		1-xxx**	1 vol	200	1-xxx**	1,2-1,5 vol	200-250
Notes:							
<i>9-080 hardener is recommended for Air drying overnight.</i>							
<i>Thinner – 1-480 Direct PUR Thinner can be used for application temperatures below 25°C.</i>							
<i>1-470 Extra Slow thinner is recommended for application temperatures above 25°C.</i>							
<i>Stir in Hardener after addition before adding thinner and then stir again.</i>							
	Spray viscosity:	25-30 sec DIN 4 at 20°C		20 -25 sec DIN 4 at 20°C			
	Pot life at 20°C:	2-3 hours		3 hours			
	Spray gun set up:	11-13 thou tips		Nozzle =1,8 mm			
	Spray pressure:	100-140 bar	70-100 bar	Standard 3-4 bar HVLP 2 bar Air cap pressure: 2 – 2.5			
	Number of coats:	1 - 2		2 - 3			
	Flash off between coats	15-20 minutes		15-20 minutes			
Total dry film build :	80-100µm		80-100µm				
	Higher thickness can be achieved with additional coats This may extend the drying time						

APPLICATION GUIDE USING 9-070 or 9-080 HARDENERS



**Drying times at
20°C :**

dust free :

1 hour

1 hour

tack free :

1,5- 2 hours

2 hours

hard dry

24 hours

24 hours

stoving :

45mn at 60°C
(metal temperature)

45mn at 60°C
(metal temperature)



Recoatability:


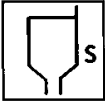


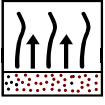
Selemix Direct Topcoats can be overcoated without sanding, with themselves 10 days after drying and up to 5 months after drying. It is extremely important that the surface is thoroughly cleaned before overcoating.



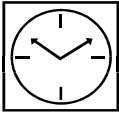
Colour:

Check colour and gloss before use

APPLICATION GUIDE USING 9-075 HARDENER

		White and pastel colours		Other Colours		
Tinting Ratio		Binder: 95		Binder: 85		
By weight :		Tinters: 5		Tinters: 15		
		AIRLESS	AIR ASSISTED AIRLESS	CONVENTIONAL		
	Mixing ratio:		Volume	Weight		
		Mixed col.	6 vol.	1000	Mixed col.	6 vol.
		9-075	1 vol.	130	9-075	1 vol.
		1-xxx**	0,7 vol.	100	1-xxx**	1,5
			Weight		Weight	
					1000	
					130	
					250	
Notes:						
<i>Thinner – 1-480 Direct PUR Thinner can be used for application temperatures below 25°C.</i>						
<i>1-470 Extra Slow thinner is recommended for application temperatures above 25°C.</i>						
<i>Stir in Hardener after addition before adding thinner and then stir again.</i>						
	Spray viscosity:	25- 35 sec DIN 4 at 20°C		20 - 25 sec DIN 4 at 20°C		
		2-3 hours *		2-3 hours *		
	Spray gun set up:	11-13 thou tips		Nozzle =1,8 mm		
		Spray pressure:	100-140 bar	70-100 bar	Standard	3-4 bar
			HVLP	2 bar		
			Air cap pressure: 2 – 2.5			
	Number of coats:	1 - 2		2		
		15-20 minutes		15-20 minutes		
	Flash off between coats	15-20 minutes		15-20 minutes		
		Total dry film build :	80-100µm		80-100µm	
Higher thickness can be achieved with additional coats						
This may extend the drying time						

APPLICATION GUIDE USING 9-075 HARDENER



Drying times at 20°C :

dust free :	1 hour	1 hour
tack free :	1,5 hours	1,5 hours
hard dry	16 hours	16 hours
stoving :	45mn at 60°C (metal temperature)	45mn at 60°C (metal temperature)



Recoatibility: Selemix Direct Topcoats can be overcoated without sanding, with themselves 10 days after drying and up to 5 months after drying. It is extremely important that the surface is thoroughly cleaned before overcoating.



Colour: Check colour and gloss before use

Use of Accelerator: 2% of 6-550, Accelerator for Direct to Metal topcoats, can be added, to the mixed topcoat, to achieve faster drying at temperatures below 20°C. 6-550 will reduce potlife to less than 1 hour and could decrease gloss.

1-490 Accelerated thinner can replace 1-480 Direct thinner to achieve faster drying at temperatures below 20°C or speed up process time. 1-490 will reduce potlife to less than 1 hour and could decrease gloss.

TECHNICAL DATA (using 9-070 or 9-080 HARDENERS)

	AIRLESS & AIR ASSISTED AIR LESS	CONVENTIONAL
VOC :	490-500 g/L ready for use	500-510 g/L ready for use
Solid content by weight (RFU):	64-66%	61-63%
Solid content by volume (RFU):	43-46%	40-44%
Theoretical coverage in m²/ Lt of ready to spray product	5.6 m ² /L dry film thickness:80µm	5.2 m ² /L dry film thickness:80µm

VOC EU REGULATIONS

The EU limit value for this product when used with 9-070 or 9-080 hardeners (product category: IIA(j)) ready to use form is max. 550 g/l of VOC (from 1/1/2007) and 500 gr/l of VOC (from 1/1/2010).

The VOC content of this product in ready to use form is max. 500 g/l except for conventional applications where VOC content is max 550 g/l.

The EU limit value for this product when used with 9-075 hardener (product category: IIA(j)) ready to use form is max. 550 g/l of VOC (from 1/1/2007) and 500 gr/l of VOC (from 1/1/2010).

The VOC content of this product in ready to use form is max. 500 g/l except for conventional applications where VOC content is max 550 g/l.

HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and Product can labels.

These products are for professional painting only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet

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