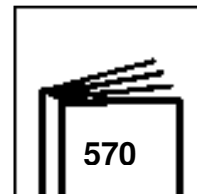




TECHNICAL DATASHEET



7-530, 7-531, 7-532, 7-533 7-534, 7-535, 7-536, 7-537 DIRECT TOPCOATS

PRODUCT DESCRIPTION

Selemix Direct is a polyurethane coating based on a PU 2K technology to be applied direct on substrates.

The product characteristics are:

- One layer system.
- High thickness: up to 300µm wet film.
- Can be sprayed with airless, air-assisted airless, conventional, or HVLP methods
- Good adhesion on various substrates such as bare steel, aluminium, galvanised steel, and fibre reinforced plastic.
- High coverage due to highly concentrated pigment pastes.

PRODUCTS

8 Binders :

4 different glosses: matt, low gloss, semi-gloss and gloss.

For white and pastel colours:

7-531 Direct Binder GL 10% Light colours
7-533 Direct Binder GL 30% Light colours
7-535 Direct Binder GL 50% Light colours
7-537 Direct Binder GL 70% Light colours

For other colours:

7-530 Direct Binder GL 10%
7-532 Direct Binder GL 30%
7-534 Direct Binder GL 50%
7-536 Direct Binder GL 70%

Note: Gloss levels quoted are within +/- 10% depending upon colour, and may vary depending upon application and drying conditions.

17 Selemix Tinters

3 Hardeners :

9-070 Direct Hardener
9-075 Direct HS Hardener
9-080 Acrylic Hardener

3 Thinners :

1-480 Direct Thinner
1-470 Direct Slow Thinner
1-208 Slow Thinner

1 Additive :

6-550 Direct Accelerator

SELECTION AND PREPARATION OF SUBSTRATES



Substrate

Iron / Steel
Blasted steel
Phosphated steel
Galvanized steel
Light alloys
Aluminium
Fiber reinforced plastic
Paintwork / Powdercoat

Sand

P80-120(dry) or blast clean
Sa2.5 , 30µm profile
Scotch brite
Scotch brite
P180-320 (dry)
P240-320 (dry)
P240 (dry)
Scotchbrite

Degrease

All surfaces should be thoroughly degreased using the appropriate cleaner



AIRLESS / AIR-AIRLESS

CONVENTIONAL



Mixing ratio:

	Volume	Weight
Mixed col.	4 vol.	1000
9-070 / 9-080	1 vol.	200
1-480*	5% max	50

	Volume	Weight
Mixed col.	4 vol.	1000
9-070 / 9-080	1 vol.	200
1-480*	1-1.5vol.	170-250

Note: 1-470 or 1-208 Slow thinner are recommended for application temperatures above 30°C.



Spray viscosity:

18-25 sec
DIN 6 at 20°C

20 -25 sec
DIN 4 at 20°C

Pot life at 20°C:

2-3 hours *

3 hours *

Drying can be accelerated by adding 2% Selemix Direct Accelerator 6-550. The above pot life is reduced by half. The use of the additive is always recommended for temperatures under 20 °C.



Spray gun set up:

11-15 thou tip

1.6-1.8 mm tip

Spray pressure:

100-140 bar

60-70 bar

Standard 3-4 bar

Air cap pressure:

1 - 2 bar

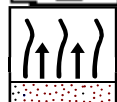
HVLP 2 bar



Number of coats:

1 - 2

2 - 3



Flash off between coats

10-15 minutes

15 minutes

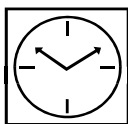
Total dry film build :

80-100µm

80-100µm

Higher thickness can be achieved with additional coats
This may extend the drying time

APPLICATION GUIDE



Drying times at 20°C :

<i>dust free :</i>	1 hour	1 hour
<i>tack free :</i>	1,5- 2 hours	2 hours
<i>hard dry</i>	16 hours	16 hours
<i>stoving :</i>	45mn at 60°C (metal temperature)	45mn at 60°C (metal temperature)



Recoatibility: Selemix Direct Topcoats can be overcoated with itself without sanding, for up to 10 days after drying. Otherwise the surface should be sanded before overcoating.

Colour: Check colour before use

TECHNICAL DATA

AIRLESS & AIR ASSISTED AIR LESS

CONVENTIONAL

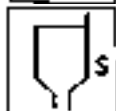
VOC :	415 to 455 g/l as supplied 470 to 500 g/l ready for use	520 to 550 g/l ready for use
Solid content :	65-70% by weight	60-65% by weight
Theoretical coverage:	4,5 m ² /L (ready for use) Dry film thickness:80µm	4.0 m ² /L Dry film thickness:80µm

APPLICATION GUIDE FOR HIGH SOLIDS MODE (VOC <420g/L)

AIRLESS - AIR ASSISTED AIRLESS



Mixing ratio:	Mixed colour 9-075	Volume 6 vol. 1 vol.	Weight 1000 130
----------------------	-----------------------	----------------------------	-----------------------



Spray viscosity: NA

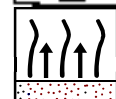


Pot life 20°C:	2- 3 hours
Spray gun set up / pressure	Airless Tip: 13-15 thou Fluid pressure: 100-140 bar

Air assisted Airless
Tip: 13-15 thou
Fluid pressure: 60 to 70 bar (1000 psi)
Air cap 1 –2 bar



Number of coats: 1 - 2



Flash off between coats: 10-15 minutes

APPLICATION GUIDE: ROLLER APPLICATION

Selemix Direct can also be applied with a roller .

Roller type advised :	Foam or short haired mohair	Volume	Weight
Mixing ratio:	Mixed colour	6 vol	1000
	9-075 Hardener	1 vol	130

PERFORMANCE AND LIMITATIONS

In case of difficulty to achieve coverage, depending on the type of colour, it is possible to use twice the standard ratio of tinters. Colour may be affected so check before use. Back-end performance, especially drying, will be affected also.

Note: This recommendation is for use with 7-530/2/4/6 binders only.

	Light colours Binders	Other Binders	Tinters
Standard ratio	950 g	-	50 g
Standard ratio	-	850 g	150 g
Standard ratio x2	-	700 g	300 g

VOC EU REGULATIONS

The EU limit value for this product (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.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the stability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of our experience and our policy of continuous product development. Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

Selemix System is a brand of PPG Group

Selemix Customer Service and Sales Group, Needham Road, Stowmarket, Suffolk, IP14 2AD, England, Tel: 01449 773993, Fax: 01449 771547