



# TECHNICAL DATASHEET

Issue date: July 2020

# SELEMIX® 2K WB ACRYLIC SINGLE STAGE TOPCOAT 8-110 High Gloss 8-111 Matt

#### PRODUCT DESCRIPTION

Selemix 8-110 (Gloss) and 8-111 (Matt) are 2K waterborne acrylic coatings, suitable for direct application to well-prepared steel, galvanized steel, phosphate steel, or aluminium surfaces exposed to weathering, mechanical and chemical stress, for both interior and exterior use.

It provides from high gloss to matt finish, with excellent gloss and colour retention and excellent hardness.

It is especially recommended for high quality finishes in industrial agricultural equipment and machinery.

#### **PRODUCTS**

8-110 Selemix WB Acrylic Single Stage Topcoat High Gloss8-111 Selemix WB Acrylic Single Stage Topcoat Matt

WBxx Selemix Waterborne Tinters

**Hardeners** 

9-110 Hardener for Acrylic Single Stage9-125 Fast Curing Hardener for Acrylic

Thinner:

Water Tap Water

## SUBSTRATES AND PREPARATION





Steel	Machine sand with P80-120 discs and degrease	
Phosphated Steel	Abrade with Scotchbrite® and degrease	
Galvanised steel	Abrade with Scotchbrite® and degrease	
Light Alloys	Machine sand with P280-320 discs and degrease	
Aluminium	Machine sand with P280-320 discs and degrease	
Painted Surfaces	Machine sand with P240-320 discs and degrease	
Apply only on a clean and dry surface with a temperature above the dew point to avoid		

condensation. In confined spaces, provide adequate ventilation during application and drying.







# **MIXING - STANDARD MODE**

Thoroughly Mix Paint before activating and check colour before use.



Features	Conventional	Air-Assisted Airless	
By Weight: 8-11x Topcoat 9-110 Hardener	1000 400 Thoroughly mix topcoat during 5 minutes and then add: 150 - 300	1000 400 Thoroughly mix topcoat during 5 minutes and then add: 50 - 150	
By Volume: 8-11x Topcoat 9-110 Hardener Water	2.5 1 Thoroughly mix topcoat during 5 minutes and then add: 0.6-1.2 (15-30%)	2.5 1 Thoroughly mix topcoat during 5 minutes and then add: 0.2-0.6 (5-15%)	
Viscosity (at 20°C):  Pot Life (at 20°C):	55-60 secs DIN4	100-120 secs DIN4 2 hours	

# **APPLICATION - STANDARD MODE**



Features	Conventional	Air-Assisted Airless
Spraygun setup:	Nozzle: Gravity: 1.6 - 1.8 mm Suction: 1.8 - 2.0 mm Pressure feed:1.2 - 1.4mm	Nozzle: 09 - 11 thou 0.23 – 0.28 mm
Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	2 - 3 Bar
Fluid Pressure:	N/A	70 - 150 Bar
Number of coats:	2 medium	1 Light Dry + 1 Full
Flash-off between coats:	15-30 mins minimum at 20°C	2 mins minimum at 20°C
Drying:	Air dry or bake at: 60°C for 45-60 mins or 80°C for 20-25 mins	Air dry or bake at: 60°C for 45-60 mins or 80°C for 20-25 mins
Flash-off before bake:	45 mins minimum at 20°C	45 mins minimum at 20°C
Wet Film Thickness:	125-140 microns	125-140 microns
Dry Film Thickness:	60-80 microns	60-80 microns





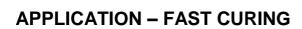


# **MIXING - FAST CURING**

Thoroughly mix paint before activating and check colour before use.



ats
during add:
during add:
a a





Features	Conventional 1 Visit	Conventional 2 coats
Spraygun setup:	Nozzle: Gravity: 1.4 - 1.6 mm Suction: 1.6 - 1.8 mm Pressure feed: 0.8 - 1.0 mm	Nozzle: Gravity: 1.4 - 1.6 mm Suction: 1.6 - 1.8 mm Pressure feed: 0.8 - 1.0 mm
Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar N/A	HVLP: 2 Bar Standard: 2-3 Bar N/A
ridia riccodio.	14/7	14/7
Number of coats:  Flash-off between coats:	1 Light dry + 1 full 2 mins minimum at 20°C	1 light closed + 1 medium 15-20 mins minimum at 20°C
Drying:	Air dry or bake at 60°C for 30 mins	Air dry or bake at 60°C for 30 mins
Flash-off before bake:	20 mins minimum at 20°C	20 mins minimum at 20°C
Wet Film Thickness:	125-150 microns	125-150 microns
Dry Film Thickness:	60-80 microns	60-80 microns







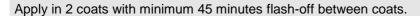
## **OTHER APPLICATION MODES**



## Features Brush and Roller

8-11x Topcoat can be applied by brush (solvent resistant) or roller short haired mohair roller.

Activate 2.5:1 with 9-110/9-125 Hardener. Thinning with 10% of water is recommended.





	Tinting Ratio (by weight):	
High Gloss	Binder 8-110: WB Tinters:	60 40
Semi-Gloss (~70%)	Binder 8-111: Binder 8-110: WB Tinters:	36 24 40
Semi-Matt (~30%)	Binder 8-111: Binder 8-110: WB Tinters:	48 12 40
Matt (15-20%)	Binder 8-111: WB Tinters:	60 40

# **DRYING TIMES**



at 20°C

<b>Features</b>	STANDARD MODE	FAST CURING MODE	
Dust Free: Touch Free: Handleable: Hard Dry:	20 - 25 mins 5 - 6 hours 8 - 9 hours 24-36 hours	10 - 15 mins 2 - 3 hours 6 hours Overnight	
Stoving:	45-60 minutes @60°C (according to film thickness)	30 minutes @60°C (according to film thickness)	
Overcoating Time:	Minimum: 8 hours  Maximum: 24 hours without sanding on clean surface  with itself	Minimum: 8 hours Maximum: 24 hours without sanding on clean surface with itself	
Note:	Lower temperatures or film thickness higher than 80µm will extend drying times. The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperature below 20°C, humidity above 85% RH and excessive film thickness will extend the drying times		





#### **TECHNICAL DATA**

Based on ready-for-use mixed paint including water:

VOC (g/L):

Solid content (weight): Solid content (volume): Theoretical coverage:

Specific gravity (Ready for use)

Gloss:

Storage:

140-198 g/L 40-59 % 36-50 % 5 - 7 m² per litre at 70 microns DFT 1.04-1.19 Kg/L

High Gloss to Matt Finish

STORE FREE FROM FROST ABOVE 4°C.

Prolonged exposure to high temperatures or direct sources of heat should be avoided

## PRODUCT CODES AND DESCRIPTIONS

Selemix Code	<b>Short Code</b>	<b>Product Description</b>	Packs	size
1.781.1000/E12K	8-110	WB Acrylic Single Stage Topcoat High Gloss	12	Kg
1.781.1100/E12K	8-111	WB Acrylic Single Stage Topcoat Matt	12	Kg
1.781.1100/E120K	8-111	Single Stage Topcoat Matt	120	Kg
1.959.8110/E5	9-110	Hardener for Acrylic	5	Lt
1.959.8125/E5	9-125	Fast Curing Hardener for Acrylic	5	Lt
1.959.8125/E200	9-125	Fast Curing Hardener for Acrylic	200	Lt

#### **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.

#### FOR FURTHER INFORMATION PLEASE CONTACT:

Selemix Customer Service and Sales Group Needham Road Stowmarket, Suffolk IP14 2AD, England

Tel: 01449 771771

