

### PRODUCT DESCRIPTION

7-861 1K One-Stage Finish is a finish coat that will also provide corrosion resistance. Suitable applications are for agricultural equipment, containers, cranes, and general industrial coating.

### SELECTION AND PREPARATION OF SUBSTRATES

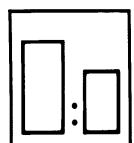


Thoroughly clean and degrease the substrate before painting

Bare iron / steel and phosphated steel  
Primer and old finishes

**Sand**  
P80 -120 (dry)  
P400 (wet) or P280 (dry)

### APPLICATION GUIDE

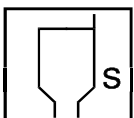


*Mixing ratio (by weight):*

AIRLESS		CONVENTIONAL	
Topcoat	1000	Topcoat	1000
1-610 *	150	1-610 *	250-350
*1-215 or 1-205 can be used		*1-215 or 1-205 can be used	

*Mixing ratio (by volume):*

Topcoat	5	Topcoat	3
1-610 *	1	1-610 *	1 - 1.5
*1-215 or 1-205 can be used		*1-215 or 1-205 can be used	



*Pot life 20 °C:*

Unlimited

Unlimited

*Spray viscosity:*

34-37 s DIN4 at 20°C

20-25 s DIN4 at 20°C



*Spray gun set up:*

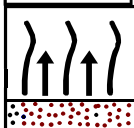
11 – 15 thou tip

1.6 – 2.0 mm

*Spray pressure:*

120-140 bar

2-4 bar



*Number of coats:*

2

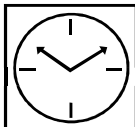
2

*Flash off between coats:*

10 - 15 minutes 20 °C

10 -15 minutes 20 °C

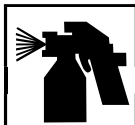
## APPLICATION GUIDE



*Drying times at 20 °C*

*Dust free:* 10-15 minutes

*Touch dry:* 40-60 minutes



*Through dry:* 24-48 hours

*Total dry film build:* 60-80 microns

Overcoat / recoat time itself or topcoat Within 2 hours; or then after more complete through drying (6-7 days)

After 24 hours by addition of 10% hardener 9-060 in the topcoat.

Recoat with: SELEMIX SYSTEM air drying 1K Synthetic, Cellulose, or Chlorinated Finishes.

## TECHNICAL DATA

*Theoretical coverage* 6.0 - 7.0 m<sup>2</sup>/l ready to spray giving 50µm dry film thickness

## HEALTH AND SAFETY

Please refer to Material Safety Data Sheet for full health and safety details and storage regulations

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**