

**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**


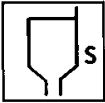


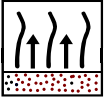
P80-120 (dry)  
P80-120(dry) or shot blast  
Scotch brite  
Scotch brite  
P280-320 (dry)  
P280-320 (dry)  
P240 (dry)

**Degrease**

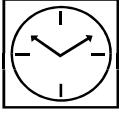
All surfaces should be thoroughly degreased using the appropriate cleaner



## APPLICATION GUIDE USING 9-070 or 9-080 HARDENERS

	White and pastel colours	Other Colours	
<b>Tinting Ratio</b>	Binder: 95	Binder: 85	
<b>By weight :</b>	Tinters: 5	Tinters: 15	
	AIRLESS	AIR ASSISTED AIRLESS	CONVENTIONAL
	<b>Mixing ratio:</b>	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
<b>Notes:</b>			
<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>			
	<b>Spray viscosity:</b>	25-30 sec DIN 4 at 20°C	20 -25 sec DIN 4 at 20°C
	<b>Pot life at 20°C:</b>	2-3 hours	3 hours
	<b>Spray gun set up:</b>	11-13 thou tips	Nozzle =1,8 mm
	<b>Spray pressure:</b>	100-140 bar      70-100 bar	Standard 3-4 bar HVLP      2 bar Air cap pressure: 2 – 2.5
	<b>Number of coats:</b>	1 - 2	2 - 3
	<b>Flash off between coats</b>	15-20 minutes	15-20 minutes
<b>Total dry film build :</b>	80-100µm Higher thickness can be achieved with additional coats This may extend the drying time	80-100µm	

## 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)



**Recoatibility:**


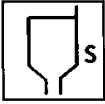


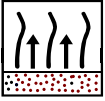
Selemix Direct Topcoats can be overcoated without sanding, with themselves 10 days after drying and up to 5 months after drying. It is extremely important that the surface is thoroughly cleaned before overcoating.



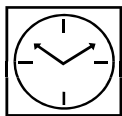
**Colour:**

Check colour and gloss before use

## APPLICATION GUIDE USING 9-075 HARDENER

		White and pastel colours		Other Colours		
<b>Tinting Ratio</b>		Binder: 95		Binder: 85		
<b>By weight :</b>		Tinters: 5		Tinters: 15		
		AIRLESS	AIR ASSISTED AIRLESS	CONVENTIONAL		
	<b>Mixing ratio:</b>		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	
				Mixed col.	1000	
				9-075	130	
				1-xxx**	250	
<b>Notes:</b>						
<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>						
	<b>Spray viscosity:</b>	25- 35 sec DIN 4 at 20°C		20 - 25 sec DIN 4 at 20°C		
	<b>Pot life at 20°C:</b>	2-3 hours *		2-3 hours *		
	<b>Spray gun set up:</b>	11-13 thou tips		Nozzle =1,8 mm		
	<b>Spray pressure:</b>	100-140 bar	70-100 bar	Standard	3-4 bar	
				HVLP	2 bar	
				Air cap pressure:	2 – 2.5	
	<b>Number of coats:</b>	1 - 2		2		
	<b>Flash off between coats</b>	15-20 minutes		15-20 minutes		
	<b>Total dry film build :</b>	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 :**

<b>dust free :</b>	1 hour	1 hour
<b>tack free :</b>	1,5 hours	1,5 hours
<b>hard dry</b>	16 hours	16 hours
<b>stoving :</b>	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

**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)

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