

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 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 without thinner in airless and air assisted airless modes.

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

PRODUCTS

8 Binders :

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

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% for the 70% and 50% binders, and +/- 5% for binders giving gloss levels 30% or less, depending upon colour, and will vary depending upon application / drying conditions.

16 SELEMIX Tinters

3 Hardeners :

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

3 Thinners :

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

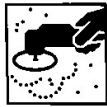
1 Additive :

6-550 Direct Accelerator

1 Accelerated Thinner

1-490 Accelerated direct thinner

SELECTION AND PREPARATION OF SUBSTRATES



Substrate

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

Sand

P80-120 (dry)
P80-120(dry) or shot blast
Sa2.5 , 30µm profile
Scotch brite
Scotch brite
P280-320 (dry)
P240 (dry)

Degrease

All surfaces should be thoroughly degreased using the appropriate cleaner



APPLICATION GUIDE

White and pastel colours

Tinting Ratio

Binder: 95

By weight :

Tinters: 5

Other Colours

Binder: 85

Tinters: 15

AIRLESS

AIR ASSISTED AIRLESS

CONVENTIONAL



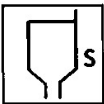
Mixing ratio:

	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
1-480*	5% max.	50	1-480*	1 vol.	170
Or with HS hardener					
Mixed col.	6 vol.	1000	Mixed col.	6 vol.	1000
9-075	1 vol.	130	9-075	1 vol.	130
1-480*	1 vol.	170	1-480*	1,5 vol.	250

Note: *Depending on spraying equipment and binder used.

1-208 Slow thinner is recommended for application temperatures above 30°C.

1-470 Direct slow thinner is for temperatures above 35°C or very large areas



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 up to 2% 6-550 accelerator into the ready for use paint or by thinning with 1-490 Accelerated Thinner. That means the above pot life is reduced to the half.



Spray gun set up:

11-17 from 7-530 to 7-535
11-13 with 7-536 and 7-537

NozzleØ =1,8 mm

Spray pressure:

100-140 bar

70-100 bar
Air cap pressure:
2 - 3 bar

Standard 3-4 bar

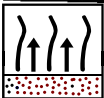
HVLP 2 bar



Number of coats:

1 - 2

2 - 3



Flash off between coats

10-15 minutes

15 minutes

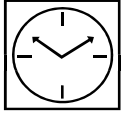
Total dry film build :

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 :

dust free :	1 hour	1 hour
tack free :	1,5- 2 hours	2 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 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 in m ² / Lt of ready to spray product	4,5 m ² dry film thickness:80µm	4.0 m ² /lt dry film thickness:80µm

APPLICATION GUIDE: OTHER APPLICATION MODE

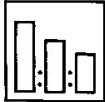
Selemix Direct can also be applied with a roller .

Roller type advised :	short haired mohair	Volume	Weight
Mixing ratio:	Mixed colour	4 vol	1000
	9-070	1 vol	200
	1-480	0,5 - 0,7 vol	85-120

It is advisable to add 1 – 2% of 6-570 Anti-foam additive when applying by roller, to avoid air bubbles in the paint film.

APPLICATION GUIDE FOR VOC COMPLIANT MODE

AIRLESS - AIR ASSISTED AIRLESS

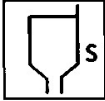


Mixing ratio:

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

Tip: 13-15 thou
Fluid pressure: 100-140 bar

Airless

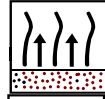
Air assisted Airless

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



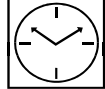
Number of coats:

1 - 2



Flash off between coats:

10-15 minutes



Drying times at 20°C:

dust free :

30 minutes

tack free:

60 minutes

hard dry:

16 hours

Stoving :

45 minutes at 60°C

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.

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.

PERFORMANCE AND LIMITATIONS

In case of difficulty to achieve full opacity, it is possible to use twice the standard ratio of tinters, however, there may be an impact on colour accuracy so check colour before use.

Also the use of twice the quantity of toner, will have an effect on drying properties so the add of catalyst additive or thinning with accelerated thinner might be necessary.

Note: This recommendation is for use with 7-530/2/4/6 binders only, not in 7-531/3/5/7 white binders

	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.

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

SELEMIX SYSTEM is a brand of PPG Group.

PPG Industries (UK) Ltd, Auto refinish, Customers Service and Sales Group, Needham Road, Stowmarket, Suffolk, IP14 2AD, England, Tel : 01449 771775, Fax : 01449 771547