

1K ONE-STAGE FINISH SEMI-GLOSS

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

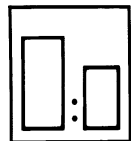


Thoroughly clean and degrease the substrate before painting

Bare iron / steel and phosphated steel
Primer and old finishes

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

APPLICATION GUIDE

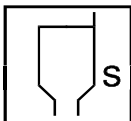


Mixing ratio (by weight):

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

Mixing ratio (by volume):

	AIRLESS		CONVENTIONAL	
Topcoat	5		3	
1-610 *	1		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:

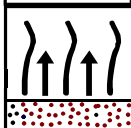
11 – 15 thou tip

1.6 – 2.0 mm

Spray pressure:

120-140 bar

2-4 bar



Number of coats:

2

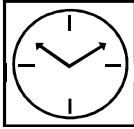
2

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 m²/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

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