



TECHNICAL DATASHEET

8-110 / 8-111

2K WB SINGLE STAGE TOPCOAT

PRODUCT DESCRIPTION

8-110 (Gloss) and 8-111 (Matt) are two component, waterborne, polyurethane, single stage topcoats, suitable for direct application to properly 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, colour retention and excellent hardness.

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

SELECTION AND PREPARATION OF SUBSTRATES



Substrate

Bare Steel
Phosphated Steel
Galvanised Steel
Light Alloys
Aluminium

Sand

P80 – 120 (dry)
Scotchbrite
Scotchbrite
P280 – 320 (dry)
P280 – 320 (dry)

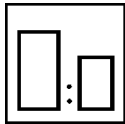
Degrease

All surfaces should be thoroughly degreased using the appropriate cleaner both before and after preparation.

VERY IMPORTANT: Degrease **thoroughly** prior to painting. All substrates should be free from any contamination such as oil, grease and rust.

APPLICATION GUIDE

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



Mixing ratio (by weight):

Topcoat 8-110 / 8-111 1000
Hardener 9-110 400

Mix thoroughly and then add:-

15 – 30% Water – Conventional application

5 – 15% Water – Airmix application

(*) It is very important to thoroughly mix topcoat and hardener during 5 minutes before adding water

Mixing ratio (by volume):

Topcoat 8-110 or 8-111 2,5
Hardener 9-110 1

Mix thoroughly and then add:-

15 – 30% Water – Conventional application

5 – 15% Water – Airmix application

Pot life 20°C:

3 hours

Conventional 1 Visit Application

65-70 sec DIN 4 at 20°C

1.6 – 1.8 mm

2 – 3 bar

1 light coat, 2 minute flash off, 1 normal coat

2 minutes at 20°C

45 minutes at 20°C

Conventional 2 Coat Application

55-60 sec DIN 4 at 20°C

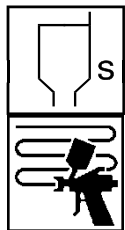
1.6 – 1.8 mm

2 – 3 bar

1 light coat, 15 - 30 minutes flash off, 1 normal coat

15 - 30 minutes at 20°C, until surface dry

45 minutes at 20°C



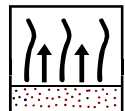
Spray viscosity:

Spray gun set up:

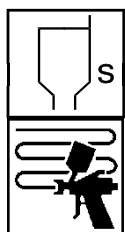
Spray pressure:

Number of coats:

Flash off between coats:



Flash off before stoving:



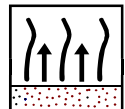
Spray viscosity:

Spray gun set up:

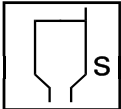

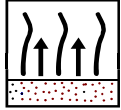
Spray pressure:

Number of coats:

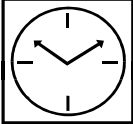

Flash off between coats:



Flash off before stoving:

  	<p>Spray viscosity:</p> <p>Spray gun set up:</p> <p>Fluid pressure:</p> <p>Spraygun Pressure</p> <p>Number of coats:</p> <p>Flash off between coats:</p> <p>Flash off before stoving:</p>	<p><u>Airmix Application</u></p> <p>100-120 sec DIN 4 or 30-34 sec DIN 6 at 20°C</p> <p>9 - 11 thou</p> <p>70 – 150 bar</p> <p>2 – 2.5 bar</p> <p>1 very light coat, 2 minutes flash off, 1 normal coat</p> <p>2 minutes at 20°C</p> <p>45 minutes at 60°C</p>
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APPLICATION GUIDE

 	<p>Drying times at 60°C (metal T°):</p> <p>Drying times at 80°C (metal T°):</p> <p>Drying times at 20°C</p> <p>Dust free:</p> <p>Touch free:</p> <p>Handling:</p> <p>Recommended thickness:</p> <p>Recoat time:</p>	<p>45 - 60 minutes (regarding film thickness)</p> <p>20-25 minutes</p> <p>20 minutes</p> <p>5 - 6 hours</p> <p>8 - 9 hours</p> <p>140 microns max. – wet film thickness</p> <p>60 – 80 microns – dry film thickness</p> <p>min. 8 hours and max. 24 hours at 20°C without flatting</p>
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The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C, above 85% RH and excessive film thickness will extend the drying times.

APPLICATION GUIDE – BRUSH / ROLLER APPLICATION

Equipment type advised : short haired mohair roller or solvent resistant brush

Mixing ratio:	Mixed colour	Volume	Weight
	9-110	3 vol	1000
	Water	1 vol	300
		0.3 vol	100-150

Application in 2 medium coats, leave a minimum 45 minutes drying time between coats.

TECHNICAL DATA RFU

	8-110	8-111
<i>Theoretical coverage:</i>	5.2 – 6.4	5.3 – 5.5 m ² /L of paint ready to use for 70µm of thickness
<i>Solid content (by vol):</i>	39 - 50%	40 – 42%
<i>Solid content (by w):</i>	43 - 59%	44 – 46%
<i>% Solvent:</i>	9 – 10%	7 – 9%
<i>Density:</i>	1040 – 1190	1050 – 1180 g/L

Storage:

STORE FREE FROM FROST ABOVE 5°C

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

HEALTH AND SAFETY

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, also available at:

<http://corporateportal.ppg.com/Refinish/Selemix>

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