



**TECHNICAL DATASHEET**

# 8-110 / 8-111

## 2K WB SINGLE STAGE TOPCOAT / FAST CURING SYSTEM

### PRODUCT DESCRIPTION

8-110 (Gloss) and 8-111 (Matt) are a two component, waterborne, polyurethane, single stage topcoat, suitable for direct application to properly prepared steel, galvanized steel, phosphated 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 agricultural equipment and machinery.

8-11x when activated with 9-125 Fast Curing Hardener provides a short flash-off between coats and prior baking in a short time. It is also air dry capable.

### 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)

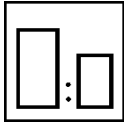
**Degrease**

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.

### GLOSS CHART GUIDE

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



**Mixing ratio (by weight):**

Topcoat 8-110 / 8-111                    1000  
Hardener 9-125 (\*)                        400

Mix thoroughly and then add:

15 – 30% Water – Conventional application

**Mixing ratio (by volume):**

Topcoat 8-110 / 8-111                    2,5  
Hardener 9-125 (\*)                        1

Mix thoroughly and then add:-

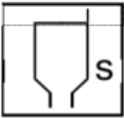
15 – 30% Water – Conventional application

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

**Pot life 20°C:**

2 hours

**Conventional 1 Visit Application**



**Spray viscosity:**

65-70 sec DIN 4 at 20°C

**Spray gun set up:**

1.6 – 1.8 mm

**Spray pressure:**

2 – 3 bar

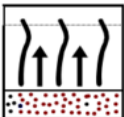


**Number of coats:**

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

**Flash off between coats:**

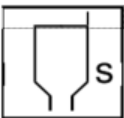
2 minutes at 20°C



**Flash off before stoving:**

20 minutes at 20°C

**Conventional 2 Coats Application**



**Spray viscosity:**

55-60 sec DIN 4 at 20°C

**Spray gun set up:**

1.6 – 1.8 mm

**Spray pressure:**

2 – 3 bar

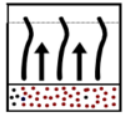


**Number of coats:**

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

**Flash off between coats:**

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



**Flash off before stoving:**

20 minutes at 20°C

**Air Assisted Airless Application**

NOT RECOMMENDED

## APPLICATION GUIDE



**Drying times at 60°C (metalT°):**

30 minutes (for 60-80 µm DFT)

**Drying times at 20°C**

10-15 minutes

**Dust free:**

2 - 3 hours

**Touch free:**

6 hours

**Handling:**

8-9 hours

**Through Dry:**

Overnight

**Recommended thickness:**

140 microns max. – wet film thickness  
60 – 80 microns – dry film thickness

**Recoat time:**

min. 8 hours and max. 24 hours at 20°C  
without flatting

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

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

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

## TECHNICAL DATA RFU

	<b>8-110</b>	<b>8-111</b>
<i>Theoretical coverage:</i>	5.2 – 6.4	5.3 – 5.5 m <sup>2</sup> /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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