

## TECHNICAL DATASHEET

Issue date:  
October 2020

# SELEMIX® 1K SYNTHETIC URETHANE TOPCOAT 7-630

## PRODUCT DESCRIPTION

*Selemix* 7-630 1K Synthetic Urethane Topcoat is a high gloss 1K synthetic finish for solid colours and single-layer metallic finishes.

It is compatible with *Selemix* Fast Dry primers, giving a durable paint system. It has a very high gloss finish with good durability. Application can be by conventional or air-assisted airless spray.

It is suitable for the coating of machinery, agricultural and construction equipment, and many other industrial painting applications where a high gloss finish is required.

## PRODUCTS

7-630                      *Selemix* 1K Synthetic Urethane Topcoat  
 NPxx                     *Selemix* NP Tinters

### Thinners:

1-610                     Synthetic Thinner  
 1-215                     Nitrocellulose Thinner  
 1-205                     Aromatic Free Thinner

## SUBSTRATES AND PREPARATION



Painted Surfaces  
 Polyurethane or  
 Polyester Fillers

Machine sand with P320-400 discs and degrease






**Selemix 1K primers :**

Refer to Primer TDS for recoat time




Apply only on a clean and dry surface with a temperature above the dew point to avoid condensation. In confined spaces, provide adequate ventilation during application and drying.

## MIXING

Thoroughly mix paint before activating and check colour before use

	Features	Conventional	Air-Assisted Airless
	<b>By Weight:</b> 7-630 Topcoat 1-610/1-215/1-205 Thinner	1000 250-350	1000 100-200
	<b>By Volume:</b> 7-630 Topcoat 1-610/1-215/1-205 Thinner	7 2 - 3 (30-40%)	10 1 - 2 (10-20%)
	Viscosity (at 20°C): Pot Life (at 20°C):	18-22 secs DIN4 Unlimited	30-50 secs DIN4 Unlimited

## APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.3-1.4mm Suction: 1.6-1.8mm Pressure feed: 0.85-1.2mm	Nozzle: 9-11 thou 0.23-0.28mm
	Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	2.5 Bar
	Fluid Pressure:	N/A	100-120 Bar
	Number of coats:	2	2
	Flash-off between coats:	10-15 mins	10-15 mins
	Drying:	Air dry	Air dry
	Wet Film Thickness:	100-120 microns	100-120 microns
	Dry Film Thickness:	40-50 microns	40-50 microns

## DRYING TIMES



at 20°C

Dust Free:	10-15 mins
Touch Free:	1-2 hours
Tape Free:	16 hours
Handleable:	4-5 hours
Hard Dry:	48-72 hours
Overcoating time:	Minimum: 2 hours
	Maximum: 10 days by itself without sanding

Lower temperature or film thickness higher than 50µm will extend drying times

## TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:

VOC (g/L):	535-619 g/L (depending on colour and dilution)
Solid content (weight):	41-49 %
Solid content (volume):	30-39 %
Solvent content (weight):	51-59 %
Specific gravity (Ready for use)	0.96-1.05 Kg/L

Theoretical coverage:  
Gloss:

5.9-7.8 m<sup>2</sup>/L at 50 microns DFT  
High Gloss

Note on Paint Mixing:

When mixing colours, it is recommended that binders and toners are weighed out first and mixed well before the addition of driers

## PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.776.3000/E3.25K	7-630	1K Synthetic Urethane Topcoat	3.25	Kg
1.911.5610/E5	1-610	Synthetic Thinner	5	Lt
1.921.3215/E1	1-215	Nitrocellulose Thinner	1	Lt
1.921.3215/E5	1-215	Nitrocellulose Thinner	5	Lt
1.991.1205/E25	1-205	Aromatic-Free Thinner	25	Lt

## HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and Product can labels.

## 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.

### FOR FURTHER INFORMATION PLEASE CONTACT:

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