

TECHNICAL DATASHEET

Issue date:
Feb 2020

SELEMIX® 1K WB SYNTHETIC HYDRO-THINNABLE GLOSS TOPCOAT 8-863

PRODUCT DESCRIPTION

Selemix 8-863 Synthetic 1K Hydro-Thinnable gloss topcoat, is based on high solids resins, and is water thinnable, providing a low VOC topcoat.

Suitable to be used in conjunction with *Selemix* Aqua 1K Polyurethane primer 5-8851, this will give a complete waterborne system with good sag resistance and drying properties. It may also be used over other solventborne *Selemix* Primers as long as they are completely dry.

PRODUCTS

8-863 *Selemix* 1K WB Synthetic Hydro-Thinnable Gloss Topcoat
 WBxx *Selemix* Waterborne Tinters

Thinner:

Water Tap Water

SUBSTRATES AND PREPARATION



5-8851 1K Polyurethane
Primer

Wet on Wet or Machine sand with P320-360 discs and degrease






Painted Surfaces

Machine sand with P320-360 discs and degrease




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
	By Weight: 8-863 Topcoat Water	1000 0 - 50	1000 0
	By Volume: 8-863 Topcoat Water	10 0 – 0.5 (0-5%)	10 No thinning required
	Viscosity (at 20°C): Pot Life (at 20°C):	55-65 secs DIN4 unlimited	As supplied unlimited

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup: Air Pressure: Fluid Pressure:	Nozzle: Gravity: 1.3 - 1.6 mm Suction: 1.6 - 1.8 mm Pressure feed: 0.8 - 1.2 mm HVLV: 2 Bar Standard: 2-3 Bar N/A	Nozzle: 9-11 thou 0.23-0.28 mm 2.5 – 3 Bar 70 - 100 Bar
	Number of coats: Flash-off between coats:	2 medium coats 10-25 mins minimum at 20°C	1 Light Dry + 1 full coats 2 mins minimum at 20°C
	Drying: Flash-off before bake:	Air dry N/A	Air dry N/A
	Wet Film Thickness: Dry Film Thickness:	100-125 microns 40-50 microns	100-125 microns 40-50 microns

MATTING CHART (All Colours)

	8-864 Matt	8-863/8-864 Semi-Matt	8-863/8-864 Semi-Gloss	8-863 Gloss	8-863 Black Colours Gloss
8-863	-	35 %	50 %	75 %	85 %
8-864	75 %	40 %	25 %	-	-
Tinting Bases	25 %	25 %	25 %	25 %	15 %

DRYING TIMES



at 20°C

Dust Free	10-15 mins
Touch Free	4 - 5 hours
Handleable	24 hours
Hard Dry	48 hours
Stoving:	Not recommended
Overcoating time:	Minimum: 24 hours Maximum: 7 days without sanding on clean surface with itself
Note:	Lower temperature or film thickness higher than 50µm will extend drying times. The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperature below 20°C, humidity above 85% RH and excessive film thickness will extend the drying times.

TECHNICAL DATA

Based on ready-for-use mixed paint including water:	
VOC (g/L):	60 g/L
Solid content (weight):	27-37 %
Solid content (volume):	25-30 %
Theoretical coverage:	5 - 6 m ² per litre at 50 microns DFT
Specific gravity (Ready for use)	1.03-1.10 Kg/L
Gloss:	Gloss to Matt Finish
Storage:	STORE FREE FROM FROST ABOVE 4°C. Prolonged exposure to high temperatures or direct sources of heat should be avoided

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.788.6300/E3.75K	8-863	1K WB Synthetic Hydro-Thinnable Gloss Topcoat	3.75	Kg
1.788.6400/E3.75K	8-864	1K WB Synthetic Hydro-Thinnable Matt Topcoat	3.75	Kg

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:

Selemix Customer Service and Sales Group
Needham Road
Stowmarket, Suffolk
IP14 2AD, England
Tel: 01449 771771