

TECHNICAL DATASHEET

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SELEMIX® 1K FAST DRY SYNTHETIC DIRECT TOPCOAT - SEMI GLOSS 7-870

PRODUCT DESCRIPTION

7-870 *Selemix* 1K Fast Dry Synthetic Direct Topcoat is a 1K semi-gloss finish that is intended to be applied directly to a metal substrate. It has fast drying and good anticorrosion properties.

It is intended to protect ferrous substrates and can be used over previously painted surfaces.

This product provides a fast and simple process for the finishing and protection of machinery, agricultural and construction equipment, and many other industrial painting applications.

PRODUCTS

7-870 *Selemix* Fast Dry Synthetic Direct Topcoat – Semi Gloss
 NPxx *Selemix* NP Tinters

Thinners:

1-215 Nitro Thinner
 1-470 Slow Direct Thinner

SUBSTRATES AND PREPARATION






Bare Steel	Machine sand with P80-120-150 discs and degrease
Steel (Blast Cleaned)	Blast clean to ISO 8501-1 SA 2.5 with a blast profile of maximum 40 µm Rz
Phosphated Steel	Degrease if required
Painted Surfaces Polyurethane or Polyester Fillers	Machine sand with P320-400 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 diluting

Features	Conventional	Air-Assisted Airless
 <p>By Weight: 7-870 Tinted Topcoat 1-215 / 1-470 Thinner</p>	1000 150	1000 75-150
 <p>By Volume: 7-820 Tinted Topcoat 1-215 / 1-470 Thinner</p>	5 1 (20%)	5 0.5-1 (10-20%)
 <p>Viscosity (at 20°C):</p>	25-30 secs DIN4	30-50 secs DIN4
<p>Pot Life (at 20°C):</p>	unlimited	unlimited

APPLICATION

Features	Conventional	Air-Assisted Airless
 <p>Spraygun setup:</p>	Nozzle: Gravity: 1.6-2.0mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm	Tip: 11-13 thou (0.28-0.33 mm)
<p>Air Pressure:</p>	HVLP: 2 Bar Standard: 2.5-3 Bar	2.5 Bar
<p>Fluid Pressure:</p>	N/A	100-140 Bar
 <p>Number of coats:</p>	2-3	2
<p>Flash-off between coats:</p>	10-15 mins	10-15 mins
 <p>Drying:</p>	Air dry	Air dry
<p>Wet Film Thickness:</p>	120-200 µm	120-200 µm
<p>Dry Film Thickness:</p>	50-80 microns	50-80 microns

DRYING TIMES



at 20°C

Dust Free
Touch Free
Tape Free
Handleable
Hard Dry

10-15 mins
40-60 minutes
12-16 hours
2-4 hours
16 hours

Stoving:

Not recommended

Overcoating time:

Minimum: 24 hours
Maximum: 1 month without sanding on clean surface

Note:

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):
Solid content (weight):
Solid content (volume):
Solvent content (weight):
Specific gravity (Ready for use)

526-554 g/L (depending on colour and dilution)
46-55 %
35-40 %
45-54 %
1.02-1.16 Kg/L

Theoretical coverage:

7-8 m² per litre at 50 microns DFT

Gloss:

Semi-Gloss Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
7-870/E4.25K	7-870	1K Fast Dry Synthetic Direct Topcoat – Semi Gloss	4.25	Kg
7-870/E17K	7-870	1K Fast Dry Synthetic Direct Topcoat – Semi Gloss	17	Kg
1.921.3215/E1	1-215	Nitro Thinner	1	Lt
1.921.3215/E5	1-215	Nitro Thinner	5	Lt
1.991.1470/E5	1-470	Slow Direct Thinner	5	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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