

TECHNICAL DATASHEET

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SELEMIX® DIRECT PRO CUSTOMIZED GLOSS

PRODUCT DESCRIPTION

Selemix Direct Pro Gloss is a versatile, high solids 2-pack Acrylic PU finish that can be applied directly to a variety of substrates without need for a primer, giving a very efficient process.

It gives a high quality gloss finish with good colour and UV stability. Its good anticorrosive properties make it suitable for the finishing and protection of machinery, agricultural and construction equipment, and many other industrial painting applications.

PRODUCTS

7-168 *Selemix* Direct Pro Gloss (All Colours)

Hardeners:

- 9-158 Fast Hardener for Acrylic
- 9-154 Medium Hardener for Acrylic
- 9-152 Slow Hardener for Acrylic

Thinners:

- 1-159 Reactive Thinner For Acrylic
- 1-160 Slow Reactive Thinner for Acrylic

Additive:

- 6-551 Flexible Additive

SUBSTRATES AND PREPARATION






Steel (Blast Cleaned)	Blast clean to ISO 8501-1 SA 2.5 with a blast profile of maximum 40 µm Rz
Steel / Stainless Steel	Machine sand with P80-120 discs and degrease
Galvanised steel	Abrade with SCOTCHBRITE® and degrease
Aluminium	Machine sand with P240-320 discs and degrease
Painted Surfaces	Machine sand with P240-320 discs and degrease
<i>Selemix</i> Epoxy Primer or PU Primer	Refer to Primer TDS for recoat time
GRP	Machine sand with P240-320 discs and degrease
Plastics : PA, PC, ABS, PC/ABS, PMMA, PVC (**PP)	Abrade with SCOTCHBRITE® and degrease **PP must be flame treated before painting




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: 7-168 Topcoat 9-15X Hardener 1-159 / 1-160 Thinner	1000 330 200-250	1000 330 50-150
 By Volume: 7-168 Topcoat 9-15X Hardener 1-159 / 1-160 Thinner	2.5 1 0.75-0.9 (25-30%)	2.5 1 0.2-0.6 (7-20%)
 Viscosity (at 20°C): Pot Life (at 20°C):	28-35 secs DIN4 2.5-3 hours	40-45 secs DIN4 1.5-2 hours

APPLICATION

Features	Conventional	Air-Assisted Airless
 Spraygun setup:	Nozzle: Gravity: 1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm	Nozzle: 09-11 thou 0.23-0.28mm
Air Pressure: (refer to spraygun manufacturer)	HVLP: 2 Bar Standard: 2.5-3 Bar	2.5 Bar
Fluid Pressure:	N/A	100 Bar
 Number of coats:	2	2 (or 1 Visit)
Flash-off between coats:	15 mins	15-20 mins (or 2 mins for 1 Visit)
 Drying:	Air dry or bake at 50°C for 30-45 mins	Air dry or bake at 50°C for 30-45 mins
Flash-off before bake:	10-15 mins	10-15 mins
Wet Film Thickness:	150-175 microns (2 x 75 -100 µm)	150-175 microns (130-150 µm 1 Visit)
Dry Film Thickness:	90-110 microns	90-110 microns (70-80 µm 1 Visit)

DRYING TIMES



at 20°C

Dust Free
 Touch Free
 Tape Free
 Handleable
 Hard Dry

20 mins (or 15 mins with Fast Hardener)
 3 hours (or 2 hours with Fast Hardener)
 6 hours (or 3 hours with Fast Hardener)
 8-10 hours (or 5-6 hours with Fast Hardener)
 1 day (or overnight with Fast Hardener)

Stoving:

30 minutes @ 50°C (according to film thickness)



Overcoating time:

Minimum: when Hard Dry
 Maximum: 1 month by itself without sanding

Note:

Lower temperature or DFT higher than 100µm will extend drying times

STRUCTURED / TEXTURED FINISH

A structured / textured finish can be achieved with Selemix Direct Pro using the following process.

1. Apply a first coat of 7-15X as normal, ensuring that the film thickness is sufficient to cover and protect the substrate.
2. Allow 30 mins flash-off time at 20C
3. Mix the 7-15X Direct Pro 3:1:0-0.2 with 9-15X Hardener and 1-155 Thinner
 More thinner will give a finer texture and less thinner will give a coarser texture.
4. Apply a coat using a gravity gun with a 1.8-2.5mm tip at 0.1-0.3 Bar pressure
 Lower pressures will give a coarser texture, higher pressures, a finer texture
5. Air dry, or allow 15 mins flash-off before baking.

FLEXIBILISING

Selemix Direct Pro can be flexibilised to give improved flexibility and mechanical properties

Mixed Colours in 7-51X Direct Pro are mixed 1000 : 20 by weight with 6-115 Flexible Additive (2% by weight). The Selemix Direct Pro should then be activated and thinned as normal.

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:
 Theoretical coverage at 100 microns DFT:
 Theoretical coverage at 100 microns DFT:
 Theoretical solvent emission per sq. m at 100 microns DFT:
 Gloss:

Conventional Spray

437-464 g/L
 59-65%
 50-52%
 35-41%
 1.12-1.24
 5.0-5.2 m²/L
 4.0-4.6 m²/Kg
 84-93 g per m²
 Gloss

Air-Assisted Airless Spray and Plural Mix

370-433 g/L
 62-71%
 52-59%
 29-38%
 1.13-1.14
 5.2-5.9 m²/L
 4.6-5.2 m²/Kg
 63-83 g per m²
 Gloss

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
7-168/E15K	7-168	Direct Pro Customized Gloss Binder	15	K
7-168/E150K	7-168	Direct Pro Customized Gloss Binder	150	K
9-158/E1	9-158	Fast Hardener For Acrylic	1	Lt
9-158/E5	9-158	Fast Hardener For Acrylic	5	Lt
9-154/E1	9-154	Medium Hardener For Acrylic	1	Lt
9-154/E5	9-154	Medium Hardener For Acrylic	5	Lt
9-152/E1	9-152	Slow Hardener For Acrylic	1	Lt
9-152/E5	9-152	Slow Hardener For Acrylic	5	Lt
1-159/E5	1-159	Reactive Thinner For Acrylic	5	Lt
1-160/E5	1-160	Slow Reactive Thinner For Acrylic	5	Lt
6-115/E1	6-115	Flexible Additive	1	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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