

TECHNICAL DATASHEET

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SELEMIX® 2K POLYURETHANE DIRECT TOPCOATS 7-538 / 7-539

PRODUCT DESCRIPTION

Selemix 2K Polyurethane Direct Gloss Topcoat is a versatile, high solids 2-pack PU finish that can be applied directly to a variety of substrates giving gloss levels of approximately 80-85% without need for a primer, giving a very efficient process.

It is suitable for application by a wide range of methods, and has good adhesion to a wide variety of substrates including steel, galvanized steel, aluminium and GRP. It has a gloss finish and 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

7-538 *Selemix* 2K Polyurethane Direct Gloss 80% Mixed Colour

7-539 *Selemix* 2K Polyurethane Direct Gloss 80% Light Colours (for white and pastel colours)

Note: Gloss levels are within +/- 10% depending on colour

Hardeners:

9-070 Direct Hardener
 9-080 Acrylic Hardener
 9-075 HS Direct Hardener

Thinners:

1-470 Slow Direct Thinner
 1-480 Direct Thinner
 1-490 Accelerated Direct Thinner

Additive:

6-550 Accelerator for Direct

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 / Cast Iron

Machine sand with P80-120 discs and degrease

Galvanised steel

Abrade with SCOTCHBRITE® and degrease

Aluminium / Light Alloys

Machine sand with P240-320 discs and degrease

GRP

Machine sand with P240 discs and degrease

Plastics (PA, PC, ABS, PC/ABS, PMMA, PVC, PP*)







Abrade with SCOTCHBRITE® and degrease
 *PP must be flame treated before coating

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.


The speed of drying can be increased with use of 1-490 Thinner, or 6-550 Accelerator (added at 1-2%) but these can reduce the final gloss and shorten the potlife. Use of 1-490 Thinner AND 6-550 together is not recommended. Use of 1-490 Thinner or 6-550 when applied directly to aluminium is not recommended.

	Features: Standard System	Conventional	Air-Assisted Airless
	By Weight: 7-538 / 7-539 Topcoat 9-070 / 9-080 Hardener 1-480 / 1-470 / 1-490 Thinner	1000 200 200 - 250	1000 200 40-90
	By Volume: 7-538 / 7-539 Topcoat 9-070 / 9-080 Hardener 1-480 / 1-470 / 1-490 Thinner	4 1 1.2 – 1.5 (30-38%)	4 1 0.2-0.5 (5-12%)
	Viscosity (at 20°C): Pot Life (at 20°C):	20-25 secs DIN4 3 hours 1-2 hours with 1-490 Thinner	25-35 secs DIN4 2-3 hours 1-2 hours with 1-490 Thinner
	Features: 9-075 HS Hardener	Conventional	Air-Assisted Airless
	By Weight: 7-538 / 7-539 Topcoat 9-075 Hardener 1-480 / 1-470 / 1-490 Thinner	1000 130 170-220	1000 130 110-150
	By Volume: 7-538 / 7-539 Topcoat 9-075 Hardener 1-480 / 1-470 / 1-490 Thinner	6 1 1.5-2 (25-30%)	6 1 1-1.3 (15-20%)
	Viscosity (at 20°C): Pot Life (at 20°C):	20-25 secs DIN4 2-3 hours 1-2 hours with 1-490 Thinner	25-35 secs DIN4 2-3 hours 1-2 hours with 1-490 Thinner

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm	Nozzle: 11-13 thou 0.28-0.33mm
	Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	2-3 Bar
	Fluid Pressure:	N/A	100 Bar
	Number of coats:	2	1-2
	Flash-off between coats:	15-20 mins	15-20 mins
	Drying:	Air dry or bake at 60°C for 45 mins	Air dry or bake at 60°C for 45 mins
	Flash-off before bake:	5-10 mins	5-10 mins
	Wet Film Thickness:	160-200 microns	160-200 microns
	Dry Film Thickness:	80-100 microns	80-100 microns

DRYING TIMES

	Dust Free	60 mins
	Touch Free	1.5-2 hours
at 20°C	Tape Free	24 hours
	Handleable	6-10 hours
	Hard Dry	24 hours
	Stoving:	45 minutes @60°C (according to film thickness)
	Overcoating time:	Minimum: when Hard Dry Maximum: 5 months by itself without sanding If 6-550 Accelerator or 1-490 Fast Hardener are used, it can be recoated with itself up to 24 hours without sanding.
	Note:	Lower temperature or film thickness higher than 100µm will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner (depending on colour):	Conventional Spray 4:1:1.2 mix 9-070 / 1-480	Air Assisted Airless Spray 6:1:1 mix 9-075 / 1-480
VOC (g/L):	510-519 g/L	438-481 g/L
Solid content (weight):	55-59%	63-66%
Solid content (volume):	41-42%	49-50%
Solvent content (weight):	41-45%	34-37%
Specific gravity (Ready for use)	1.16-1.24 Kg/L	1.20-1.30 Kg/L
Theoretical coverage at 100 microns DFT:	4.1-4.2 m ² /L	4.9-5.0 m ² /L
Theoretical coverage at 100 microns DFT:	3.3-3.6 m ² /Kg	3.8-4.2 m ² /Kg
Theoretical Solvent emission per sq. m at 100 microns DFT:	121-127 g per m ²	88-98 g per m ²
Gloss:	Gloss 80% +/- 10%	

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.775.3800/E4.25K	7-538	Direct Gloss 80% Topcoat	4.25	Kg
1.775.3800/E17K	7-538	Direct Gloss 80% Topcoat	17	Kg
1.775.3900/E4.75K	7-539	Direct Gloss 80% Topcoat Light Colours	4.75	Kg
1.775.3900/E19K	7-539	Direct Gloss 80% Topcoat Light Colours	19	Kg
1.991.5070/E1	9-070	Direct Hardener	1	Lt
1.991.5070/E5	9-070	Direct Hardener	5	Lt
1.991.5070/E25	9-070	Direct Hardener	25	Lt
1.959.5080/E1	9-080	Acrylic Hardener	1	Lt
1.959.5080/E5	9-080	Acrylic Hardener	5	Lt
1.959.5080/E25	9-080	Acrylic Hardener	25	Lt
1.991.5075/E5	9-075	Direct HS Hardener	5	Lt
1.991.5075/E25	9-075	Direct HS Hardener	25	Lt
1.959.5080/E5	9-080	Acrylic Hardener	5	Lt
1.959.5080/E25	9-080	Acrylic Hardener	25	Lt
1.991.1470/E5	1-470	Slow Direct Thinner	5	Lt
1.991.1480/E5	1-480	Direct Thinner	5	Lt
1.991.1480/E25	1-480	Direct Thinner	25	Lt
1.991.1490/E5	1-490	Accelerated Direct Thinner	5	Lt
1.991.1490/E25	1-490	Accelerated Direct Thinner	25	Lt
1.965.5000/E1	6-550	Direct Accelerator	1	Lt
1.965.5000/E5	6-550	Direct Accelerator	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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