

## TECHNICAL DATASHEET

Issue date:  
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# SELEMIX® 2K WB ACRYLIC SINGLE STAGE TOPCOAT 8-110 High Gloss 8-111 Matt

## PRODUCT DESCRIPTION

*Selemix* 8-110 (Gloss) and 8-111 (Matt) are 2K waterborne acrylic coatings, suitable for direct application to well-prepared steel, galvanized steel, phosphate steel, or aluminium surfaces exposed to weathering, mechanical and chemical stress, for both interior and exterior use.

It provides from high gloss to matt finish, with excellent gloss and colour retention and excellent hardness. It is especially recommended for high quality finishes in industrial agricultural equipment and machinery.

## PRODUCTS

8-110	<i>Selemix</i> WB Acrylic Single Stage Topcoat High Gloss
8-111	<i>Selemix</i> WB Acrylic Single Stage Topcoat Matt
WBxx	<i>Selemix</i> Waterborne Tinters

### Hardeners

9-110	Hardener for Acrylic Single Stage
9-125	Fast Curing Hardener for Acrylic

### Thinner:

Water	Water should be drinkable quality, or deionized water.
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## SUBSTRATES AND PREPARATION






Steel	Machine sand with P80-120 discs and degrease
Phosphated Steel	Abrade with Scotchbrite® and degrease
Galvanised steel	Abrade with Scotchbrite® and degrease
Light Alloys	Machine sand with P280-320 discs and degrease
Aluminium	Machine sand with P280-320 discs and degrease
GRP	Machine sand with P280 discs and degrease
Painted Surfaces	Machine sand with P240-320 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 – STANDARD MODE

Thoroughly Mix Paint before activating and check colour before use.




	Features	Conventional	Air-Assisted Airless
	<b>By Weight:</b> 8-11x Topcoat 9-110 Hardener	1000 400 Thoroughly mix topcoat during 5 minutes and then add:	1000 400 Thoroughly mix topcoat during 5 minutes and then add:
	Water	150 - 300	50 - 150
	<b>By Volume:</b> 8-11x Topcoat 9-110 Hardener	2.5 1 Thoroughly mix topcoat during 5 minutes and then add:	2.5 1 Thoroughly mix topcoat during 5 minutes and then add:
	Water	0.4 - 0.75 (15-30%)	0.13 - 0.4 (5-15%)
	Viscosity (at 20°C):	55-60 secs DIN4	100-120 secs DIN4
	Pot Life (at 20°C):	3 hours	2 hours

## APPLICATION – STANDARD MODE




	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.6 - 1.8 mm Suction: 1.8 - 2.0 mm Pressure feed: 1.2 - 1.4mm	Nozzle: 9 - 11 thou 0.23 – 0.28 mm
	Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	2 - 3 Bar
	Fluid Pressure:	N/A	70 - 150 Bar
	Number of coats:	2 medium	1 Light Dry + 1 Full
	Flash-off between coats:	15-30 mins minimum at 20°C	2 mins minimum at 20°C
	Drying:	Air dry or bake at: 60°C for 45-60 mins or 80°C for 20-25 mins	Air dry or bake at: 60°C for 45-60 mins or 80°C for 20-25 mins
	Flash-off before bake:	45 mins minimum at 20°C	45 mins minimum at 20°C
	Wet Film Thickness:	125-140 microns	125-140 microns
	Dry Film Thickness:	60-80 microns	60-80 microns

## MIXING – FAST CURING

Thoroughly mix paint before activating and check colour before use.

	Features	Conventional 1 Visit	Conventional 2 Coats	Air Assisted Airless
	<b>By Weight:</b> 8-11x Topcoat 9-125 Hardener	1000 400 Thoroughly mix topcoat during 5 minutes and then add:	1000 400 Thoroughly mix topcoat during 5 minutes and then add:	1000 400 Thoroughly mix topcoat during 5 minutes and then add:
	Water	150 - 300	150 - 300	150 - 200
	<b>By Volume:</b> 8-11x Topcoat 9-125 Hardener	2.5 1 Thoroughly mix topcoat during 5 minutes and then add:	2.5 1 Thoroughly mix topcoat during 5 minutes and then add:	2.5 1 Thoroughly mix topcoat during 5 minutes and then add:
	Water	0.4-0.75 (15-30%)	0.4-0.75 (15-30%)	0.4-0.6 (15-20%)
	Viscosity (20°C): Pot Life (20°C):	65-70 secs DIN4 2 hours	55-60 secs DIN4 2 hours	55-60 secs DIN4 2 hours

## APPLICATION – FAST CURING

	Features	Conventional 1 Visit	Conventional 2 Coats	Air Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.4 - 1.6 mm Suction: 1.6 - 1.8 mm Pressure feed: 0.8 - 1.0 mm	Nozzle: Gravity: 1.4 - 1.6 mm Suction: 1.6 - 1.8 mm Pressure feed: 0.8 - 1.0 mm	Tip Size: 04.132/ 05.152/05.172
	Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	HVLP: 2 Bar Standard: 2-3 Bar	Atomization: 3-3.5 Bar
	Fluid Pressure:	N/A	N/A	Paint Pressure: 90-100 Bar
	Number of coats:	1 Light dry + 1 full	1 light closed + 1 medium	1 medium + 1 medium
	Flash-off between coats:	2 mins minimum at 20°C	15-20 mins minimum at 20°C	15-20 mins minimum at 20°C
	Drying:	Air dry or bake at 60°C for 30 min	Air dry or bake at 60°C for 30 min	Air dry or bake at 60°C for 30 min
	Flash-off before bake:	20 mins minimum at 20°C	20 mins minimum at 20°C	15-20 mins minimum at 20°C
	Wet Film Thickness:	125-150 microns	125-150 microns	125-150 microns
	Dry Film Thickness:	60-80 microns	60-80 microns	60-80 microns

## OTHER APPLICATION MODES



### Features

### Brush and Roller

8-11x Topcoat can be applied by brush (solvent resistant) or roller short haired mohair roller.

Activate 2.5:1 with 9-110/9-125 Hardener. Thinning with 10% of water is recommended.

Apply in 2 coats with minimum 45 minutes flash-off between coats.

## MATTING CHART (All Colours)

	Tinting Ratio (by weight):	
<b>High Gloss</b>	Binder 8-110:	60
	WB Tinters:	40
<b>Semi-Gloss (~70%)</b>	Binder 8-111:	36
	Binder 8-110:	24
	WB Tinters:	40
<b>Semi-Matt (~30%)</b>	Binder 8-111:	48
	Binder 8-110:	12
	WB Tinters:	40
<b>Matt (15-20%)</b>	Binder 8-111:	60
	WB Tinters:	40

## DRYING TIMES



at 20°C

Features	STANDARD MODE	FAST CURING MODE
Dust Free:	20 - 25 mins	10 - 15 mins
Touch Free:	5 - 6 hours	2 - 3 hours
Handleable:	8 - 9 hours	6 hours
Hard Dry:	24-36 hours	Overnight
Stoving:	45-60 minutes at 60°C (according to film thickness)	30 minutes at 60°C (according to film thickness)
Overcoating Time:	Minimum: 8 hours Maximum: 24 hours without sanding on clean surface with itself	Minimum: 8 hours Maximum: 24 hours without sanding on clean surface with itself
Note:	Lower temperatures or film thickness higher than 80µm 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):	140-198 g/L
Solid content (weight):	40-59 %
Solid content (volume):	36-50 %
Theoretical coverage:	5 - 7 m <sup>2</sup> per litre at 70 microns DFT
Specific gravity (Ready for use)	1.04-1.19 Kg/L

Gloss: High 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	
1.781.1000/E12K	8-110	WB Acrylic Single Stage Topcoat High Gloss	12	Kg
1.781.1100/E12K	8-111	WB Acrylic Single Stage Topcoat Matt	12	Kg
1.781.1100/E120K	8-111	Single Stage Topcoat Matt	120	Kg
1.959.8110/E5	9-110	Hardener for Acrylic	5	Lt
1.959.8125/E5	9-125	Fast Curing Hardener for Acrylic	5	Lt
1.959.8125/E200	9-125	Fast Curing Hardener for Acrylic	200	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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