

TECHNICAL DATASHEET

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SELEMIX® DIRECT PRO HIGH GLOSS 7-159

PRODUCT DESCRIPTION

Selemix Direct Pro High 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 has a high 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

7-159 *Selemix* Direct Pro High Gloss Mixed Colour

Hardeners:

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

Thinners:

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

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	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 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: 7-159 Topcoat 9-15x Hardener 1-159 / 1-160 Thinner	1000 330 100 - 200	1000 330 50 - 100
	By Volume: 7-159 Topcoat 9-15x Hardener 1-159 / 1-160 Thinner	2.5 1 0.3 – 0.5 (10-20%)	2.5 1 0.1 – 0.3 (5-10%)
	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: Air Pressure: (refer to spraygun manufacturer) Fluid Pressure:	Nozzle: Gravity: 1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm HVLP: 2 Bar Standard: 2.5-3 Bar N/A	Nozzle: 09-11 thou 0.23-0.28mm 2.5 Bar 100 Bar
	Number of coats: Flash-off between coats:	2 15 mins	2 (or 1 Visit) 15-20 mins (or 2 mins for 1 Visit)
	Drying: Flash-off before bake: Wet Film Thickness: Dry Film Thickness:	Air dry or bake at 50°C for 30-45 mins 10-15 mins 150-175 microns (2 x 75 -100 µm) 90-110 microns	Air dry or bake at 50°C for 30-45 mins 10-15 mins 150-175 microns (120-130 µm 1 Visit) 90-110 microns (70-80 µm 1 Visit)

DRYING TIMES



at 20°C

Dust Free
Touch Free
Tape Free
Handleable
Hard Dry

Stoving:

Overcoating time:

Note:

20 mins (or 15 mins with Fast Hardener)
3 hours (or 2 hour with Fast Hardener)
6 hours (or 3 hours with Fast Hardener)
8-10 hours (or 5-6 hours with Fast Hardener)
16 hours (or 12-14 hours with Fast Hardener)

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

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

Lower temperature or film thickness 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 7-159 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 7-159 Direct Pro 2.5:1:0-0.5 with 9-15X Hardener and 1-159 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.

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	Conventional Spray	Air-Assisted Airless Spray
VOC (g/L):	367-407 g/L	338-381 g/L
Solid content (weight):	63-70%	66-73%
Solid content (volume):	55-60%	58-63%
Solvent content (weight):	30-37%	27-34%
Specific gravity (Ready for use)	1.11-1.24 Kg/L	1.12-1.25 Kg/L
Theoretical coverage at 100 microns DFT:	5.5-6.0 m ² /L	5.8-6.3 m ² /L
Theoretical coverage at 100 microns DFT:	4.4-5.4 m ² / Kg	4.6-5.6 m ² / Kg
Theoretical solvent emission per sq. m at 100 microns DFT:	61-70 g per m ²	54-66 g per m ²
Gloss:	High Gloss	High Gloss

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
7-159/E3.75K	7-159	Direct Pro High Gloss	3.75	Kg
7-159/E15K	7-159	Direct Pro High Gloss	15	Kg
9-152/E1	9-152	Slow Hardener For Acrylic	1	Lt
9-152/E5	9-152	Slow 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
9-158/E1	9-158	Fast Hardener For Acrylic	1	Lt
9-158/E5	9-158	Fast 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

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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