

Name **BINDER EXTRA ACRYLIC DTM SATIN**
Definition: **Two-pack acrylic enamel**
Code: **6J.3.K1**

Category: **2K high performance A/j**
V.O.C (ready to use): **600 g/l**
V.O.C. limit: 500 g/l
Product according to 2004/42/CE

NATURE OF THE PRODUCT

Two-pack acrylic-urethane topcoat, based on hydroxylated acrylic resins and aliphatic isocyanic adduct to mix before use.

GENERAL USES

Product for high quality applications on machines tools, operating and agricultural machines, furniture and plastics.

Suitable for use with direct adhesion on metals and plastics. Considering the variety of commercially available materials, we strongly recommend doing preliminary tests¹. To improve the adhesion on metal we suggest acid washing with our OG.044 thinner and diluting the product with the same thinner.

If special yellowing resistance to and to exposure to atmospheric agents is required, we recommend using the anti-UV additive OC.007, at 1.5-3% (calculated by weight on the product without hardener).

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle.

This means that the presence of grease, oils, dirty, rust and calamine on the surfaces is absolutely not allowed.

- **Ferrous surfaces:** SA2 1/2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents.
- **Galvanized sheet:** accurate sanding by using scotch brite coarse grain, then degreasing with solvents. Otherwise, accurate degreasing with our thinner OG.115 or OG.044, and final cleaning with silicone remover OG.051. The use of acidic thinners such as OG.044, slow, and OG.115, quick, improve greatly the adhesion performance on this surface, especially if, contrary to what is specified above, it has been sanded short before.
- **Aluminum:** accurate sanding followed by careful degreasing with our thinner OG.115 or OG.044, and final cleaning with silicone remover OG.051. When it is not possible to sand the surface, the use of acids thinners such as OG.044, slow, and OG.115, quick, improves greatly the adhesion performance on this surface. For this application we suggest using the additive OC.040 (3% to 5% by weight in the product without hardener, an excess can give a slight haze in the gloss colors). Nevertheless, we suggest testing the adhesion on a sample before proceeding with large applications.
- **Plastics²:** elimination of any molding release agents. Sanding with brown scotch brite followed by accurate degreasing with suitable solvents. We suggest testing the adhesion on a test sample before proceeding with large applications.

If conditions require the use of a primer, we recommend: Acrylic Primer , Epoxy primer 21.3 series, . Follow the surface preparation instructions given in the TDS of the selected primer.

¹ To improve the adhesion on metal we recommended using the additive OC.040 at 3-5% (calculated by weight on the product without hardener, an excess can give a slight haze in the gloss colors).

² Considering the big variety of plastics, we recommend performing some preliminary tests.

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PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	6J.3.K1(Tinted)	Binder Extra Acrylic DTM Satin	100 part	100 part
Component B	0A.014	Activator Standard	20 parts	25 parts
As an alternative	0A.012	Activator Slow	20 parts	25 parts

Carefully mix until an even color and consistency are obtained. Dilute with our polyurethane thinner 0G.013 in a percent of 10-15% to obtain a viscosity of 23-28" Ford 4 (at temperatures over 25°C use 0G.030 thinner and also 0A.012 hardener).

APPLICATION

Spray gun:	nozzles of 1,4-1,7 mm. diameter and 3-5 atm. pressure
Airless	Nozzle 0,09 inches, 180-240 bar
Electrostatic spray gun:	suitable
Roller or brush ³ :	only for large surfaces

TECHNICAL DATA

PRODUCT TYPE:	Two pack product	
FILM APPEARANCE (ASTM D 523):	Semi matt, 30±5 gloss	
COLOURS:	On request, (the binder 6J.3.K1 must be used in a binder/tinters ratio of 80/20 with the tintometric system tinters).	
SPECIFIC WEIGHT (iso 2811):	1,25 kg/L (±0,10)	
SUPPLY VISCOSITY (DIN 53211):	30" ± 5" Ford 8	
SOLID ON VOLUME:	A+B 48% (±2%)	
SOLIDS CONTENT:	A+B 60% (± 3%).	
DRYING AT 20°C	Dust dry:	20-30 minutes
	Touch dry:	4 hours
	Total Hardening:	24 hours
	Forced drying	30-40 minutes at 60-80°C
	Maximum chemical resistance:	After 7 days
RECOMMENDED COATS:	One light coat and one standard coat	
RECOMMENDED THICKNESS:	40-60 µm	
THEORETIC YIELD ⁴:	10 m ² /kg	

³ You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tools

⁴ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

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POT-LIFE AT 20° C: 6 hours. At higher temperatures, pot-life decreases

REPAINTING: After minimum 6 hours. After total hardening, it is better a light sanding before overcoating.

STORAGE STABILITY: One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.