

Name **BINDER ACRYLIC DTM SEMIGLOSS**  
Definition: **Industrial acrylic 2K enamel**  
Code: **6B.2.K1**

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

### **Nature of this product:**

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

### **General Uses**

Product for general use, furniture, machines tools, coach work, industrial applications, marine sector, industrial finishes, concrete coatings, doors and windows frames, plastics, etc.

Suitable for direct adhesion applications on metals and plastics. Considering the variety of commercially available materials, we strongly recommend doing preliminary tests<sup>1</sup>. 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 and weathering resistance are required, we recommend using the anti UV Additive OC.007 at 1.5-3%.

### **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.

The product shows direct adhesion on metals<sup>2</sup> without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before.

- 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 thinners OG.115 or OG.044, and final cleaning with silicone remover. The use of acidic thinners such as OG.044, Slow and OG.115, quick, improve greatly the adhesion performance on this substrate.
- Aluminium: Accurate sanding followed by careful degreasing with our thinner OG.115 or OG.044 and final cleaning with silicone remover. When it is not possible to sand the surface, the use of acids thinners such as, slow OG.044, 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 colours). Nevertheless, we suggest testing the adhesion on a sample before proceeding with large applications.
- Plastics<sup>3</sup>: 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 our epoxy primer 2I.3 Series or our acrylic primer.*

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<sup>1</sup> To improve the adhesion on metal we recommended using the right additive 0C.040 at 3-5% (calculated by weight on the product without hardener, an excess can give a slight haze in the gloss colors).

<sup>2</sup> If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

<sup>3</sup> Considering the big variety of plastics, we recommend performing some preliminary tests.

## Preparation of the product

	code	Name	By Weight	By Volume
Component A	6B.2.K1(TINTED)	<b>BINDER ACRYLIC DTM SEMI GLOSS</b>	100 parts	100 parts
Component B	0A.014	<b>ACTIVATOR STANDARD</b>	20parts	25 parts

Carefully mix until an even colour and consistency are obtained. Dilute at 5-15% with our thinners 0G.013. With temperature over 25°C we suggest using the slow hardener and thinner 0G.094 or 0G.075 with the same ratio as the standard versions.

## Application

Spray gun: nozzle of 1,4-1,7 mm. diameter and 3-5 atm. pressure.  
Airless: nozzle 0,09 inches, 180-240 bar  
Roller or brush<sup>1</sup>: Only for large surfaces

## Technical data

**Product Type** Two pack product

By request (the binder **6B.2.K1** has to be used in a ratio **75/25** with the tintometric system tinters).

**Film Appearance:** Semigloss, 60±8 gloss (60° angle)

**Specific Weight** (ISO 2811): 1,23 g/cm<sup>3</sup> (±0,07)

**Supply Viscosity:** 85KU at 25°C (±5) for component A

This information is based on our present knowledge and is intended to provide information about our products and their employment opportunities. They are not intended therefore to provide certain specific properties of the products or their fitness for specific application. We guarantee the quality of our product under our conditions of sale.

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**Solid Content:** A+B 50% ( $\pm$  3%).

**Drying at 20°C**

Dust dry:	20-30 minutes
Touch dry:	2-4 hours
Total hardening:	24 hours
Forced Drying	30' mins at 60°C
Maximum chemical resistance:	After 7 days

**Recommended coats:** One or two crossed coat

**Thickness<sup>2</sup>:** 60 - 90  $\mu$ m

**Theoretic Yield<sup>3</sup>:** 8m<sup>2</sup>/kg

**Pot-Life at 20°C:** 4 hours at 20°C. At higher temperatures, pot-life decreases.

**Repainting:** Wet on wet (within 15') or after minimum 6 hours. After complete hardening of the film, it is better a light sanding before over-coating

**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.

<sup>4</sup> You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tools

<sup>5</sup> Considering a dry film.

<sup>6</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.