

Name **BINDER ACRYLIC DTM MATT**
Definition: **Industrial acrylic 2K enamel**
Code: **6B.4.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 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 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 The product shows direct adhesion on metals² without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before positive result of the painting cycle.

- **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.
- **Aluminum:** 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**³: 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.

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

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

³ 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	6B.4.K1(TINTED)	BINDER ACRYLIC DTM MATT	100 parts	100 parts
Component B	0A.014	ACTIVATOR STANDARD	20parts	25 parts

Carefully mix until an even colour and consistency are obtained. Dilute with our polyurethane thinner 0G.013 in a percent of 5-15% (at temperatures over 25°C use slow thinner 0G.030 and also slow hardener 0A.012) to obtain a viscosity of 20"-25" Ford 4 at 20°C.

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 brush⁴: Only for large surfaces

Technical data

Product Type Two pack product

By request (the binder 6B.4.K1 has to be used in a ratio 80/20 with the tintometric system tinters).

Film Appearance: Semi matt, 15±5 gloss (60° angle)

Specific Weight (ISO 2811): 1,25 g/cm³ (±0,07)

Supply Viscosity: 115KU @ 25°C

Solid Content: A+B 62% (± 3%).

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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	
Thickness⁵:	60 - 90 µm	
Theoretic Yield⁶:	6-8 m ² /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.	

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

⁵ Considering a dry film.

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