Name: **BINDER ACRYLIC DTM STRUCTURED**
Definition: **Industrial acrylic 2K enamel**
Code: **6B.6.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 THE 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[1]. To improve the adhesion on metal we suggest acid washing with our 0G.044 thinner and diluting the product with the same thinner.
If special yellowing and weathering resistances are required, we recommend using the anti-UV additive 0C.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.

The product shows direct adhesion on metals[2] 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 thinner 0G.115 or 0G.044, and final cleaning with silicone remover 0G.051. The use of acidic thinners such as 0G.044, slow, and 0G.115, quick, improve greatly the adhesion performance on this surface.
- Aluminum: Accurate sanding followed by careful degreasing with our thinner 0G.115 or 0G.044, and final cleaning with silicone remover 0G.051. When it is not possible to sand the surface, the use of acids thinners such as 0G.044, slow, and 0G.115, quick, improves greatly the adhesion performance on this surface. For this application we suggest using the additive 0C.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.
- 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: Acrylic Primer , Epoxy Primer 2I.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 0C.040 at 3-5% (calculated by weight on the product without hardener, an excess can give a slight haze in the gloss colors).
[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.6.K1	Binder Acrylic DTM Structured (TINTED)	100 part	100 part
Component B	0A.014	Activator Standard	20 part	25 part
In alternative	0A.012[4]	Activator Slow	20 part	25 part

Carefully mix until an even color and consistency are obtained. For airless application no dilution is requested. For standard application with air mix spry gun dilute at 5-10% with our 0G.013 polyurethane thinner to obtain a smooth appearance, no dilution or maximum 5% to obtain an embossed effect.

APPLICATION

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

TECHNICAL DATA

PRODUCT TYPE:	Two pack product	
FILM APPEARANCE (ASTM D 523):	Semigloss, 50±5 gloss	
COLOURS:	By request (the binder 6B.6.K1 has to be used in a ratio 80/20 with the tintometric system tinters)	
SPECIFIC WEIGHT (ISO 2811):	1,34 kg/L (± 0,07).	
SUPPLY VISCOSITY (DIN 53211):	40" Ford 8 a 25° C. (±10”).	
SOLID ON VOLUME:	A + B 42% (± 2%)	
SOLIDS CONTENT:	A + B 57% (± 3%).	
DRYING AT 20°C	Dust dry:	20-30’
	Touch dry:	4-6 hours
	Total hardening:	24 ours
	Forced drying	30’ at 60°C
	Maximum chemical resistance:	After 7 days
RECOMMENDED COATS:	One crossed coat of diluted product to obtain a smooth and even film. After 2-8 hours, apply one coat of product not diluted to obtain the embossed effect.	
THICKNESS [6]:	60-90 μm	

[4] For temperatures above 25°C in combination with slow thinner 0G.030
[5] You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tools
[6] Considering a dry film.

Name:**ACRYLAC INDUSTRIAL DTM ENAMEL,EMBOSSED**
Definition: **Industrial acrylic 2K enamel**
Code: **62.6**

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

THEORETIC YIELD [7]:	6-8 m^2/kg
POT-LIFE AT 20° C:	2 hours at temperature of 20° C. At higher temperatures, pot-life decreases
REPAINTING:	Wet on wet (within 15') or after 2>8 hours for the embossed effect. 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.

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