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Name **BINDER UHS ACRYLIC DTM 420 GLOSS**  
Definition: **Acrylic two pack enamel**  
Code: **6FA.1.K1**

Category: **Top Coat**  
V.O.C.limit: **420 g/l**  
V.O.C (ready to use): **390\*\* g/l**  
Product according to 2004/42/CE  
\*\*only if applied without dilution

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### **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 applications on direct adhesion and high dry film thickness. It is suitable for general use, machines tools, coachwork, marine sector, industrial applications, concrete applications, doors and windows-frames, plastics, earthmover, containers, etc.

Suitable for use with direct adhesion 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 0G.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 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<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:** no sanding, but careful 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, especially if, contrary to what is specified above, it has been sanded short before.
- **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<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: Epoxy primer 2I.3 series or Acrylic primer . Follow the surface preparation instructions given in the TDS of the selected primer.

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<sup>1</sup> 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).

<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.

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### PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	6FA.1.K1 (TINTED)	BINDER DTM UHS GLOSS	100 parts	100 parts
Component B	0A.H3	ACTIVATOR HS STANDARD	20 parts	25 parts
	0A.014	ACTIVATOR STANDARD	25 parts	30parts

Carefully mix until an even color and consistency are obtained. For airless application no dilution is required, for standard airmix application dilute with our polyurethane thinner 0G.013 at 10-15%, using 0A.014 hardener, to obtain a viscosity of 6-8" Ford 8.

### 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<sup>4</sup>: only for large surfaces

### TECHNICAL DATA

**PRODUCT TYPE:** Two pack product  
**FILM APPEARANCE (ASTM D523):** Gloss, 85±5 gloss  
**COLOURS:** On request (the binder 6FA.1.K1 must be used in a binder/tinters ratio of 70/30 with the tintometric system tinters)  
**SPECIFIC WEIGHT (ISO 2811):** 1,25 g/cm<sup>3</sup> A (±0,07)  
**SUPPLY VISCOSITY :** 8000 CPs at 25°(±2000).  
**SOLID ON VOLUME:** 59%±3% ready to use  
**SOLIDS CONTENT:** A + B 68% (± 3%).  
**DRYING AT 20°C**  
Dust dry: 20-30 minutes  
Touch dry: 4-6 hours  
Total hardening: 24-36 hours  
Maximum chemical resistance: After 10 days  
**RECOMMENDED COATS:** Minimum two crossed coat  
**THICKNESS <sup>5</sup>:** from 100 µm up to 300 µm  
**THEORETIC YIELD <sup>6</sup>:** 3-8 m<sup>2</sup>/kg  
**POT-LIFE AT 20° C:** 3 hours at temperature of 20° C. At higher temperatures, pot- life decreases.

<sup>4</sup> You may need Antifoam additive 03.009 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.

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**REPAINTING:**

From 30' to 6 hours with itself. Otherwise wait 24 hours then, after a previous light sanding, the product can be over-coated.

**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.