



BICELLINE

$\frac{3}{4}$ gloss

PRODUCT CODE: 4153

Description

BICELLINE Gloss is a very fast-drying spray enamel based on cellulose and alkyd resins.

Features

- very fast-drying
- excellent gloss retention
- good hardness
- available in all colours
- resistant to yellowing
- scratch-resistant
- for interior use

Uses

For various industrial applications in the woodworking and metalworking sectors.
For furniture and limited serial production.

Specifications

(tinted product at 20°C)

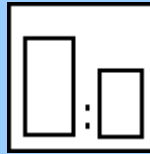
Finish	: gloss
Gloss level (60°)	: approx. 60 – 80%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 9.8 m ² /l at 30 µm dry film thickness
Specific gravity	: 1.03 g/ml
Solids content	: 41% wt. / 29% vol.
Flash point	: 7°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 610 g/l
Shelf life in can	: min. 1 year in original unopened packaging (5 – 25°C)

APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and free of grease and rust.
First sand old and intact paint layers.



Mixing ratio

See BICCS recipes for the addition of colour pastes.

Hardener

see Additional Information



Viscosity and thinning

BICCS Thinner 0104
20 – 50%

Air spray

Nozzle 1.2 – 1.5, 3 to 4 bar
18 – 22 sec. DIN cup 4

Airless

Nozzle 0.009"- 0.011"
110 – 130 bar
30 – 50 sec. DIN cup 4



Spraying instructions

If necessary, multiple cross-coats.

Recommended film thickness:

Min. 130 µm wet
Min. 30 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0104



Drying times

Touch-dry	approx. 10 minutes
Tack free	approx. 20 minutes
For re-spraying	after 20 minutes or after sanding of cured layer
For sanding	approx. 12 hours
Cured	approx. 24 hours

Data at 20°C and 65% RH



Substrates

Old substrates after checking
Bichothane Filler Primer
Bipox primers and Corr-O-Cryl Adhesive Primer
2K Wash Primer

Additional Information

Suitable for many purposes, thanks to rapid drying.
Higher scratch resistance and better chemical resistance can be obtained by adding Bichodur 2K Hardener.
The mixing ratio Bicelline : Bichodur 2K Hardener is 6 : 1 by volume.
This will limit the potlife to 4 hours.

Safety

See the appropriate safety sheet

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INDUSTRIAL COATING & COLOURANT SYSTEMS

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