



BICHOLUX HB Coating SM

PRODUCT CODE: 1156

Description

BICHOLUX HB Coating SM is a high solids, high build coating based on medium oil alkyd resins.

Features

- fast-drying
- can be applied in thick layers
- good protection through high film thickness

Uses

For industrial applications such as machinery, container manufacture and steel construction.

Specifications

(tinted product at 20°C)

Finish	: semi-matt
Gloss level (60°)	: approx. 35%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 6.3 m ² /l at 70 µm dry film thickness
Specific gravity	: 1.17 g/ml
Solids content	: 62% wt. / 45% vol.
Flash point	: 26°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 446 g/l
Shelf life in can	: min. 1 year in original unopened packaging (5 – 25°C)

Substrates

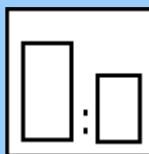
Intact existing paint layers
Steel
Bicholux Primer
Bipox HB Midcoat and Corr-O-Cryl Adhesive Primer
Bicholux QD Primers
Bichothane 1K PU Filler Primer

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

n.a.



Viscosity and thinning

BICCS Thinner 0101 or 0102
0 – 10%

Air spray

Nozzle 2.5 – 3.0, 3 to 5 bar
30 – 60 sec. DIN cup 4

Airless

Nozzle 0.013"– 0.015"
160 – 200 bar
40 – 60 sec. DIN cup 4



Spraying instructions

If necessary, multiple cross-coats.

Recommended film thickness

Min. 145 µm wet
Min. 70 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

Touch-dry	approx. 2 hours
Tack free	approx. 4 hours
For re-spraying	after initial drying, but within max. 5 hours.
For sanding	hours.
Cured	after thorough curing approx. 7 days

Data at 20°C and 65% RH



Additional Information

For faster hard drying, a maximum of 4% Bicholux Hardener may be added. The potlife is then approx. 8 hours.
Its strong adhesion and high film thickness enables it to be applied directly to grit blasted steel. However, use of a primer is recommended.

Safety

See the appropriate safety sheet

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INDUSTRIAL COATING & COLOURANT SYSTEMS

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