



BICHOLUX QD HAMMERTONE ENAMEL

PRODUCT CODE: 1291

Description

BICHOLUX QD HAMMERTONE ENAMEL is a fast-drying effect finish based on alkyd resin combined with aluminium pigments and silicone oils.

Features

- fast-drying
- attractive hammertone effect
- effective camouflaging
- high abrasion-resistance
- also applicable as 2K system

Uses

For industrial applications, machine parts, tools, container manufacture and steel structures. Also applicable as 2 component system, in combination with a hardener; see page 2.

Specifications

(at 20°C)

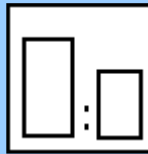
Finish	: satin gloss
Gloss level (60°)	: approx. 40 to 60 (for 2K)
Colour	: 15 standard colours as per swatch. Other colours on request.
Theoretical coverage	: approx. 10.3 m ² /l at 40 µm dry film thickness
Specific gravity	: 0.97 g/ml
Solids content	: 47% wt. / 41% vol.
Flash point	: 23°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 513 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

n.a., see additional information



Viscosity and thinning

BICCS Thinner 0102
0 – 5%

Air spray

Nozzle 1.3 – 1.8, 3 to 4 bar
25 – 40 sec. DIN cup 4

Airless

Nozzle 0.009"– 0.011"
110 – 130 bar
40 – 60 sec. DIN cup 4



Spraying instructions

Spray a thin base coat, followed by 1 – 2 cross-coats.

Recommended film thickness

Min. 105 µm wet
Min. 40 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

Touch-dry	approx. 30 minutes
Tack free	approx. 60 minutes
For re-spraying	after thorough curing and a good sanding
For sanding	after thorough curing
Cured	approx. 7 days; when used as 2 component coating, 24 hours

Data at 20°C and 65% RH



Substrates

1. Intact existing paint layers
2. Bicholux (QD) and Bichothane primers
3. Bipox HB Midcoat and Corr-O-Cryl Adhesive Primer
4. 2K Wash Primer

Additional Information

Improved mechanical resistance can be obtained by adding Bichothane 2K PU Extra Hardener in the ratio 5 : 1 by volume. Besides increased mechanical resistance, this will improve chemical resistance and hardness.

Additional possibilities to enable stacking of workpieces, e.g. for series production. The potlife is then approx. 4 hours.

Safety

See the appropriate safety sheet

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The information provided in this product information sheet is based on accurate testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by BICCS, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge.

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INDUSTRIAL COATING & COLOURANT SYSTEMS

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