



# BICHOLUX QD SPRAY ENAMEL

## gloss

**PRODUCT CODE: 1253**

### Description

BICHOLUX QD Spray Enamel is a very fast-drying spray enamel based on short oil alkyd resins.

### Features

- very fast-drying
- excellent gloss retention

### Uses

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

### Specifications

(tinted product at 20°C)

Finish	: gloss
Gloss level (60°)	: approx. 90%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 11.4 m <sup>2</sup> /l. at 40 µm dry film thickness
Specific gravity	: 1.13 g/ml
Solids content	: 59% wt. / 46% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.V.
VOC content	: 469 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

### Substrates

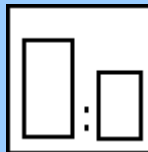
- Intact existing paint layers
- Bicholux QD Primers
- Bipox HB Midcoat and Corr-O-Cryl Adhesive Primer
- Bichothane 1K PU Filler Primer

### 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 0102  
10 – 20%

#### Air spray

Nozzle 1.2 – 1.5, 3 to 4 bar  
18 – 25 sec. DIN cup 4

#### Airless

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

#### Tool cleaning

Washing thinner or BICCS thinner 0102



#### Spraying instructions

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

#### Recommended film thickness

Min. 95 µm wet  
Min. 40 µm dry.

#### Drying times

Touch-dry	approx. 15 minutes
Tack free	approx. 30 minutes
For re-spraying	after initial drying, but within max. 4 hours
For sanding	approx. 72 hours
Cured	approx. 7 days



Data at 20°C and 65%



## Additional Information

For faster hard drying, a maximum of 4% Bicholux Hardener may be added. The potlife is then approx. 8 hours.

## Safety

See the appropriate safety sheet

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## INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.