



# BICHOLUX QD SPRAY ENAMEL

## satin gloss

**PRODUCT CODE: 1252**

### Description

BICHOLUX QD SPRAY ENAMEL satin gloss is a very fast-drying spray enamel based on short oil alkyd resins.

### Features

- very fast-drying
- good filling power
- high abrasion-resistance

### Uses

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

### Specifications

(tinted product at 20°C)

Finish	: satin gloss
Gloss level (60°)	: approx. 40%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 11.2 m <sup>2</sup> /l at 40 µm dry film thickness
Specific gravity	: 1.27 g/ml
Solids content	: 64% wt. / 45% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 455 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-sprayed layers.

#### Recommended film thickness:

Min. 90 µm wet  
Min. 40 µm dry.



#### Drying times

Touch-dry	approx. 30 minutes
Tack free	approx. 60 minutes
For re-spraying	after initial drying, but within max. 4 hours
For sanding	approx. 48 hours
Cured	approx. 72 hours

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

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