



# BICHOLUX SPRAY ENAMEL

## high gloss

**PRODUCT CODE: 1153**

### Description

BICHOLUX SPRAY ENAMEL high gloss is a fast-drying spray enamel based on medium oil alkyl resins.

### Features

- excellent gloss retention
- cures to a hard finish
- especially high outdoor durability

### Uses

For industrial applications such as machinery and steel structures.

### Specifications

(tinted product at 20°C)

Finish	: high gloss
Gloss level (60°)	: approx. 95%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 10.8 m <sup>2</sup> /l at 40 µm dry film thickness
Specific gravity	: 1.08 g/ml
Solids content	: 58% wt. / 43% vol.
Flash point	: 40°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 452 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

### Substrates

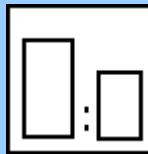
Intact existing paint layers  
Bicholux Primer  
Bipox HB Midcoat and Corr-O-Cryl Adhesive Primer  
Wash Primer 2K  
Bichothane 1K PU Filler Primer  
Bicolux QD Primers

### 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  
5 - 15%

#### Air spray

Nozzle 1.2 – 1.5, 3 to 4 bar  
18 – 30 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. 95 µm wet  
Min. 40 µm dry.

#### Tool cleaning

Washing thinner or BICCS thinner 0102



#### Drying times

Touch-dry	approx. 60 minutes
Tack free	approx. 3 hours
For re-spraying	wet in wet or after curing
For overcoating	approx. 24 hours
For sanding	approx. 48 hours
Cured	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.

## 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.