



BICHOLUX SPRAY ENAMEL

satin gloss

PRODUCT CODE: 1152

Description

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

Features

- 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	: satin gloss
Gloss level (60°)	: approx. 40%
Colour	: using BICCS colour mixing system
Theoretical coverage	: approx. 11.2 m ² /l. at 40 µm dry film thickness
Specific gravity	: 1.2 g/ml
Solids content	: 63% wt. / 45% vol.
Flash point	: 40°C
Application conditions	: min. 5°C / 80% R.V.
VOC content	: 441 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

Substrates

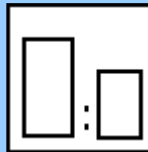
Intact existing paint layers
Bicholux Primer
Bipox HB Midcoat and Corr-O-Cryl Adhesive Primer
Bichothane 1K Filler primer
Bicholux QD Primers

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
Tack free
For re-spraying
For sanding
Cured

approx. 60 minutes
approx. 3 hours
approx. 24 hours
approx. 48 hours
approx. 72 hours

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

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