



# BICHOLUX QD HB SYSTEM-COATING GLOSS

*High build 1K 'primer and topcoat in one' based on alkyd resins*

## Description

Bicholux QD HB System-Coating Gloss [1257] is a solvent based very fast-drying 1C high build 'DTM-coating' (Direct To Metal) gloss based on short oil alkyd resins.

When this 'Direct to Metal' paint system is used on steel, it functions both as a primer as well as a top coat. This is a great advantage. Because of its high build characteristics one applies sufficient film thickness in only one go.

Significant savings compared to a conventional two-layer primer/topcoat system!

## Properties

- Very efficient: primer and topcoat in one
- Very fast drying
- Good filling power
- Anti-corrosive properties
- High build; can be applied easily in thick layers
- By adding a hardener obtains a 2C coating with high mechanical and chemical resistance (see overleaf for more information)
- Bicholux QD products are lead and chromate free
- Available in all colours by the BC-S 8200 CMS

## Typical Applications

Suitable for various industrial applications such as machinery, containers, steel and other constructions.

## Substrates

- Steel
- Grit blasted steel
- Intact old paint layers

(Please note: NOT suitable for non-ferrous metals)

## Technical Specifications

(ready mixed product at 20°C)

Finish	: gloss
Gloss level (!)	: ca. 55% (depending on colour)
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 4,3 m <sup>2</sup> /ltr. at 100 µm DFT
Specific gravity	: 1,03 g/ml (depending on colour)
Solids content	: 52% by weight / 43% by volume
Flashpoint	: 23°C
Application conditions	: min. 10°C / 80% R.H.
VOC content	: 492 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

## APPLICATION INSTRUCTIONS



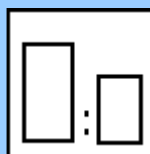
### Pre-treatment

The surface needs to be entirely clean, dry and degreased. Old, intact paint layers need to be abraded/sand papered. Pre-treatment (also) depends on the substrate, but in any way needs to be done in such a way that a solid and suitable substrate is obtained, suitable to be painted.

See the additional info in this sheet. Please contact our Technical Department for further enquiries.

### Application

Spray



### Mixing ratio BC-S Colourants, 8200 series:

Add 10% BC-S Colourants (by volume)

*All available colours Bicholux QD HB System-Coating Gloss [1257] are lead and chromate free.*

### Thinner :

(standard) BICCS Thinner 0102 [9162] or (slow) BICCS Thinner 0103 [9163], ca. 0 – 10%.



### Airspray

Nozzle : 1,8 – 2,5  
Pressure : 3 to 5 bar  
Viscosity : 25 – 40 sec., DIN cup 4

### Airless

Nozzle : 0.011" - 0.013"  
Pressure : 110 – 130 bar  
Viscosity : 40 – 60 sec. DIN cup 4



### Spraying instructions

If necessary, multiple cross-coats.

### Recommended film thickness

Min. 220-335 µm WFT <> 100-150 µm DFT

### Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]



### Drying times

Dust-free : approx. 30 minutes  
Tack-free : approx. 60 minutes  
For re-spraying : after initial drying with both 1C or 2C products  
For sanding : after 48 hours  
Hard drying time : after 7 days

Data at 20°C and 65% RH



## Additional information

Bicholux QD HB System Coating can also be used as two-component coating system by adding:

- BICCS 2C Projecthardener [9086] with mixing ratio 4 : 1 by volume (base:hardener) *or*
- Bichothane 2C-PU Extra Hardener [3381] with mixing ratio 6:1 by volume (base:hardener).

By adding one of the above hardeners the strength of the coating will be influenced positively:

- > hardening and scratch resistance
- > significantly improved sanding
- > solid base for re-painting
- > higher mechanical and chemical resistance.

### **Pay Attention!**

After adding a hardener, you need to take potlife (limited processing time) into account. Because of quality loss, do not use products after expired potlife.

The use of unknown (not BICCS-) 2C hardeners may have a negative effect on the quality of the final product. Therefore we do not recommend the non BICCS hardeners.

Adding a 2C hardener will generally result in a higher gloss level.

## Bicholux QD HB System-Coating is NOT suitable for non-ferrous metals

- (!) Due to variable pigment content of/in the colour pastes, gloss degree of the end product may vary somewhat. Data in our datasheets are based on the average gloss degree of the RAL K7 colours, measured under an angle of 60° according to ISO 2813.

## Pre-treatment

To prevent recurrent corrosion, the object/item needs to be coated immediately after blasting/grinding/degreasing. If there is any doubt about what's beneath the surface and/or about the pre-treatment, you always must do a trial to judge adhesion.

## Application conditions

Data in this publication are based on a temperature of 20°C and a RH of 65%. In case of higher film thicknesses and/or lower temperatures, longer drying times apply. During application and drying, avoid temperatures lower than 10°C and an RH higher than 80%. The temperature of the object to be sprayed must be at least 3°C above dew point. See the dew point -table on the download page of our website ([www.biccs.nl](http://www.biccs.nl)). Good ventilation is required during application and drying.

## Safety

Only for professional use. See the appropriate safety datasheet, downloadable from our website: [www.biccs.nl](http://www.biccs.nl).

*For further enquiries about this product, please contact our laboratory by phone or email.*

The information provided in this product data sheet is based on precision 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. The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. BICCS bv has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of using or referring to this data sheet, except where otherwise agreed in writing.

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