



## DIRECT TO METAL 70

### PRODUCT DESCRIPTION

Commercial Performance Coatings Direct To Metal 70 is a two component polyurethane technology containing anticorrosive pigmentation, which can be applied direct to metal substrates giving a gloss level of approximately 70% at 60°.

It is a high productivity, one layer system that can be applied at high film thicknesses - up to 160µm wet film - with good adhesion to various substrates such as bare steel, aluminium, galvanised steel and fibre reinforced plastic.

Utilizing the SELEMIX® universal tinter system, Commercial Performance Coatings Direct To Metal 70 is available in a range of colours.

### PRODUCTS

Direct To Metal 70 Mixed Colour		DM7
Hardener		DMH10 Direct To Metal Pack B Fast DMH20 Direct To Metal Pack B
Reducers	<i>Cold conditions</i>	PUR10 Polyurethane Reducer Fast
	<i>Normal conditions</i>	PUR20 Polyurethane Reducer Normal
	<i>Hot conditions</i>	PUR30 Polyurethane Reducer Slow
	<i>Very Hot conditions</i>	PUR40 Polyurethane Reducer Extra Slow
Cleaners		971-9119 PROTEC® Metal Conditioner AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

### SUBSTRATES & PREPARATION



Commercial Performance Coatings Direct To Metal 70 can be applied over the following substrates once they have been prepared as follows:



#### SUBSTRATE

Cast Iron  
Bare Steel  
Phosphated Steel  
Galvanized Steel  
Light Alloys  
Aluminium  
Fibre Reinforced Plastic

#### PREPARATION

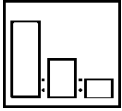
STARTLINE® P80-P120 - dry  
*Startline* P80-P120 - dry, or shot blast  
*Startline* Scourer  
*Startline* P80-P120 - dry  
*Startline* P280-P320 - dry  
*Startline* P280-P320 - dry  
*Startline* P240 - dry

Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

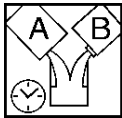
*Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.*

### MIXING RATIO BY VOLUME



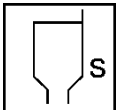
Direct To Metal 70	4	
DMH10 or 20	1	
Reducer	20 - 40%	(by volume)

### POT LIFE



Catalysed material is useable for up to 2 hours at 25°C

### SPRAY VISCOSITY



CONVENTIONAL, HVLP	18 - 25 seconds (DIN 4) at 25°C
AIRLESS, AIR ASSISTED AIRLESS	25 - 32 seconds (DIN 4) at 25°C

### SPRAYGUN



#### CONVENTIONAL, HVLP

##### SETUP

- GRAVITY 1.6 mm - 1.8 mm
- SUCTION 1.6 mm - 1.8 mm

##### SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar



#### AIRLESS, AIR ASSISTED AIRLESS

##### SETUP

- TIP 0.011 - 0.013
- PUMP RATIO 32:1

##### SPRAY PRESSURE

- AIRLESS 100 - 140 bar
- AIR ASSISTED AIRLESS 70 - 100 bar

## APPLICATION & FLASH OFF



CONVENTIONAL, HVLP 2 - 3 wet, even coats  
AIRLESS, AIR ASSISTED AIRLESS 1 - 2 wet, even coats

Allow 10 - 15 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

## DRYING TIMES



### AIR DRY (25°C)

	DMH10	DMH20
• TOUCH DRY:	20 minutes	1 hour
• TACK FREE:	40 minutes	2 hours
• HARD DRY:	24 hours	24 hours

### BAKE (60°C)

30 minutes 45 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

## RECOAT



Can be recoated for up to 7 days without sanding.

If recoating after 7 days the coating must be lightly abraded and degreased prior to painting.

Aged films must be free of chalk and dirt (abraded and degreased) before recoating.

## TOTAL DRY FILM BUILD

60 - 100 µm

## TECHNICAL PARAMETERS

### VOLUME SOLIDS (RFU)

50 - 55%, depending on colour

### COVERAGE

4.2 - 5.6 metres squared per litre (m<sup>2</sup>/L)

### RESISTANCE PROPERTIES

#### WEATHERING

Good

#### ABRASION

Good

#### SOLVENT

Good to splash and spillage for common solvents

#### CHEMICAL

Good to splash and spillage for mild chemicals

#### HEAT

Satisfactory up to 120°C Dry Heat

#### IMMERSION

Not recommended

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## HEALTH AND SAFETY

**Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.**

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.  
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.  
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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