

# 309 TPC-AKD

## 1K Alkyd Topcoat

Resin base: 1-component alkyd resin



<b>Products needed:</b>	Pastes GJ50- Converter GK41-1102 Converter/Pastes 65:35 Thinner SV12-0360 Nitro SV13-0732 Fast SV13-0701 Normal		
<b>Application and properties:</b>	<b>1K Alkyd Topcoat</b> <ul style="list-style-type: none"> <li>• good weathering, yellowing resistance and hardness</li> <li>• good build and flow</li> <li>• brilliant top coat appearance</li> <li>• optimum product properties after 12 days of drying</li> <li>• can be applied directly to steel</li> <li>• min. ambient temp. +15°C for application</li> </ul>		
<b>Substrates/Pre-treatment:</b> Well-cured old paintwork Bare steel Undercoats	<b>Cleaning</b> SV20-0505 SV22-0500 309 TPC-AKD can be used for all Salcomix primers.	<b>Sanding</b> P240-360 P80-150	<b>Final cleaning</b> SV20-0505 SV22-0500
<b>Product details:</b>	Due to different qualities and compounds of steel direct adhesion should always be checked case by case. Glossy 1K Alkyd Topcoat for painting of out- and indoor goods with direct adhesion on steel. Remove corrosion (e.g., rust) by fine sanding or blasting before applying the product. If adjusted with Nitro Thinner SV12-0360 a lower gloss level may occur. Addition of 5-10% Hardener (SC27-0500 / SC29-0863) optimize weathering and drying (Potlife ~4h)		
<b>Special Remark:</b>	It cannot be ruled out that this product contains particles < 0.1 µm The products are suitable for professional use only.		















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**Application:** 1C solid Topcoat

**Remarks:** Values reg. VOC, coverage, solid content and viscosity are based on a mixing ratio by Vol.  
Select thinner acc. ambient temperature and size of object to be painted.

	Paint system	309 TPC-AKD 1K Topcoat				
	VOC	Theor. Coverage at 1 µm (RAL3000/9010)			Solid Content	
	565-605 g/l	375/336 m²/kg		374/367 m²/L	38-48 % Gew.	
	Check Color prior application		Weigh in according to mixing formula (colour):			
	Mixing ratio	309 TPC-AKD	100 % by weight		3 Vol.	
	Hardener	-				
	Thinner	SV12-0360 SV13-0732 SV13-0701	30 % by weight		1 Vol.	
	Viscosity at 23°C DIN 4		Film Thickness (DFT)		Potlife 20°C	Gloss at 60°
	3:1 Vol. 18-22 sec. 4:1 Vol. 22-26 sec.		40-60 µm (2-3 coats) flash off 5-10 min. between		-	> 80
	Application		Viscosity (sec)	Mixing ratio	Spraying Pressure (bar)	Nozzle (mm)
	Compliant Gun		18-22	3:1	< 2,5	1.3-1.6
	HVLP		18-22	3:1	~ 2	1.3-1.7
	Suction Cup		18-22	3:1	2-3	1.3-1.7
	Airless / Airmix		22-26	4:1	120-150	0.23-0.28
	Double Diaphragm or Pressure Pump		18-22	3:1	< 4	1.0
	Brush & Roll					
	Drying at Object Temp.	dust-dry	Touch Dry	Ready for Assembling	trough dry	Recoatable
	20°C	~30 min	18 h	36-48 h	12-15 Days	> 7 days
	60°C	-	30-45 min	60-90 min	-	-