

<b>Designation of type</b>	⇒ DG, DM	State of 4/18
<b>Product description</b>	⇒ 1-component industrial coat with very fast drying and good adhesion to steel ⇒ As single-coat paint or top coating with primer ⇒ Simple processing, good weather resistance ⇒ Glossy or silk-matt available	
<b>Application area</b>	⇒ General industry, protection against corrosion	
<b>Binder</b>	⇒ Modified alkyd-resin	
<b>Substrate/Preparation</b>	⇒ As single-coat paint or on all 1-component primers ⇒ Steel: at least degrease, better hand or eccentric sanding St 2-3 (P80-P220) or sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ Cast iron: sand blasted Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ All surfaces dry, free of fat, oil, grease and dirt	
<b>Processing</b>	⇒ Brushing, rolling undiluted, 0-10 % thinner VS 15 or VS 30; because of the fast drying brush marks are possible ⇒ Gravity feed gun: 1.3-1.7 mm nozzle, 3-4 bar atomisation pressure, 15-20 % thinner VS 15 or VS 30 ⇒ HVLP: 1.4-1,7 mm nozzle, 1.5-2.0 bar atomisation pressure, 10-15 % thinner VS 15 or VS 30 ⇒ Double-diaphragm-pump: 1.0-1.2 mm nozzle, 2.5-3.5 bar atomisation pressure, material pressure 0.8-2.0 bar, 10-15 % thinner VS 15 or VS 30 ⇒ Airmix: 0,28-0,33 mm nozzle, 3-4 bar atomisation pressure, material pressure from 70 bar up, 10-15 % thinner VS 15 or VS 30 ⇒ Airless: from 0.28 mm nozzle up, material pressure from 100 bar up, 5-10 % thinner VS 15 or VS 30 ⇒ Electrostatic: optional adjustable ⇒ Dipping: 30-40 % thinner VS 15 or VS 30 ⇒ For single-coat painting, pre-spray once in difficult-to-reach areas ⇒ Dependent on film thickness 1-2 spraying cycles, 3-6 minutes intermediate flash off time ⇒ Ambient temperature: at least. + 10° C, relative air humidity: max. 75 % ⇒ Object temperature: at least + 5° C and at least 3° C above the dew point	
<b>Viscosities</b>	⇒ Compressed-air spraying: 25- 30 sec. 4 mm / DIN ⇒ Airmix: 40- 50 sec. 4 mm / DIN ⇒ Airless: 70-100 sec. 4 mm / DIN ⇒ Dip: 18- 25 sec. 4 mm / DIN	
<b>Thinner</b>	⇒ VS 15 or VS 30	

<b>Drying time at 20° C</b>	⇒ Tack-free	after approx. 1 hour
	⇒ Ready to installation	after 6-8 hours
	⇒ Complete drying	after a few days
<b>Colours</b>	⇒ All RAL-colours, special colours	
<b>Degree of gloss</b>	⇒ Type DG glossy, Type DM silk-matt	
<b>Specific weight</b>	⇒ Ø 1.25 g/cm <sup>3</sup> (± 5 % dependent on colour)	
<b>Solid matter content</b>	⇒ Ø 62 % (percent by weight; ± 5 % dependent on colour)	
<b>Solvent content</b>	⇒ Ø 38 % (percent by weight; ± 5 % dependent on colour)	
<b>Film thickness</b>	⇒ 40-60 µm dry film thickness / 85-125 µm wet film thickness	
	⇒ At sand blasted to Sa 2½ (roughness depth 45 µm) at least 60 µm dry film thickness	
<b>Theoretical coverage</b>	⇒ Ø 9.5 m <sup>2</sup> /kg at 40 µm dry film thickness	
<b>Practical consumption</b>	⇒ Compressed-air spraying: approx. 0.15 kg/m <sup>2</sup> or 6.7 m <sup>2</sup> /kg at 40 µm dry film thickness	
	⇒ Airless: approx. 0.20 kg/m <sup>2</sup> or 5.1 m <sup>2</sup> /kg at 60 µm dry film thickness	
<b>VOC-value ready to use</b>	⇒ 498 g/l	
	⇒ Limiting value paint material for buildings: 500 g/l	2004/42/IIA(i)(500)498
	⇒ Limiting value industrial coating: no specification Coating of other metal and plastic surfaces	
<b>Standard packaging</b>	⇒ 5 kg / 10 kg / 25 kg	
<b>Shelf life</b>	⇒ At + 10 to + 30° C and unopened packaging 1 year	
<b>Material safety data sheet</b>	⇒ No. 011	
<b>Flash point</b>	⇒ > + 23° C	