TECHNICAL DATA SHEET (TDS)

17-0680-P-SG

Exterior Opaque Topcoat
Semi Gloss
45-50 GU / % at 60°

mighton coatings

PRODUCT DESCRIPTION

Alkyd Resin Water-Borne Gloss opaque Topcoat
for use as midcoat and/or topcoat in conjunction with 17-0576 Primer. Suitable for windows, doors and other dimensionally stable exterior joinery.

TECHNICAL DATA

Viscosity	Approx. 12 d'Pa's(Poises)	at 20°C
Density	1.2	Kg./dm³
Flashpoint	>60°C	Method: Calculation
Solid content	40	% by volume
Theoretical spreading rate	0%	8-10 m²/litre
Storage stability	12 months at	>5°C - 35°C, low R.H

APPLICATION METHOD Spray - Air Assisted, Airless, HVLP or Conventional. Can be brushed but may require minor adjustment.

PRODUCT PREPERATION Ready for use - stir thoroughly before use. Paint Temp >15°C.

ADDITIONAL INFORMATION

Additional Info - Although our recommended method of application is AAA spraying, conventional spraying such as the use of a gravity fed pot gun can be conducted with a 2.5mm fluid tip. It may be necessary to thin down the coating to get good flow through such apparatus. Do not thin by more than 10%.

RECOMMENDED NO. OF COATS:	1-2
REQUIRED WET FILM THICKNESS:	125 µm
MAXIMUM WET FILM THICKNESS:	250µm

SUBSTRATE PREPERATION:

Suitable for all commonly used timber species. Timber moisture content should be between 12 and 16%. The substrate must be clean, dry and free from dust, dirt, grease, silicone and wax prior to sanding. For further guidance and information see additional information on Page 2.

OTHER INFORMATION:

Cleaning	Clean tools and equipment with warm water or Glycol
Thinning	Avoid if possible, water if needed
Storage	Frost free, good airflow, not in direct sunlight.
Shelf Life	Up to 12 Months
Safety Info	Please see Safety Data Sheet
VOC content	42 g/l (TR) 38 g/l (White)

MAIN PROPERTIES

- KOMO Certified
- Good UV Protection
- Good outdoor durability
- Fast drying
- Good weather resistance

MINIMUM RECOMMENDED SETTINGS

Air Assisted Airless (AAA)

Minimum pump size 15:1

Fluid Pressure:	50 psi @ 30:1
Air Assistance:	30 psi @ 30:1
Tip Size (Thou.):	11 to 13
Filter size	150

Airless

Fluid Pressure:	1500psi
Tip Size (Thou.):	12

Conventional

Fluid Pressure:	Compliant
Tip Size (mm):	2.5mm

DRYING TIMES

Drying at : 20°C and relative humidity of 65%

Dust free	:	**30 mins**
Handle	:	**2-3 Hours**
Sanding	:	**3-4 Hours**
Overcoat	:	**4-5 Hours**
Stack	:	**12-24 Hours**

Drying and Curing Conditions:
Maintain a minimum temperature of 16°C throughout drying and curing. During the initial critical drying phase, ensure at least 18°C, humidity ≤65%, with good air circulation.

*** Additional use of catalytic IR heating can speed up drying process if applied after dust free period.**