

Technical Data Sheet
AK DTM 230
Direct Alkyd Topcoat 1K

RELATED PRODUCTS

THIN 50



Universal thinner,
slow, standard, and fast



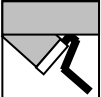


USE:

- The Direct Alkyd Topcoat 1K is intended for coating steel and cast iron. Requires no priming.

PROPERTIES

- Primer and topcoat in one
 - UV-resistant
- Good anti-corrosion properties

SUBSTRATES				
Steel and cast iron	The steel/cast iron substrate shall be dry and free of oils, grease, dust, loose old coatings, milling scale, loose rust, and foreign bodies. The surface shall exhibit a bare metallic gloss. Mat smooth and shining metallic surfaces with P120 sand paper to produce sufficient substrate roughness.			
Old coatings	Mat down and degrease. Test coat a small area of the old coating. If the dry coat finish is unsatisfactory, remove the old coating completely and pretreat the substrate as instructed above.			
Note: Dry sanding generates dust. Proper respiratory protection is recommended.				
MIXING RATIO				
	Coating method	Product	Volume ratio	Weight ratio
	Rollers or brushes	AK DTM 230	-	-
	Pneumatic spraying	AK DTM 230 THIN 50 Universal thinner	100 0 ÷ 6%	100 0 ÷ 5
	Airless spraying	AK DTM 230	-	-
VISCOSITY				
	DIN 4/20°C Pneumatic spraying	35 ÷ 45 s		
COLOURS				
All colours available in the Novol Industrial mixing system.				
VOC CONTENT				
VOC II/A/i limit*		500 g/l		
Actual VOC		440 g/l		
* For ready to use mixture applied with brush or roller acc. to EU Directive 2004/42/EC				
APPLICATION CONDITIONS				
<ul style="list-style-type: none"> - The substrate shall be dry. - Min. product temperature: +10°C. - The coat, coated surface, and ambient temperatures must be between +5°C and +30°C. - The relative humidity must not exceed 80%. - Do not coat at high humidity (e.g. when rain, snow, or fog is possible), on hot afternoons and/or in strong wind. <p>The application conditions determine the product layer drying time, and the developed coating properties. The substrate temperature shall be 3°C higher than the ambient dew point, or more.</p>				

APPLICATION				
 CAUTION: Follow the equipment manufacturer's guidelines	Pneumatic spraying	Nozzle	Pressure	Distance
		1.8 ÷ 2.2 mm	2 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.33 ÷ 0.38 mm (0.013" ÷ 0.015")	100 ÷ 120 bar Air jacket 2 bar	10 ÷ 15 cm
	Brush	Natural bristle brushes or natural and synthetic bristle brushes are recommended.		
	Roller	Velour and mohair rollers are recommended.		
The spray application parameters depend on the individual performance and requirements of the tool, and must be tested prior to coating. Caution! Verify that all corners and edges have been properly coated. Depending on the roller type, the coating may result in air bubbles which burst and form craters during drying.				
	Recommended number of layers	1 ÷ 2 Apply in more layers on complex shapes to produce a homogeneous coating thickness.		
	Overall wet layer thickness:	80 - 100 µm		
	Overall dry layer thickness:	40 - 55 µm		
	The yield of the ready-to-use mixture for the specified range of dry film thickness:	10 m ² /l at 50 µm		
	Time to recoat	Recoat in 1-5 h.		
TECHNICAL DATA				
Solids content by weight		55 ÷ 65%		
Solids content by volume		48 ÷ 52%		
Density		Depending on the colour, 1.2 - 1.3 g/cm ³		
Gloss		Semi-matt		
Adhesion, PN-EN ISO 2409		0 ÷ 1		
Flexibility, PN-EN ISO 1519		min. 10		
Impact strength, PN-EN ISO 6272-1		max 25		

Corrosion resistance, salt spray test, PN-EN ISO 9227	Good anti-corrosion properties	
Water resistance, PN-EN ISO 2812-2	intermittent, not resistant to permanent submersion	
Chemical resistance	Intermittent (splashes and sprays)	
DRY LEVELS		
	PN-C 81519	Time
Dust-free	Level 1	20 minutes
Tack-free	Level 3	40 minutes
Ending hardness	Level 6	24 hours
CAUTION: The drying time may vary with temperature and/or humidity.		
EQUIPMENT CLEANING		
THIN 50 universal thinner or NC solvent.		
STORAGE CONDITIONS		
Store in a dry and cool room, away from sources of fire and heat at 5-25°C. Avoid exposure to sunlight.		
SHELF LIFE		
AK DTM 230	12 months/20°C	
THIN 50 Universal thinner	24 months/20°C	
SAFETY		
See the Safety Data Sheet.		
OTHER INFORMATION		
Registration number: 000024104.		
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions, and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final results were affected by factors beyond our control.		