

Derilux 33

Topcoat with anti-corrosive pigments (zinc-phosphate or aluminium pigment) on alkyd resin basis

- Field of application**
- Protection against corrosion for iron and steel
 - Topcoat for low rust protection requirements, if required applicable as an one-coat paint system
 - Not suitable for coating of metals for interior use according to the deco paint directive.

- Product properties**
- Recoatable with itself

Technical Specification

Colours	RAL 9006 , RAL 9006/9007 (mar resistance).
Flash point	>23 °C
Temperature stability	Up to 120 °C
Gloss	Mat, appr. 5 U in 85° angle
Potential dry film thickness in one working process	40 up to 60 µm
Viscosity	Appr. 25 sec running time (DIN 6 mm pot)
Density in kg/l	1,11
Solid content in %	54
Solid volume in %	42
Theoretical spreading capacity	<ul style="list-style-type: none"> • 10,5 m²/l at 40 µm DFT • 9,46 m²/kg at 40 µm DFT
Recommended film thickness	100 µm WFT corresponds to 40 µm DFT
Drying (DIN EN ISO 1517)	40 µm DFT
Dust-dry (Tg1)	After 90 min
Touch-dry (Tg4)	After 5 h
Dry (Tg6)	After 24 h
Interval for overcoating	<ul style="list-style-type: none"> • after 5 h with itself
Note	<ul style="list-style-type: none"> • The specifications are based on standard atmospheric conditions 23/50, DIN 50014. • Lower temperatures and/or higher humidity will prolong drying and hardening.

Safety information (See Security Data Sheet)

VOC-level	Appr. 510 g/l
Solvent content	Appr. 46 % by weight
Aromatic content	Appr. 40 % by weight

Storage

- Storage**
- In dry, cool rooms, if possible frost-proof
 - Ensure good ventilation
- Shelf life**
- 6 month from date of delivery when in unopened original containers in cool and dry conditions

Application methods

- Airless spraying**
- Flow pressure 180 bar
 - Nozzle size 0,009 - 0,011 inch (0,23 - 0,28 mm)
 - Spraying angle according to the geometry and size of the object to be laquered

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Compressed air spraying	<ul style="list-style-type: none"> • Spraying pressure 3 - 5 bar • Nozzle size 1,5 - 2 mm • Adjust to spraying viscosity (appr. 30 s DIN 4 mm) adding appr. 8 % KH-Verdünnung (two component products: after mixing)
Electrostatic application	<ul style="list-style-type: none"> • Application is possible, provided that the material is set to the appropriate conductance for the system concerned • It should be noted that, adapting the material to the appropriate conductance for the system concerned, may prolong drying and impair the resistance to corrosion and weathering
Dipping	<ul style="list-style-type: none"> • Can not be applied as delivered
Other methods	<ul style="list-style-type: none"> • Roller and brush application is possible in the quality as delivered
Thinner	<ul style="list-style-type: none"> • Max. 10% KH-Verdünnung
Cleaning	<ul style="list-style-type: none"> • Rinse immediately with KH-Verdünnung • Residues are dissolvable with Derozink-Verdünnung
Preparation of support	<ul style="list-style-type: none"> • Shot blasting to a purity according to SA 2½ • If necessary clean with high pressure-cleaner and turbo-cleaner-solution • Mill scale, welding residues, dust and dirt on the surface which might reduce adhesion have to be carefully and thoroughly removed
General remarks	<ul style="list-style-type: none"> • During coating and drying the humidity should be min. 10 % / max. 85 % • During coating and drying the environmental temperature should be min. 5°C / max. 30°C • Object temperature at least 3° C above dew point.
Example for a system	<ul style="list-style-type: none"> • Primer coat: Derogrund • Finish coat: Derilux 33

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