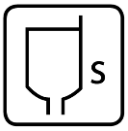
Data sheet

709.TIX90

2K TRANSPARENT ACRYLIC TIXOFILLER

1000 ml +
400 ml +
50 - 100 ml



18″ - 23″ ford 4
at 20°C

Ø 1.3 - 15 mm
4-5 Atm
No. of coats 2

Drying at 20°C: 25′ - 30′
Curing at 70°C: 45′ - 50′

NATURE OF PRODUCT:

Two-component transparent filler primer with thixotropic rheology, characterized by excellent wettability, filling power, fast drying, high gloss and resistance to running.
After complete curing the films are characterized by excellent hardness, weathering and yellowing resistance. Remarkable application flexibility.

FIELD OF APPLICATION:

Thixotropic acrylic primer particularly suitable for painting on carbon fiber. It can also be used as a glossy finish for two-layer systems on water and solvent Base-Coat.

PREPARATION OF THE SUBSTRATE:

Carbon fiber: sanding with P.240 - P.320 followed by cleaning with silicone remover **D.030**

Metal (steel, aluminum, galvanized sheet metal) and plastics: treat with suitable primers

PREPARATION OF THE PRODUCT:

Comp. A:	**709.TIX90**	100 parts by Volume
Comp. B (*):	**CZ.760 (Standard)**	40 parts by Volume
	CZ.770 (Fast)	40 parts by Volume
Alternatively:	**CZ.711 (Standard)**	50 parts by Volume
	CZ.700 (Slow)	50 parts by Volume

Mix component A with stirrer (if possible) until completely homogenized. Possible thixotropic structure of the paint is not an indication of altered quality. The thixotropy index may also differ slightly from batch to batch depending on the storage time elapsed before use.

(*) Hardener and thinner should be chosen according to environmental conditions and/or the size of the piece.
*After catalysis, thin the perfectly mixed mixture with 5-10% of our acrylic thinner **D.737** (Standard) or **D.727** (Slow).*

For high cabin temperatures (> 28°C - 30°C) and/or extensive surface applications, we recommend adding to the paint 3% - 5% of retardant **10304R.**
Also applicable with electrostatic systems; in this case, prefer ***D.727 (Slow).***

TEST QUV PANEL (ASTM G154 cycle 2):

Spray application to a sheet metal with primer and BC/aluminum.

Mixture preparation by weight	*Standard process*
709.TIX90	100
CZ.760	40
D.737	10
Baking	10' A.T. + 1 hour at 60°C
Aging specimen	12 days A.T.
Total thickness (µ)	100
Final gloss (gloss at 60°)	101 +/- 1
Brilliance after 360 hours QUV test	100 +/- 1
ΔE after 360 hours QUV test	1,07 CIELab

BUCHHOLZ Hardness Test BH2000 (EN ISO NF 2815-2003):

Mixture preparation by weight	*Standard process*
709.TIX90	100
CZ.760	40
APPLICATION ON THICK GLASS: 150 µ WET	
Flash off	20' at A.T.
Baking	1h at 70°C
Hardness (BH) after baking	71 BH
Hardness (BH) after 1 day	83 BH
Hardness (BH) after 7 days	95
Casting Limit (µ Wet)	150

XENON TEST (EN ISO 11341:2005):

Spray application to a carbon fiber specimen.

Mixture preparation by weight	*Standard process*
709.TIX90	100
CZ.760	40
D.737	10
Baking	10' A.T. + 1 hour at 70°C
Aging specimen	12 days A.T.
Total thickness (µ)	100
Final gloss (gloss at 60°)	93 +/- 1
Brilliance after 2000 hours XENON TEST	91.5 +/- 0.5
ΔE after 2000 hours XENON TEST	0,3 CIELab

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT	: Two-component	
APPEARANCE OF THE FILM	: Glossy	
COLORS	: Clear	
SPECIFIC WEIGHT	: 0,99 Kg/l (± 0,05)	
SUPPLY VISCOSITY [1]	: 90" (± 10) FORD 4 at 25°C	
DRY RESIDUE (A)	: 52% (± 2%)	
DRYING	: - *Dry dust-free*	: 10′ - 15′ at 20°C
	- *Print-free*	: 5 - 6 hours at 20°C
	- *Forced Drying*	: 45′ at 60 - 70°C
RECOMMENDED LAYERS	: Two full coats with 10′/15' flash off between the 2 coats [2]	
RECOMMENDED THICKNESS	: 50 - 60 micron dry	
THEORETICAL YIELD	: 9 m^2/Lt or Kg at 50 micron dry	
POT- LIFE AT 20°C	: 2 hours. The pot-life decreases at higher temperatures	

It is possible to raise the baking temperature up to 90°C, thus achieving maximum product hardness and strength.

[1] Viscosity values refer to freshly produced paint. During storage this value may increase by as much as several units, this increase depends on the storage time, the temperature conditions of the storage and any temperature changes experienced by the paint during transport. Changes in viscosity up to a maximum of 30% of the initial value are to be considered normal and do not affect the quality of the product in any way.

[2] For carbon fiber applications apply two coats and wait 10′ - 15′ at A.T., then bake for 30′ - 40′ at 40°C and then apply another two coats of **709.TIX90**. Final cooking of 90' at 90°C follows.

RECOATING:

Wet-on-wet after 15′/20′ flash off or after complete curing after sanding with P.400.

SAFETY REGULATIONS:

Strictly follow the instructions on the labeling and in the safety data sheet.

STORAGE CONDITIONS:

The storage room must be dry and with a temperature between +10°C and +30°C.

The data and information contained in this sheet are the result of our experience and accurate laboratory tests. However, since the painting process represents a set of operations that are beyond our control, they do not therefore guarantee, in any way, the final performance of the cycle.

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