

**WC27**
**SOLVEN-BORNE PAINT SYSTEM FOR EXTERIOR WINDOWS AND DOORS**
**DICCO FLEX 30          752-serie**

Solvent -borne system WC27 is elastic paint system for exterior wooden windows and doors. The system is suitable for solid wood windows and HDF-board doors. System consists of only top Dicco Flex 30 coat and separate primer is not needed.

Dicco Flex 30 is two-component acid catalysed elastic top coat for exterior windows and doors. It is thixotropic easy to spray paint with good filling properties and excellent hiding power.

**Typical paint system**

Treatment	Product	Application method	Wet film thickness
Priming	1x Dicco Flex 30	Spraying	125-150 g/m <sup>2</sup>
Top coat	1x Dicco Flex 30	Spraying	125-150 g/m <sup>2</sup>

**PRODUCT PROPERTIES**

**Solid Content**    55 volume-%, 69 weight-%    (752 7221)

**Specific gravity**    1,3 kg/l    (752-s)

**Paint hardener mixing ratio**    752-serie : 006 2098    100:10

**Drying times**

	100–120 /m <sup>2</sup>	+23°C	+50°C
Dicco Flex 30	Dry to sand Dry to stack	24 h 2-3 d	3-4 hours 6-8 hours

Stacking temperature below +35°C.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

**Gloss**    Semi-matt    (752 serie)

**Colors**    Temaspeed Premium tinting    (752 series)

**Application methods**    Airless, air assisted airless and conventional spraying.

**Thinner**    Thinner 1033 (fast), 1027 (normal)

**Cleaning of equipment**    Thinner 1033, 1027

**SURFACE PREPARATION**

Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150–240. All sanding dust must be removed before application.

**APPLICATION CONDITIONS**

During application and drying the temperature of the air, paint and surface should be at least +18°C. The relative humidity should not exceed 70%. Good ventilation is needed during drying process.

**APPLICATION**

Stir the Dicco Flex 30 well and add 10% by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1033 or 1027. Proper spraying viscosity is 20–30 sec (Din4). Spray an even coat (wet film thickness about 125–150 g/m<sup>2</sup>) and let it dry about minimum 24 h (in 20–30°C temperature) and sand the surface carefully with sanding paper grain 320 or 400.

Apply second coat same way as first coat and let it dry minimum 24 h before further processing.

The drying time depends of film thickness, temperature, relative humidity and the air ventilation.

The right nozzle size is 0,011–0,013" and angle 20 or 40 and the spraying distance from object about 20–25 cm.

**MAINTENANCE PAINTING**

Wash down the surface with Maalipesu and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Otex primer well and applicate it according the instructions of the paint. Let it dry and sand lightly. Stir Teho oil paint well and applicate according instructions of the paint and let it dry.

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