



GUIDE FORMULATION

HT018 – *silan free* 1K wb DTM-System (white)
SETAQUA DTM 6850

Based on: "REC19044: one-component glossy white monocoat for Metal"

HT018 - 1K DTM Monocoat (white)

System	REC19045 (allnex)
Color	white
Solids content by weight	54.7 %
Solids content by volume	45.1 %
Pigment : binder ratio	50 : 50
Pigment volume concentration	18.6 %
VOC content	31 g/l
Organic solvent content	2.5 %

HT018 - 1K DTM Monocoat (white)

HT018_1K_AC_wb_DTM_SAQ6850_white_C4E_0120

Amount	Designation	Function
62.20	SETAQUA DTM 6850	acrylic dispersion
<i>under running stirrer</i>		
0.20	Ammonia 25%	neutralizing agent
1.40	Coasol 290 Plus	coalescing solvent
<i>stir well for 20 minutes.</i>		
33.35	Pigment slurry white	
<i>under running stirrer</i>		
1.00	demin. water	
0.20	flashproTAC C4E (for sandblasted or grinded steel 0.30 – 0.40)	flashrust inhibitor
0.20	ADDITOL XW 6585	defoamer
0.20	ADDITOL VXW 6387	anti-setting
0.25	ADDITOL XW 6580	substrate wetting
1.00	ADDITOL VXW 6388 (1 : 10 in water)	PU thickener
100.00	total	

Adjust the application viscosity with demin. water

Pigment slurry HT018

HT018-1_ Pigment slurry white

Amount	Designation	Function
11.70	demin. water	acrylic dispersion
<i>under running stirrer in listed order</i>		
3.25	ADDITOL XW 6588	dispersing additive
1.60	ADDITOL XW 6585	defoamer
3.00	Dowanol DPM	solvent
0.20	Aerosil R 972	rheology control
80.00	Kronos 2310	filler
17.70	Nubirox 102	anti-corrosion pigment
0.25	ADDITOL VXW 6388	PU thickener
<i>15 min. pre-disperse, then 45 min. pearl mill</i>		
100.00	total	