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# SELCHEM

## PE Fibre Body Filler for Zinc Zink-Faserplastic



- »PE Fibre Body Filler Coarse, fibreglass-reinforced
- »For repairing small rust holes
- »Suitable for steel, UP-GF and aluminium
- »Suitable for galvanized substrates

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## TECHNICAL DESCRIPTION

- Mix with 2-3% Selchem Hardener paste potlife 4-5 min/20°C
- Air dry 20-30 min/20°C
- Force drying possible
- Dry sand P36 - P80



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# SELCHEM PE Fibre Body Filler for Zinc

<b>WORKING PROCESS:</b>	Coarse Body Filler
<b>SUBSTRATE:</b>	-Through-hardened sanded paintwork -Bare steel, UP-GF and Aluminium, sanded -Galvanized metal, sanded
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2-3% Selchem Hardener paste potlife 4-5 min/20°C  Apply Stopper  20-30 min/20°C  Short wave 2-3 min Medium wave 5-7 min (see Selchem Painting System S10)  P36 - P80 Flat bed sander Orbital sander  Selchem Stoppers  Selchem Spray Filler

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# SELCHEM PE Fibre Body Filler for Zinc

WORKING PROCESS:	Holes
SUBSTRATE:	-Non-supporting parts of the vehicle
PRETREATMENT/ CLEANING:	For substrate preparation information see Selchem Painting System S1.
Small holes up to approx 1 cm in diameter:  Larger damage:	Fill in and cover area with Selchem PE Fibre Body Filler for Zinc.  Use glassfibre mat(1 -2 mm grid).  This should extend 5 - 10 cm beyond the edges of the repair.  Fill area for repair work with Selchem PE Fibre Body Filler for Zinc. Then press glass fibre mat into freshly applied Selchem PE Fibre Body Filler for Zinc.  After 10 - 20 min/20°C apply Selchem PE Fibre Body Filler for Zinc to the glassfibre mat and spread over the edges.  Sand with P36 - P80

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# SELCHEM PE Fibre Body Filler for Zinc

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
33°C	91,4°F	1,77 g/cm <sup>3</sup>	85,5 Gew.-%	71,4 Vol.-%	257g/Ltr.	2,1 lbs/gal

Raw Material:	Unsaturated Polyester Resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Storage:	Polyester materials have a limited shelf life. Store in a cool place, and use within 12 months for best results.
Important remarks:	<p>For professional use only</p> <p>Do not apply to Etch Primers, 1K Filler, TPA substrates and elastic old paintwork.</p> <p>Do not apply at temperatures below +5°C</p> <p>Mix the 2-3% Selchem Hardener paste well with the stopper. Do not add more as this may cause staining of the topcoat finish.</p>

Hardener paste contains organic peroxide and is corrosive. If Hardener paste comes in contact with the skin, wipe off immediately and wash with soap and water.

After eye contact irrigate copiously with a 2% aqueous sodium carbonate solution or water and seek medical advice.

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# SELCHEM

## PE Soft Stopper Soft-Spachtel



- »Multi-purpose PE Stopper Coarse or Fine
- »Also useable as a Fine Stopper
- »Especially suitable for Infrared drying
- »Excellent vertical hold out
- »Easy to sand
- »Excellent adhesion on all substrates

## TECHNICAL DESCRIPTION

- Mix with 2-3% Selchem Hardener paste potlife 4-5 min/20°C
- Air dry 20-30 min/20°C
- Force drying possible
- Dry sand P80 - P280



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# SELCHEM PE Soft Stopper

<b>WORKING PROCESS:</b>	Coarse and Fine Stopper
<b>SUBSTRATE:</b>	-Through-hardened sanded paintwork -Bare steel, UP-GF and Aluminium, sanded -Galvanized substrate, sanded -Through-hardened 2K Fillers, sanded
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2-3% Selchem Hardener paste potlife 4-5 min/20°C  Apply Stopper  Air dry 15-20 min/20°C  Short wave 2-3 min Medium wave 5-7 min (see Selchem Painting System S10)  Coarse sand P80 - P120 Fine sand P180 - P280  Selchem Primers and Primer Surfaces

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# SELCHEM PE Soft Stopper

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
32°C	89,6°F	1,83 g/cm <sup>3</sup>	85,8 Gew.-%	71,1 Vol.-%	259 g/Ltr.	2,2 lbs/gal

Raw Material:	Unsaturated Polyester Resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Storage:	Polyester materials have a limited shelf life. Store in a cool place, and use within 12 months for best results.
Important remarks:  Un-opened original tins 12 months/20°C	For professional use only  Do not apply to Etch Primers, 1K Filler, TPA substrates and elastic old paintwork.  Do not apply at temperatures below +5°C  Mix the 2-3% Selchem Hardener paste well with the stopper. Do not add more as this may cause staining of the topcoat finish.  Using the Selchem Hardener paste Blue prolongs potlife by 2 min.

Hardener paste contains organic peroxide and is corrosive. If Hardener paste comes in contact with the skin, wipe off immediately and wash with soap and water.

After eye contact irrigate copiously with a 2% aqueous sodium carbonate solution or water and seek medical advice.

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# SELCHEM

## PE Fine Stopper Stando-Soft-Feinplastic



»PE Fine Stopper

»Easy to spread

»Pore-free, fine surface

»Easy to sand, very good feather edging

»Suitable for steel, UP-GF and aluminium

## TECHNICAL DESCRIPTION

- Mix with 2-3% Selchem Hardener paste potlife 4-5 min/20°C
- Do not apply to galvanised substrates
- Force drying possible
- Air Dry 20-30 min/20°C
- Dry sand P180 - P240  
Wet sand P220 - P320



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# SELCHEM PE Fine Stopper

<b>WORKING PROCESS:</b>	Fine Stopper
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>-Through-hardened sanded paintwork</li><li>-Bare steel, UP-GF and Aluminium, sanded</li><li>- Selchem PE Stopper</li><li>- Through-hardened 2K Fillers, sanded</li><li>- Primed hard-plastics</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>2-3% Selchem Hardener paste potlife 4-5 min/20°C</p> <p>Apply Stopper</p> <p>20-30 min/20°C</p> <p>Short wave 2-3 min Medium wave 5-7 min (see Selchem Painting System S10)</p> <p>Dry sand P180 - P240 Wet sand P220 - P320</p> <p>Selchem Primers and Primer Surfaces</p>

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# SELCHEM PE Fine Stopper

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
33°C	91,4°F	1,79 g/cm <sup>3</sup>	83,9 Gew.-%	67,7 Vol.-%	284 g/Ltr.	2,4 lbs/gal

Raw Material:	Unsaturated Polyester Resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Storage:	Polyester materials have a limited shelf life. Store in a cool place, and use within 12 months for best results.
Important remarks:  Un-opened original tins 12 months/20°C	For professional use only  Do not apply to Etch Primers, 1K Filler, TPA substrates and elastic old paintwork.  Do not apply at temperatures below +5°C  Mix the 2-3% Selchem Hardener paste well with the stopper. Do not add more as this may cause staining of the topcoat finish.  On galvanised substrates apply Selchem Rapid/Zink-Rapid Stopper coarse and fine.

Hardener paste contains organic peroxide and is corrosive. If Hardener paste comes in contact with the skin, wipe off immediately and wash with soap and water.

After eye contact irrigate copiously with a 2% aqueous sodium carbonate solution or water and seek medical advice.

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# SELCHEM

## Etching Adhesion Primer Reaktiv-Haftprimer



- » Transparent 2K Acid Primer
- » Excellent adhesion
- » Chromate-free
- » For 3-Stage systems
- » Outstanding corrosion protection

## TECHNICAL DESCRIPTION

- Mix 1:1 with Selchem Etching Adhesion Activator
- Potlife 8 h/20°C
- 2 Spray passes = 8 micron

- Flash off 30 min/20°C



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# SELCHEM Etching Adhesion Primer

<b>WORKING PROCESS:</b>	Acid primer
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>- Bare metal, sanded</li><li>- Aluminium sanded</li><li>- Galvanized metal, sanded</li><li>- Through-hardened sanded paintwork</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>1:1 with Selchem Etching Adhesion Activator potlife 8 h/20°C</p> <p>Ready to spray</p> <p>1.3 - 1.5 mm 3 - 4 bar 2 = 8 micron</p> <p>1.5 - 1.7 mm 3 - 4 bar 2 = 8 micron</p> <p>30 min/20°C</p> <p>Selchem 2K Filler</p>

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# SELCHEM Etching Adhesion Primer

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
26°C	78,8°F	0,96 g/cm <sup>3</sup>	26,0 Gew.-%	14,0 Vol.-%	708 g/Ltr.	5,9 lbs/gal

Theoretical Coverage:	8.8 m <sup>2</sup> /Ltr. at 8 micron dry film thickness
Raw Material:	Polyvinyl butyral , corrosion-resistant pigments
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.5 - 1.7 mm Suction feed 1.7 - 1.9 mm	<ul style="list-style-type: none"><li>- For professional use only</li><li>- Selchem Etching Adhesion Primer must be applied in combination with Selchem 2K Filler in a 3-Stage system.</li><li>- Do not overcoat with PE, EP and Standohyd products.</li></ul>

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# SELCHEM

## 1K Primer Filler



» Suitable with Standohyd Basecoat

» 1K Acid Primer

» Chromate-free

» Wet-on-Wet working process or can be used as a sanding filler

» Outstanding corrosion protection

» Welding certificate

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## TECHNICAL DESCRIPTION

- Suitable as a primer

- 1 Spray pass

- Overcoat with Selchem 2K Filler after 10 - 15 min/20°C flash off

- Suitable as a primer surfacer

- 2 - 3 Spray passes

- dry, denib slightly and repaint



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# SELCHEM 1K Primer Filler

<b>WORKING PROCESS:</b>	Primer
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>- Bare metal, sanded</li><li>- Through-hardened sanded paintwork</li><li>- Repair panel, primed and sanded</li><li>- Selchem PE substrates, sanded</li><li>- Aluminium, sanded</li><li>- Galvanized metal, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	50% Selchem 2K Thinner 18 - 20 s/Din 4 mm/20°C 45 - 53 s/Din 4 mm/20°C  1.4 - 1.5 mm 3 - 4 bar 1 = 15 micron  1.5 - 1.7 mm 3 - 4 bar 1 = 15 micron  10 - 15 min/20°C  Selchem 2K Filler

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# SELCHEM 1K Primer Filler

<b>WORKING PROCESS:</b>	Primer Surfacer
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>- Bare metal, sanded</li><li>- Through-hardened sanded paintwork</li><li>- Repair panel, primed and sanded</li><li>- Selchem PE substrates, sanded</li><li>- Aluminium, sanded</li><li>- Galvanized metal, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>50% Selchem 2K Thinner 18 - 20 s/Din 4 mm/20°C 45 - 53 s/Din 4 mm/20°C</p> <p>1.4 - 1.5 mm 3 - 4 bar 2 - 3 = 30 - 50 micron</p> <p>1.5 - 1.7 mm 3 - 4 bar 2 - 3 = 30 - 50 micron</p> <p>30 - 60 min/20°C depending on film thickness</p> <p>After 45 min/20°C denib lightly or after 90 min/20°C Wet sand P800 - P1000</p> <p>Standocryl 2K/2K HS Topcoat or Selchem Basecoat/Standohyd Basecoat with Standocryl 2K Clears</p>

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# SELCHEM 1K Primer Filler

<b>WORKING PROCESS:</b>	Wet-on-Wet-application
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>- Bare metal, sanded</li><li>- Through-hardened sanded paintwork</li><li>- Repair panel, primed and sanded</li><li>- Selchem PE substrates, sanded</li><li>- Aluminium, sanded</li><li>- Galvanized metal, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>50% Selchem 2K Thinner 18 - 20 s/Din 4 mm/20°C 45 - 53 s/Din 4 mm/20°C</p> <p>1.4 - 1.5 mm 3 - 4 bar 1 - 2 = 20 - 30 micron</p> <p>1.5 - 1.7 mm 3 - 4 bar 1 - 2 = 20 - 30 micron</p> <p>10 - 15 min/20°C depending on film thickness</p> <p>Standocryl 2K/2K HS Topcoat or Selchem Basecoat/Standohyd Basecoat with Standocryl 2K Clears</p>

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# SELCHEM 1K Primer Filler

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
24°C	75,2°F	1,07 - 1,12 g/cm <sup>3</sup>	40,5-44,3 Gew.-%	21,5-23,1 Vol.-%	626-632 g/Ltr.	5,23-5,28 lbs/gal

Theoretical Coverage:	5.4 - 5.8 m <sup>2</sup> /Ltr. at 40 micron dry film thickness
Raw Material:	Polyvinyl butyral , corrosion-resistant pigments
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.5 - 1.7 mm Suction feed 1.7 - 1.9 mm	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- We recommend applying a 3-stage system on galvanized substrates and aluminium.</li> <li>- Do not overcoat with PE and EP products.</li> <li>- Selchem 1K Primer Filler gives steel 3 months weather resistance with a dry film thickness of 50 micron minimum.</li> <li>- Do not dry sand.</li> <li>- IR drying possible 5 min. 50% performance.</li> </ul>

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# SELCHEM

## 1K Body Fine



»1K Fine Stopper

»Fast drying when applied in thin coats

»Pin hole stopper

»Easy to apply

»Easy to sand

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## TECHNICAL DESCRIPTION

- 1K Stopper for primed surfaces

- Wet sand P240 - P400

- Air dry 30-60 min/20°C

- Dry sand P220 - P280



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# SELCHEM 1K Body Fine

<b>WORKING PROCESS:</b>	Fine stopper
<b>SUBSTRATE:</b> Through-sanded areas must be pre-primed.	<ul style="list-style-type: none"><li>- Primed metal, sanded</li><li>- Through-hardened sanded paintwork</li><li>- Selchem PE Stopper</li><li>- Selchem 1K Primer, sanded</li><li>- Selchem 1K/2K Filler, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>If necessary apply several thin coats</p> <p>30-60 min/20°C</p> <p>P220 - P280</p> <p>P240 - P400</p> <p>Selchem Primers and Fillers</p>

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# SELCHEM 1K Body Fine

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
23°C	73,4°F	1,49 g/cm <sup>3</sup>	68,7 Gew.-%	45,0 Vol.-%	464 g/Ltr.	3,9 lbs/gal

Raw Material:	Special blend of alkyd resins.
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:	- For professional use only.

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# SELCHEM

## 2K Primer Red Brown



»Special 2K Primer for passenger cars for further treatment with Selchem Spray Filler

»Chromate-free

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## TECHNICAL DESCRIPTION

- Mixing ratio 4:1 with Selchem 2K Hardener MS
- Potlife 4 h/20°C
- 1 Spray pass
- After 30 min/20°C Selchem Spray Filler
- Force drying possible



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# SELCHEM 2K Primer Red Brown

<b>WORKING PROCESS:</b>	Special Primer for cars
<b>SUBSTRATE:</b> Bare metal substrate and galvanized panels must be pre-primed with acid primer.	- Through-hardened sanded paintwork
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	4:1 with Selchem 2K Hardener MS Potlife 4 h/20°C  If necessary add Selchem 2K Thinner 15 - 18 s/Din 4 mm/20°C 33 - 45 s/ISO 4 mm/20°C  1.4 - 1.5 mm 3 - 4 bar 1 = 15 micron  1.5 - 1.7 mm 3 - 4 bar 1 = 15 micron  30 min/20°C or 10 min/60°C  overcoat with Selchem Spray Filler

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# SELCHEM 2K Primer Red Brown

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
24°C	75,2°F	1,26 g/cm <sup>3</sup>	43,0 Gew.-%	21,5 Vol.-%	716 g/Ltr.	6,0 lbs/gal

Theoretical Coverage:	11.4 m <sup>2</sup> /Ltr. at 20 micron dry film thickness
Raw Material:	Polyurethane
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.5 - 1.7 mm Suction feed 1.7 - 1.9 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- After brush application allow longer flash off time.</li><li>- Sand Selchem 2K Primer Red Brown slightly after air dry overnight/20°C before further treatment.</li><li>- Use as corrosion-protective adhesion promoter below Selchem 2K Fillers is not recommended.</li></ul>

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# SELCHEM

## 2K Transparent Adhesion Sealer



»Transparent 2K Adhesion Promoter

»For unsanded original or through-hardened paintwork

»Especially for an economical overall repaint

»Can be used as a Transparent Filler

»Chromate-free

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## TECHNICAL DESCRIPTION

- Mix 2:1 with all Selchem 2K Hardener MS
- Mix 3:1 with all Selchem 2K Hardener HS

- 1 - 2 Spray passes



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# SELCHEM 2K Transparent Adhesion Sealer

<p><b>WORKING PROCESS:</b></p>	<p>Adhesion promoter</p>
<p><b>SUBSTRATE:</b> Bare metal substrate and galvanized panels must be pre-primed with acid primer.</p>	<p>- Through-hardened unsanded paintwork</p>
<p><b>PRETREATMENT/ CLEANING:</b></p>	<p>For substrate preparation information see Selchem Painting System S1.</p>
<p><b>APPLICATION:</b></p> <p>Use air fed respirator. Refer to relevant Health and Safety Data sheets.</p> <p>3:1 with all Selchem Hardener HS 35% Selchem 2K Thinner It is necessary to allow to flash-off of at least 30 min. before overcoating with Selchem Basecoat in a wet-on-wet system.</p>	<p>2:1 with all Selchem 2K Hardener MS potlife 2 - 3 h/20°C</p> <p>20% Selchem 2K Thinner 15 - 16 s/Din 4 mm/20°C 33 - 37 s/ISO 4 mm/20°C</p> <p>1.3 - 1.4 mm 3 - 4 bar 1 = 15 micron</p> <p>1.5 - 1.7 mm 3 - 4 bar 1 = 15 micron</p> <p>15 min/20°C</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K Transparent Adhesion Sealer

<p><b>WORKING PROCESS:</b></p>	<p>Transparent Filler</p>
<p><b>SUBSTRATE:</b> Bare metal substrate and galvanized panels must be pre-primed with acid primer.</p>	<p>- Through-hardened sanded paintwork</p>
<p><b>PRETREATMENT/ CLEANING:</b></p>	<p>For substrate preparation information see Selchem Painting System S1.</p>
<p><b>APPLICATION:</b></p> <p>Use air fed respirator. Refer to relevant Health and Safety Data sheets.</p> <p>3:1 with all Selchem Hardener HS 35% Selchem 2K Thinner It is necessary to allow to flash-off of at least 30 min. before overcoating with Selchem Basecoat in a wet-on-wet system.</p>	<p>2:1 with all Selchem 2K Hardener MS potlife 2 - 3 h/20°C</p> <p>15% Selchem 2K Thinner 18 s/Din 4 mm/20°C 45 s/ISO 4 mm/20°C</p> <p>1.4 - 1.5 mm 3 - 4 bar 2 = 30 - 40 micron</p> <p>1.5 - 1.7 mm 3 - 4 bar 2 = 30 - 40 micron</p> <p>Air dry 2 - 3 h/20°C or 20 min/60°C Panel temperature</p> <p>Short wave 8 min Medium wave 10 - 12 min (see Selchem Painting System S10)</p> <p>P800</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K Transparent Adhesion Sealer

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
25°C	77,0°F	1,19 g/cm <sup>3</sup>	57,6 Gew.-%	42,8 Vol.-%	502 g/Ltr.	4,2 lbs/gal

Theoretical Coverage:	14.7 m <sup>2</sup> /Ltr. at 30 micron dry film thickness
Raw Material:	Acrylic-Polyurethane
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.6 mm Suction feed 1.6 - 2.2 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- If not overcoated within 24h sand slightly and apply topcoat.</li><li>- Can be used as an adhesion promoter on unsanded substrates with the addition of Selchem 2K Smart Blend.</li><li>- The filler can be mixed with max. 5% Selchem 2K HS Topcoat. Drying and sanding properties will change.</li></ul>

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# SELCHEM

## 2K HS Filler



»High quality 2K Sanding Filler

»High solid product

»Excellent vertical hold out

»Good filling properties

»Easy to Sand

»Chromate-free

## TECHNICAL DESCRIPTION

- Mixing ratio 4:1 with Selchem 2K Hardener MS

- Force drying possible

- Air Dry overnight/20°C



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# SELCHEM 2K HS Filler

<p><b>WORKING PROCESS:</b></p>	<p>2K Sanding Filler with Thinner</p>
<p><b>SUBSTRATE:</b> Pre-prime aluminium and galvanized substrates with acid primer.</p>	<ul style="list-style-type: none"> <li>- Through-hardened sanded paintwork</li> <li>- PE products, sanded</li> <li>- Steel panel, cleaned and sanded</li> <li>- OEM Primer or EDP, sanded</li> <li>- Thermoplastic coatings (TPA)</li> </ul>
<p><b>PRETREATMENT/ CLEANING:</b></p>	<p>For substrate preparation information see Selchem Painting System S1.</p>
<p><b>APPLICATION:</b></p> <p><b>U</b>se air fed respirator. Refer to relevant Health and Safety Data sheets.</p> <p>Flash off 5-10 min/20°C before Oven- or Infrared Drying</p> <p>P800</p>	<p>4:1 with all Selchem 2K Hardener MS potlife 45 - 60 min/20°C</p> <p>10% Selchem 2K Thinner 18-20 s/Din 4 mm/20°C 45-53 s/ISO 4 mm/20°C</p> <p>1.5 - 1.8 mm 3 - 4 bar 2 - 4 = up to 160 micron</p> <p>1.7 - 2.0 mm 3 - 4 bar 2 - 4 = up to 160 micron</p> <p>20 - 30 min/60°C Panel temperature depending on film thickness</p> <p>Short wave 8 - 10 min Medium wave 10 - 12 min (see Selchem Painting System S10)</p> <p>P400 - P500 Orbital sander</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K HS Filler

<p><b>WORKING PROCESS:</b></p>	<p>2K Sanding Filler without Thinner</p>
<p><b>SUBSTRATE:</b> Pre-prime aluminium and galvanized substrates with acid primer.</p>	<ul style="list-style-type: none"> <li>- Through-hardened sanded paintwork</li> <li>- PE products, sanded</li> <li>- Steel panel, cleaned and sanded</li> <li>- OEM Primer or EDP, sanded</li> <li>- Thermoplastic coatings (TPA)</li> <li>- Selchem Primer Surfacer, sanded</li> <li>Selchem Primers</li> </ul>
<p><b>PRETREATMENT/ CLEANING:</b></p>	<p>For substrate preparation information see Selchem Painting System S1.</p>
<p><b>APPLICATION:</b></p> <p><b>U</b>se air fed respirator. Refer to relevant Health and Safety Data sheets.</p> <p>Flash off 5-10 min/20°C before Oven- or Infrared Drying</p> <p>P800</p>	<p>4:1 with all Selchem 2K Hardener MS potlife 45 min/20°C</p> <p>10% Selchem 2K Thinner 25 - 30 s/Din 4 mm/20°C 72 - 91 s/ISO 4 mm/20°C</p> <p>1.5 - 1.8 mm 3 - 4 bar 2 - 4 = up to 250 micron</p> <p>1.7 - 2.0 mm 3 - 4 bar 2 - 4 = up to 250 micron</p> <p>20 - 40 min/60°C Panel temperature depending on film thickness</p> <p>Short wave 8 - 10 min Medium wave 10 - 12 min (see Selchem Painting System S10)</p> <p>P400 - P500 Orbital sander</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K HS Filler

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
24°C	75,2°F	1,56 g/cm <sup>3</sup>	67,9 Gew.-%	43,5 Vol.-%	500 g/Ltr.	4,2 lbs/gal

Theoretical Coverage:	5 m <sup>2</sup> /Ltr. at 80 micron dry film thickness
Raw Material:	Acrylic-Polyurethane, corrosion-resistant pigments
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.6 - 1.9 mm Suction feed 1.8 - 2.6 mm	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- The filler can be mixed with max. 15% Selchem 2K HS Topcoat. Drying and sanding properties will change.</li> <li>- For film thicknesses of more than 150 micron air dry overnight/20°C or 40 min/60°C panel temperature.</li> <li>- Wet sand after 1 - 3 h/20°C, Dry sand after 2 - 4 h/20°C depending on hardener and film thickness</li> <li>- Best sealing properties are obtained even on sensitive surfaces with an intermediate film thickness of 80-120 micron after 2-3 spray passes and air dry overnight/20°C or force dry. A fine pretreatment is necessary and a filler must be applied to complete parts.</li> </ul>

*"Selchem the designers choice"*

# SELCHEM

## 2K HS System Filler



- »Supports HS system
- »Excellent vertical hold out
- »Good filling properties
- »Good isolating properties
- »Chromate-free

## TECHNICAL DESCRIPTION

- Mix 4:1 with all Selchem 2K Hardener HS
- Force drying possible
- Mixing ratio 3:1 with all Selchem 2K Hardener MS
- Air Dry overnight/20°C



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# SELCHEM 2K HS System Filler

<b>WORKING PROCESS:</b>	HS System
<b>SUBSTRATE:</b> Bare metal substrate and galvanized panels must be pre-primed with acid primer.	<ul style="list-style-type: none"><li>- Through-hardened sanded paintwork, except TPA</li><li>- Selchem PE products, sanded</li><li>- UP-GF, sanded</li><li>- OEM Primer or EDP, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.  Flash off 5-15 min/20°C before Oven- or Infrared Drying  P800	<p>4:1 with all Selchem 2K Hardener HS potlife 60-90 min/20°C</p> <p>If necessary add Selchem 2K Thinner 24-26 s/Din 4 mm/20°C 68-76 s/ISO 4 mm/20°C</p> <p>1.5 - 1.8 mm 3 - 4 bar 2 - 3 = max. 250 micron</p> <p>1.7 - 2.0 mm 3 - 4 bar 2 - 4 = max. 250 micron</p> <p>Air dry overnight/20°C 30-40 min/60°C Panel temperature</p> <p>Short wave 10-15 min Medium wave 15-20 min (see Selchem Painting System S10)</p> <p>P400 - P500 Orbital sander</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K HS System Filler

<b>WORKING PROCESS:</b>	MS System
<b>SUBSTRATE:</b> Bare metal substrate and galvanized panels must be pre-primed with acid primer.	<ul style="list-style-type: none"><li>- Through-hardened sanded paintwork, except TPA</li><li>- Selchem PE products, sanded</li><li>- UP-GF, sanded</li><li>- OEM Primer or EDP, sanded</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.  Flash off 5-15 min/20°C before Oven- or Infrared Drying  P800	<p>3:1 with all Selchem 2K Hardener MS potlife 90-120 min/20°C</p> <p>If necessary add Selchem 2K Thinner 19-21 s/Din 4 mm/20°C 49-57 s/ISO 4 mm/20°C</p> <p>1.5 - 1.8 mm 3 - 4 bar 2 - 4 = max. 250 micron</p> <p>1.7 - 2.0 mm 3 - 4 bar 2 - 4 = max. 250 micron</p> <p>Air dry overnight/20°C 30-40 min/60°C Panel temperature</p> <p>Short wave 10-15 min Medium wave 15-20 min (see Selchem Painting System S10)</p> <p>P400 - P500 Orbital sander</p> <p>Selchem 2K HS Topcoat or Selchem Basecoat and Selchem 2K Clears</p>

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# SELCHEM 2K HS System Filler

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
25°C	77,0°F	1,54 g/cm <sup>3</sup>	70,4 Gew.-%	47,5 Vol.-%	456 g/Ltr.	3,8 lbs/gal

Theoretical Coverage:	5.7 m <sup>2</sup> /Ltr. at 80 micron dry film thickness
Raw Material:	Acrylic-Polyurethane
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.5 - 1.9 mm Suction feed 1.8 - 2.2 mm	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- For better control of the sanding process, spray the filler and allow to flash off. Spray a thin coat of Control Black as a guide coat.</li> <li>- The filler can be mixed with max. 15% Selchem 2K HS Topcoat. Drying and sanding properties will change.</li> <li>- For film thicknesses of more than 150 micron air dry overnight/20°C or 40 min/60°C panel temperature.</li> </ul>

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# SELCHEM

## 2K Topcoat



»2K MS Topcoat with optimal gloss and colour retention

»High mechanical and chemical resistance

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## TECHNICAL DESCRIPTION

- Mix 3:1 with all Selchem 2K Hardener HS
- Force drying possible
- Air Dry overnight/20°C
- Mixing ratio 2:1 with all Selchem 2K Hardener MS



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# SELCHEM 2K Topcoat

<b>WORKING PROCESS:</b>	2:1 MS System
<b>SUBSTRATE:</b> Isolate sensitive substrates with Selchem 2K Fillers, preferably Selchem Nonstop Primer Filler	- Through-hardened sanded paintwork - Selchem 1K Primer - Selchem 1K/2K Filler
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2:1 with all Selchem 2K Hardener MS potlife 6 h/20°C  0 - 5% Selchem 2K Thinner 17-19 s/Din 4 mm/20°C 41-49 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 bar 2 = 50 - 60 micron  5 - 10 min/20°C Flash off between coats and final flash off  Air dry overnight/20°C 25 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

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# SELCHEM 2K Topcoat

<b>WORKING PROCESS:</b>	3:1 HS System
<b>SUBSTRATE:</b> Isolate sensitive substrates with Selchem 2K Fillers, preferably Selchem Nonstop Primer Filler	- Through-hardened sanded paintwork - Selchem 1K Primer - Selchem 1K/2K Filler
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	3:1 with all Selchem 2K Hardener HS potlife 6 h/20°C  10% Selchem 2K Thinner 17-19 s/Din 4 mm/20°C 41-49 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 bar 2 = 50 - 60 micron  5 - 10 min/20°C Flash off between coats and final flash off  Air dry overnight/20°C 25 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

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# SELCHEM 2K Topcoat

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
24-34°C	75-93°F		0,98-1,33 g/cm <sup>3</sup>	47,1-68,3 Gew.-%	40,3-51,8 Vol.-%	412-517 g/Ltr.

Theoretical Coverage:	7.3 - 7.6 m <sup>2</sup> /Ltr. at 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 1.8 - 2.2 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- Selchem 2K Topcoat can be used with: Matting, effecting, plasticising and retarding additives</li><li>- Selchem 2K Topcoat can be overcoated within 24 h without intermediate sanding.</li><li>- Allow additional time for heating-up of combi spray booths.</li></ul>

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# SELCHEM

## 2K Crystal Clear



»High quality 2K Clear for panel repair and overall re-sprays

»Excellent flow

»Good filling properties

»Optimum gloss

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## TECHNICAL DESCRIPTION

- Mix 3:1 with all Selchem 2K Hardener HS

- Mixing ratio 2:1 with all Selchem 2K Hardener MS

- Force drying possible

- Air Dry overnight/20°C



*"Selchem the designers choice"*

# SELCHEM 2K Crystal Clear

<b>WORKING PROCESS:</b>	2:1 MS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2:1 with all Selchem 2K Hardener MS potlife 4-5 h/20°C  15% Selchem 2K Thinner 16-18 s/Din 4 mm/20°C 37-45 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 - 5 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 - 5 bar 2 = 50 - 60 micron  5 - 10 min/20°C Final flash off  Air dry overnight/20°C or 20 - 30 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

*"Selchem the designers choice"*

# SELCHEM 2K Crystal Clear

<b>WORKING PROCESS:</b>	3:1 HS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	3:1 with all Selchem 2K Hardener HS potlife 4-5 h/20°C  20% Selchem 2K Thinner 17-18 s/Din 4 mm/20°C 41-45 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 - 5 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 - 5 bar 2 = 50 - 60 micron  5 - 10 min/20°C Final flash off  Air dry overnight/20°C or 20-30 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

*"Selchem the designers choice"*

# SELCHEM 2K Crystal Clear

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
26°C	78,8°F		0,99 g/cm <sup>3</sup>	47,9 Gew.-%	41,3 Vol.-%	513 g/Ltr.

Theoretical Coverage:	7.8 m <sup>2</sup> /Ltr. at 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.5 mm Suction feed 1.8 - 2.2 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- Selchem 2K Crystal Clear can be overcoated within 24 h without intermediate sanding.</li><li>- Selchem 2K Crystal Clear can be used with:<ul style="list-style-type: none"><li>- Selchem 2K Clear Supermatt</li><li>- Selchem 2K Plasticiser</li></ul></li><li>- Allow additional time for heating-up of combi spray booths.</li></ul>

*"Selchem the designers choice"*

# SELCHEM

## 2K Clear 20-60



- »High quality 2K Clear
- »Optimum result with one spray pass
- »Extremely fast drying possible
- »Ideal for air drying
- »Excellent vertical hold out
- »Good filling properties

## TECHNICAL DESCRIPTION

- Mix 3:1 with all Selchem 2K Hardener HS
- Mixing ratio 2:1 with all Selchem 2K Hardener MS
- Ready to spray after addition of hardener

- Force drying possible
- Air Dry overnight/20°C



*"Selchem the designers choice"*

# SELCHEM 2K Clear 20-60

<b>WORKING PROCESS:</b>	2:1 MS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  <b>Use</b> air fed respirator. Refer to relevant Health and Safety Data sheets.  For 2 spray passes add 5% Selchem 2K Thinner.  Allow 5-10 min flash off between coats	2:1 with all Selchem 2K Hardener MS potlife 1.5 h/20°C  Ready to spray, if necessary add Selchem 2K Thinner 18-20 s/Din 4 mm/20°C 45-53 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 1 = 50 - 60 micron (1 working spray pass)  1.5 - 1.7 mm 4 bar 1 = 50 - 60 micron (1 working spray pass)  5 - 10 min/20°C Final flash off  Air dry overnight/20°C or 20 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

*"Selchem the designers choice"*

# SELCHEM 2K Clear 20-60

<b>WORKING PROCESS:</b>	3:1 HS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  <b>Use</b> air fed respirator. Refer to relevant Health and Safety Data sheets.  For 2 spray passes add 5% Selchem 2K Thinner.  Allow 5-10 min flash off between coats	3:1 with all Selchem 2K Hardener HS potlife 1.5 - 2 h/20°C  Ready to spray, if necessary add Selchem 2K Thinner 18-20 s/Din 4 mm/20°C 45-53 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 1 = 50 - 60 micron (1 Working spray pass)  1.5 - 1.7 mm 4 bar 1 = 50 - 60 micron (1 Working spray pass)  5 - 10 min/20°C Final flash off  Air dry overnight/20°C or 20 min/60°C Panel temperature  Short wave 8-12 min Medium wave 12-14 min (see Selchem Painting System S10)

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# SELCHEM 2K Clear 20-60

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
30°C	86,0°F		0,97 g/cm <sup>3</sup>	45,6 Gew.-%	39,4 Vol.-%	530 g/Ltr.

Theoretical Coverage:	7.4 m <sup>2</sup> /Ltr. at 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 1.5 - 1.9 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- Selchem 2K Clear 20-60 can be used with:<ul style="list-style-type: none"><li>-Selchem 2K Clear Supermatt</li><li>-Selchem 2K Plasticiser</li></ul></li><li>- Allow additional time for heating-up of combi spray booths.</li><li>- Selchem 2K Clear 20-60 can be overcoated within 24 h without intermediate sanding.</li></ul>

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# SELCHEM

## 2K Platinum Clear



- »2K Clear for approval work
- »Special 2K MS Clear with reflow effect for improved abrasion properties e.g. automatic car wash machines
- »Durable high gloss for 2-stage finishes
- »Extremely high mechanical and chemical resistance
- »Dedicated 2K Platinum Hardener

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## TECHNICAL DESCRIPTION

- Mix 2:1 with Selchem 2K Platinum Hardener
- Force drying 35-40 min./ 65-70°C panel temperature
- IR drying 20 - 22 min.



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# SELCHEM 2K Platinum Clear

<b>WORKING PROCESS:</b>	
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2:1 with Selchem 2K Platinum Hardener potlife 2.5 h/20°C  Ready to spray 17-18 s/Din 4 mm/20°C 41-45 s/ISO 4 mm/20°C  1.3 (1.2 for small areas) 3.5 - 4 bar 2 = 40 - 60 micron  1.5 - 1.6 mm 3.5 - 4 bar 2 = 40 - 60 micron  5 - 15 min/20°C Intermediate and final flash off Flash-off times subject to booth conditions  35-40 min/65-70°C Panel temperature  20 - 22 min/50% performance with dark colour shades 20 - 22 min/100% performance with light colour shades  Short-wave radiators Distance between panel and radiator 80cm 10-15 min/20°C Intermediate and final flash-off

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# SELCHEM 2K Platinum Clear

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
27°C	80,6°F		0,98 g/cm <sup>3</sup>	53,1 Gew.-%	46,0 Vol.-%	469 g/Ltr.

Theoretical Coverage:	9,02 qm/l with 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 (1.2 for small areas) 2.0 - 2.5 bar  Compliant Gravity feed 1.3 (1.2 for small areas) 2.0 - 2.5 bar	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- Use 2K Platinum Clear with Selchem Selchem Platinum Hardener only.</li> <li>- Higher drying temperatures(65-70°C panel temperature) have to be observed to achieve desired properties.</li> <li>- Special polishing instructions(see Selchem Painting System S12) have to be observed.</li> <li>- Mix Selchem 2K Platinum Clear with Selchem Platinum Hardener, then apply two normal spray passes.</li> <li>- Additives, as for instance matting agents, elastifiers, accelerators and thinners, may not be added.</li> </ul>

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# SELCHEM

## 2K MS Xtra Clear



»High quality high performance  
2K clear

»Multi-application properties for  
- spot repairs  
- part repairs and  
- overall sprays

»Extremely good through-drying

»Very good polishability

»Optimal performance with  
Selchem 2K MS X Hardeners

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## TECHNICAL DESCRIPTION

- Mix 2:1 with all  
Selchem 2K Hardener MS

- Mix 3:1 with all  
Selchem 2K Hardener HS

- Force drying possible

- Air dry overnight / 18-22°C



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# SELCHEM 2K MS Xtra Clear

<b>WORKING PROCESS:</b>	2:1 MS System Part Repair
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<p><b>APPLICATION:</b></p> <p><b>Use</b> air fed respirator. Refer to relevant Health and Safety Data sheets.</p> <p>Overall Respray:</p> <p>Add 5-10% Selchem 2K Thinner = 16 - 18 s/Din 4mm/20°C 37 - 45 s/ISO 4mm/20°C 2 spray passes Allow 5 - 10 min between coats</p> <p>Spot Repair:</p> <p>Add 15 - 20% Selchem 2K Thinner 10-20 12 - 14 s/Din 4mm/20°C 20 - 28 s/ISO 4mm/20°C 2 - 3 spray passes Allow 2 - 3 min between coats Reduce drying time by approx. 5 min</p>	<p>2:1 with all Selchem 2K Hardener MS potlife 2 h/20°C</p> <p>Ready to spray, if necessary add Selchem 2K Thinner 18-20 s/Din 4 mm/20°C 45-53 s/ISO 4 mm/20°C</p> <p>1.3 - 1.4 mm 4 bar 0.5 + 1 = 50 - 60 micron</p> <p>1.5 - 1.7 mm 4 - 5 bar 0.5 + 1 = 50 - 60 micron</p> <p>0 - 10 min/20°C Final flash off</p> <p>Air dry overnight/20°C or 20 min/60°C Panel temperature</p> <p>Short wave 8 - 12 min Medium wave 12 - 14 min (See Selchem Painting System S10)</p>

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# SELCHEM 2K MS Xtra Clear

<b>WORKING PROCESS:</b>	3:1 HS System Part Repair
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  <b>Use</b> air fed respirator. Refer to relevant Health and Safety Data sheets.  <b>Overall Respray:</b>  Add 5-10% Selchem 2K Thinner = 16 - 18 s/Din 4mm/20°C 37 - 45 s/ISO 4mm/20°C 2 spray passes Allow 5 - 10 min between coats  <b>Spot Repair:</b>  Add 15 - 20% Selchem 2K Thinner 10-20 12 - 14 s/Din 4mm/20°C 20 - 28 s/ISO 4mm/20°C 2 - 3 spray passes Allow 2 - 3 min between coats Reduce drying time by approx. 5 min	3:1 with all Selchem 2K Hardener HS potlife 2 h/20°C  Ready to spray, if necessary add Selchem 2K Thinner 18-20 s/Din 4 mm/20°C 45-53 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 0.5 + 1 = 50 - 60 micron  1.5 - 1.7 mm 4 - 5 bar 0.5 + 1 = 50 - 60 micron  0 - 10 min/20°C Final flash off  Air dry overnight/20°C or 20 min/60°C Panel temperature  Short wave 8 - 12 min Medium wave 12 - 14 min (See Selchem Painting System S10)

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# SELCHEM 2K MS Xtra Clear

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
30°C	86,0°F		0,97 g/cm <sup>3</sup>	45,6 Gew.-%	39,4 Vol.-%	530 g/Ltr.

Theoretical Coverage:	7.4 m <sup>2</sup> /Ltr. at 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 2.2 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- Selchem 2K MS Xtra Clear can be mixed with:<ul style="list-style-type: none"><li>- Selchem 2K Clear Supermatt</li><li>- Selchem 2K Plasticiser</li></ul></li><li>- Allow additional time for heating-up of combi spray booths.</li><li>- Selchem 2K MS Xtra Clear can be overcoated within 24 h without intermediate sanding.</li></ul>

*"Selchem the designers choice"*



# SELCHEM

## Basecoat



»Selchem MSB System

»Outstanding colour accuracy

»Outstanding filling properties

»Good opacity

»Easy to blend in

»Solid, metallic, pearl colours

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## TECHNICAL DESCRIPTION

- Mix with 50%  
Selchem MSB Thinner

- 10-15 min/20°C  
Final flash off

- 2 Spray passes



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# SELCHEM Basecoat

<b>WORKING PROCESS:</b>	2-Stage System
<b>SUBSTRATE:</b>	<ul style="list-style-type: none"><li>- Through-hardened sanded paintwork</li><li>- Selchem 1K Primer</li><li>- Selchem 1K/2K Filler</li><li>- Selchem Filler</li></ul>
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	<p>50% Selchem MSB Thinner 22 s/Din 4 mm/20°C 61 s/ISO 4 mm/20°C</p> <p>1.3 - 1.4 mm 4 bar 2 = 15 - 25 micron</p> <p>1.5 - 1.7 mm 4 bar 2 = 15 - 25 micron</p> <p>5 min/20°C Flash off between coats</p> <p>10 - 15 min/20°C Final flash off</p> <p>Selchem 2K Clears</p>

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# SELCHEM Basecoat

Flashpoint:		Specific Gravity: 0,93-1,06 g/cm <sup>3</sup>	Solid content:		VOC:	
25°C	77,0°F		22,0-37,2 Gew.-%	17,7-22,0 Vol.-%	460-719 g/Ltr.	3,8-6,0 lbs/gal

Theoretical Coverage:	7.1 - 8.8 m <sup>2</sup> /Ltr. at 25 micron dry film thickness
Raw Material:	Special air-drying resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 1.9 - 2.2 mm	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- The masking of Selchem Basecoats is possible after 45-60 min/20°C or after oven drying. Hardened Selchem Basecoats should be masked only after oven drying.</li> <li>- For special colours see technical data sheets.</li> </ul>

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# SELCHEM

## 2K Clear Supermatt



»Extremely matt 2K Clear

»For small areas and replacement panels

»Plasticised for Plastic substrates

»Mixing with other 2K Clears is possible

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## TECHNICAL DESCRIPTION

- Mix 2:1 with Selchem 2K Hardener MS 25-40
- Force drying possible
- Mix 3:1 with Selchem 2K Hardener HS 25-40
- Air dry overnight/20°C
- Degree of gloss 10-14 units at 60° angle



*"Selchem the designers choice"*

# SELCHEM 2K Clear Supermatt

<b>WORKING PROCESS:</b>	2:1 MS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	2:1 with Selchem 2K Hardener MS 25-40 Potlife 4 h/20°C  20% Selchem 2K Thinner 15 s/Din 4 mm/20°C 33 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 bar 2 = 50 - 60 micron  15 - 20 min/20°C Flash off between coats and Final Flash off  Air dry overnight/20°C or 45 min/60°C Panel temperature

*"Selchem the designers choice"*

# SELCHEM 2K Clear Supermatt

<b>WORKING PROCESS:</b>	3:1 HS System
<b>SUBSTRATE:</b>	- Selchem Basecoats
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	3:1 with Selchem 2K Hardener HS 25-40 Potlife 4 h/20°C  25% Selchem 2K Thinner 15 s/Din 4 mm/20°C 33 s/ISO 4 mm/20°C  1.3 - 1.4 mm 4 bar 2 = 50 - 60 micron  1.5 - 1.7 mm 4 bar 2 = 50 - 60 micron  15 - 20 min/20°C Flash off between coats and Final Flash off  Air dry overnight/20°C or 45 min/60°C Panel temperature

*"Selchem the designers choice"*

# SELCHEM 2K Clear Supermatt

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
23°C	73,4°F		1,03 g/cm <sup>3</sup>	55,0 Gew.-%	47,4 Vol.-%	463 g/Ltr.

Theoretical Coverage:	6 - 7 m <sup>2</sup> /Ltr. at 50 micron dry film thickness
Raw Material:	2-pack acrylic resins
Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 1.9 - 2.2 mm	<ul style="list-style-type: none"> <li>- For professional use only.</li> <li>- The Selchem 2K Automotive Matt Finishing is only suitable to matt small areas or replacement panels</li> <li>- The repair of bare patches is only possible with Selchem 1K Motoring Polyurethane Top Coat Colours and Selchem Automotive Matt Finishing.</li> <li>- For the mixing ratios to achieve the different gloss levels see Selchem Matting Table. Mixed with other Selchem 2K Clears different Selchem 2K Hardeners can also be used.</li> <li>- Allow additional time for heating-up of combi spray booths.</li> </ul>

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# SELCHEM

## 2K Smart Blend

»Additive for blend-in with  
Selchem 2K/2K HS Clear and  
Selchem 2K/2K HS Topcoat



## TECHNICAL DESCRIPTION

- Mix 5:1 with hardened Selchem 2K/2K HS Clear
- Force drying possible
- Air dry overnight/20°C



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# SELCHEM 2K Smart Blend

<b>WORKING PROCESS:</b>	Blending-in with Selchem 2K/2K HS Topcoat
<b>SUBSTRATE:</b>	- For preparation of repair areas see Selchem Painting System S3. Keep surface for priming with filler as small as possible.
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	Spray repair area with Selchem 2K/2K HS Topcoat until covered  Blend-in the overlapping area with reduced pressure (1,5 bar) and further thinned material  Mixing ratio: 5 Parts Selchem 2K Blending Thinners + 1 part hardened Selchem 2K/2K HS Clear  Apply mixture on blending area  Polish after air dry overnight/20°C or 30 min/60°C Panel temperature Polish after 1 h  Short wave 8 - 12 min Polish after 1 h

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# SELCHEM 2K Smart Blend

<b>WORKING PROCESS:</b>	Blending-in with Selchem 2K/2K HS Clear
<b>SUBSTRATE:</b>	- For preparation of repair areas see Selchem Painting System S3. Keep surface for priming with filler as small as possible.
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	Spray repair area with Selchem 2K/2K HS Clear  Blend-in the overlapping area with reduced pressure (1,5 bar) and further thinned material  Mixing ratio: 5 Parts Selchem 2K Blending Thinners + 1 part hardened Selchem 2K/2K HS Clear  Apply mixture on blending area  Polish after air dry overnight/20°C or 30 min/60°C Panel temperature Polish after 1 h  Short wave 8 - 12 min Polish after 1 h

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# SELCHEM 2K Smart Blend

Flashpoint:		Specific Gravity:			
45°C	113,0°F	0,96 g/cm <sup>3</sup>			

Cleaning of equipment:	Clean after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction feed 1.8 - 2.2 mm	- For professional use only.

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# SELCHEM

## Plastic Primer



- » 1K Primer for 3-stage Plastic Painting System
- » Easy to apply
- » Adheres to all exterior plastic car parts
- » Ready to spray

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## TECHNICAL DESCRIPTION

- 1 Spray pass  
Selchem 1K Plastic Primer
- Flash off 10 min/20°C
- Overcoat Wet-on-Wet with  
Selchem Plastic Filler  
or  
plasticised Selchem 2K Filler



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# SELCHEM Plastic Primer

<b>WORKING PROCESS:</b>	Adhesion primer for plastic
<b>SUBSTRATE:</b>	- Exterior plastic car parts
<b>PRETREATMENT/ CLEANING:</b>	For substrate preparation information see Selchem Painting System S1.
<b>APPLICATION:</b>  Use air fed respirator. Refer to relevant Health and Safety Data sheets.	Ready to spray Shake well before use  1.3 - 1.4 mm 3 - 4 bar 1 = 1 - 2 micron  1.5 - 1.7 mm 3 - 4 bar 1 = 1 - 2 micron  Air Dry 10 min/20°C  Selchem Plastic Filler Plasticised Selchem 2K Filler

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# SELCHEM Plastic Primer

Flashpoint:		Specific Gravity:	Solid content:		VOC:	
23°C	73,4°F		0,88 g/cm <sup>3</sup>	4,8 Gew.-%	3,5 Vol.-%	835 g/Ltr.

Theoretical Coverage:	17 m <sup>2</sup> /Ltr. at 2 micron dry film thickness
Raw Material:	Special polymers
Cleaning of equipment:	Clean immediately after use with Selchem cleaning thinner.
Important remarks:  Gravity feed 1.3 - 1.4 mm Suction fed 1.7 - 1.9 mm	<ul style="list-style-type: none"><li>- For professional use only.</li><li>- Apply a single thin coat of Selchem Plastic Primer</li><li>- See Selchem Painting System for Plastics (S 7.0 - 7.9)</li></ul>

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