

GRIP-GARD BC Interior

Technical Data Sheet

June 2013
Basecoats




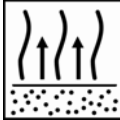
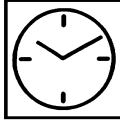

Description

When mixed according to the Interior Signage Application procedures, Grip-Gard BC Basecoat can be used to produce interior signage that conforms to ADA (Americans with Disabilities Act) requirement and other interior signage, without the need for a clearcoat.



Chose the required color in Mixit
Substitute Grip-Gard BC #90 or #91 Interior Binder for #10 Binder in the formula.
Mix the color, then add the Grip-Gard BC Interior Binder(s) as required to achieve the desired gloss levels. See below for directions.

Step1: Chose the appropriate GG BC Interior Binder(s) for desired gloss level

Satin	100	Parts GG BC toner formula	50	parts GG BC 90 Interior Satin Binder
Low	100	Parts GG BC toner formula	50	parts GG BC 90/91 Binder Blend
Flat	100	Parts GG BC toner formula	50	parts GG BC 91 Interior Matte Binder
	90	Grip-Gard BC Basecoat		
	10	Grip-Gard BC Clear Hardener Slow		
	50	Grip-Gard BC Reducer		
	Use the AkzoNobel Measuring Stick #111.			
	Application Solid Color		Apply 2 – 3 wet coats or until covered.	
	Application Metallic Color		Apply 2 coats followed by an orientation coat.	
	Flash between coats			
	2 – 5 minutes at 70°F (20°C) or until no wet gloss is apparent			
	30 – 45 minutes at 70°F dry to exposure (20°C)			
	Use suitable respiratory protection Akzo Nobel Sign Refinishes recommends the use of a fresh air supply respirator			

NOTE:

As with all paints, when adjusting the gloss level there can be variations in final gloss level depending on the color chosen. Sprayouts of the color with balanced levels of 90 and 91 binders is recommended prior to the final application.

Description

When mixed according to the Interior Signage Application procedures, Grip-Gard BC Basecoat can be used to produce interior signage that conforms to ADA (Americans with Disabilities Act) requirements, as well as for other interior signage, without the need for a clearcoat. With extremely fast tape and dry times and a tremendous range of solid, metallic and pearl colors, Grip-Gard BC Basecoat for Interior Signage is ideal for fast production and high quality. Grip-Gard BC Basecoat for Interior Signage is designed to be used directly on ADA compliant photopolymer, most common plastics, and on any properly primed metal surface. Grip-Gard BC Basecoat for Interior Signage has excellent color fastness and mar resistance, and provides excellent resistance to household cleaners such as Windex®, Formula 409® and Clorox® Kitchen Cleaner.

Suitable substrates

Grip-Gard BC Indoor Sign Colors can be applied directly over:

- Grip-Gard White Washprimer Light Enhancing (non sanding)
- Grip-Gard Epoxy Sealer Gray or White
- Grip-Gard Brite-White HF Primer
- Grip-Gard Washprimer 1K CF
- Grip-Gard Sealer White and Gray
- Grip-Gard HB Surfacer (after sanding)
- VPS1 Primer for Plastic Substrates
- Most common plastics including polycarbonate, vinyl, photopolymer, flexible membrane and PVC
- Extruded and cell cast Acrylic Plastics without adhesion promoters
- Most existing finishes; degreased and sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet but not over thermoplastic acrylic lacquers. In that case, the entire surface must be sealed with a Surfacer or Sealer.
- Grip-Gard BC Indoor Sign Color can be directly applied on top of the following primed surfaces: Aluminum, steel, galvanized steel and expanded urethane foam when primed with the appropriate Grip-Gard primer system. Consult relevant primer Technical Data Sheet for substrate recommendations.

Products and additives

PRODUCTS:	Grip-Gard BC Basecoat Toners	Assortment
	Grip-Gard BC Interior Sign Satin Binder 90	Item # 397616
	Grip-Gard BC Interior Sign Matte Binder 91	Item # 397617
HARDENER:	Grip-Gard BC Clear Hardener	Item # 391268
	Grip-Gard BC Clear Hardener Slow	Item # 481146
REDUCERS:	Grip-Gard BC Fast Reducer: Temperature range: 60°F–75°F (16°C–24°C)	Item # 391264
	Grip-Gard BC Medium Reducer: Temperature range: 70°F–85°F (20°C–30°C)	Item # 391265
	Grip-Gard BC Slow Reducer: Temperature range: 80°F–95°F (27°C–35°C)	Item # 391266
	Grip-Gard BC Extra Slow Reducer: Temperature range: above 95°F (35°C)	Item # 391267

Basic raw materials

Grip-Gard BC 90 and 91 Binder: Vinyl/polyester resins and pigments
 Grip-Gard BC Reducers: special solvent blends.
 Grip-Gard BC Clear Hardeners: polyisocyanate resin.

Surface preparation

New raw plastics

Degrease parts, then blow and tack off the parts to be painted.

Other

All products that are to be sanded: you may have to initial sand, but final sanding with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet is recommended.

Wet-on-wet products: please follow recommendation for product in use by consulting the relevant Technical Data Sheet

Mixing



Mixing Machine

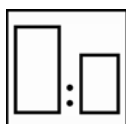
Stir Grip-Gard BC Basecoat MM colors on mixing machine every 4 hours for 15 minutes



Stir after mixing

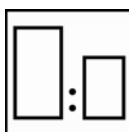
Grip-Gard BC Basecoat MM colors must be stirred thoroughly immediately after mixing the color formula

STEP 1: Choose the appropriate Grip-Gard BC Interior Binder(s) for desired gloss level



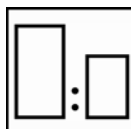
SATIN GLOSS FINISH (25 – 35 GU @60° angle)

100 Grip-Gard BC Basecoat toner formula
 50 Grip-Gard BC 90 Interior Satin Binder



LOW GLOSS FINISH (15 – 25 U @60° angle)

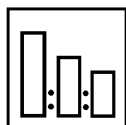
100 Grip-Gard BC Basecoat toner formula
 50 Grip-Gard BC 90 Interior Satin Binder/ Grip-Gard BC 91 Interior Matte Binder
 * Mix 90 and 91 Binder 1:1 then mix 100:50 with the color



MATTE GLOSS FINISH (5 – 15 GU @60° angle)

100 Grip-Gard BC Basecoat toner formula
 50 Grip-Gard BC 91 Interior Matte Binder

STEP 2: Take above mixture and reduce as follows for Ready-To-Spray



- 90 Grip-Gard BC Basecoat
- 10 Grip-Gard BC Clear Hardener Slow
- 50 Grip-Gard BC Reducer

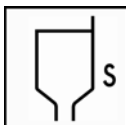
Note: As with all paints, when adjusting the gloss level there can be variations in final gloss level depending on the color chosen. When a specific gloss level is required, sprayouts of the color with balanced levels of 90 and 91 binders is recommended prior to the final application.

Color mixing by hand:

Own formulated colors: When developing your own color, it is essential that you add Grip-Gard BC Interior Binder 90 or 91 into the paint mixture. To do this, mix 2 parts mixed color by weight to 1 part Binder 90 or 91 by weight, or use a measuring Stick to mix 2 parts mixed color by volume to 1 part Binder 90 or 91 by volume. Stir thoroughly. Then harden and reduce as described in the mix ratio section. Failure to include the binder into the paint mixture will cause poor product performance.

Mixing Note: Grip-Gard BC Interior Binder is designed to be used in Grip-Gard BC solid colors for best color accuracy. If used in metallic or pearl colors the color match will be slightly varied depending on the color chosen.

Viscosity



The proper spraying viscosity is achieved by using the recommended mixing ratio. Grip-Gard BC Basecoat Solid, Metallic and Pearl colors: 13 – 15 sec. DIN Cup #4 at 70°F (20°C).

Spray gun set-up / application pressure

Spray gun	Fluid tip set-up	Application pressure	Fluid Spray Rate
High Transfer Gravity	1.3 – 1.5 mm	35 psi	
High Transfer Pressure Feed	1.0 – 1.2 mm	35 psi	10 – 15 oz/min.
HVLP Pressure Feed	0.8 – 1.0 mm	Max 10 psi (air cap)	10 – 15 oz/min.
HVLP Siphon	1.8 – 2.2 mm	Max 10 psi (air cap)	
HVLP Gravity	1.3 – 1.5 mm	Max 10 psi (air cap)	

Pot-life

After Mixing with Hardener and Reducer. Grip-Gard BC Interior Sign Color: 4 – 6 hours.

Application process

SOLID COLORS: Spray 2 – 3 single wet coats; allow approximately 2 – 5 minutes flash-off between each coat

METALLIC COLORS:

Spray 2 single coats allowing 2 – 5 minutes between coats. If a third coat for metallic orientation is needed, spray a final coat into the second coat prior to flash off. Increase the gun distance and apply this coat being careful to make the finish even.

TWO-TONE APPLICATION

Grip-Gard BC Interior colors can be taped off with fine line masking tape after 45 minutes at 70°F (20°C) and a second color of Grip-Gard BC Interior Sign color can then be applied.

Film thickness

By recommended application;

Grip-Gard BC Basecoat, Solid, Metallic and Pearl: 1.0–1.2 mils per single coat.

Recoat time



The interior coating can be recoated with itself at any stage.

Curing time



30 – 45 minutes dry to exposure at 70°F (20°C)

Material usage

Approximate square foot coverage per gallon at 1 dry mil:

Transfer Efficiency	Unmixed Interior Binder	Binder mixed with Color	Ready to Spray
100% (Theoretical)	1490	497	298
65% (HVLP)	965	322	193
35% (Conventional)	520	173	104

Cleaning of equipment

Clean equipment with Cleaning Solvent 790, Cleaning Solvent LV or lacquer thinner.

VOC

Grip-Gard BC 90 Interior Satin Binder (as is):	5.3 lbs/gal (637 g/l)
Grip-Gard BC 91 Interior Matte Binder (as is):	4.8 lbs/gal (575 g/l)
Grip-Gard BC 90 Interior Satin (ready-to-spray):	5.4 – 6.0 lbs/gal (653 – 723 g/l)
Grip-Gard BC 91 Interior Matte (ready-to-spray):	5.3 – 5.9 lbs/gal (639 – 708 g/l)

Product storage

Store products unopened, and used products with closed lids preferably between 70°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

SHELF LIFE:

Grip-Gard BC Interior Binders: One year if stored unmixed at room temperature.
Grip-Gard BC Basecoat Toners: Four years if stored unmixed at room temperature.
Grip-Gard BC Clear Hardeners: One year if stored unopened at room temperature.
Grip-Gard BC Reducers: Four years if stored unopened at room temperature.



FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product..Coatings brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

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