**PRODUCT DESCRIPTION**

One component, water based, hydrophobic coating based on latest generation compact polymer matrix binders and metal-free, organic corrosion inhibition technology

**INTENDED USES**

SpecAqua 1K DTM Flexi is a high performance, hydrophobic direct-metal anti-corrosive primer/finish for use on mild steel, Stainless Steel, Galvanized steel, Zinc Plated Steel and Zinc Phosphated Steel when applied creates a flexible, super hydrophobic film and provides excellent corrosion resistance.

Applied at minimum film thickness of 50um and applied up to 175um will provide salt spray resistance in excess of 1,440 hours

Applied at 60um DFT SpecAqua 1K DTM Flexi is estimated to provide corrosion category C5-I Long. An equivalent epoxy/polyurethane thickness of between 320-500um would be required to achieve similar corrosion resistance.

SpecAqua 1K DTM Flexi is not very hard and can be topcoated with a harder film should enhanced mechanical/chemical resistance be required. i.e. SpecAqua 2K PUD

The coating is extremely UV Stable and weather resistant

**CHARACTERISTICS**

- Water Based, 1 component
- Fast drying, early block resistance
- Spray or brush application
- Highly flexible
- Unsurpassed corrosion protection at thin films
- Applied direct to metal, no primer is required
- Easy to use one component product that can be brush, roller or spray applied
- Crack and peel resistant
- Resistant to flash rust
- Early water resistance
- Provides very good adhesion for subsequent coats
- Excellent coverage of nuts, bolts and welds
- Less working hours due to 1 coat system
- Eco friendly, without metal, low VOC
- Less weight, due to lower film thickness
## PRODUCT INFORMATION

<table>
<thead>
<tr>
<th>Colour</th>
<th>Pigmented &amp; Clear</th>
</tr>
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<tbody>
<tr>
<td>Corrosion Class</td>
<td>C5 – Very high protection</td>
</tr>
<tr>
<td>Finish</td>
<td>Gloss – 85% @ 60°</td>
</tr>
<tr>
<td>Density</td>
<td>1.10 kg</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>40%</td>
</tr>
<tr>
<td>PVC</td>
<td>&lt;15%</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Typical Film Thickness</th>
<th>DFT um</th>
<th>WFT um</th>
<th>Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 X 60</td>
<td>1 X 130</td>
<td>C4 - Long</td>
<td></td>
</tr>
<tr>
<td>2 X 60 to achieve 120</td>
<td>2 X 130</td>
<td>C5I - Medium</td>
<td></td>
</tr>
<tr>
<td>3 X 60 to achieve 180</td>
<td>2 X 380</td>
<td>C5I - Long</td>
<td></td>
</tr>
</tbody>
</table>

Typically, 150 um WFT should not be exceeded per coat.

### Theoretical Coverage
- 6.66 m²/litre at 60 microns dft
- 2.22 m²/litre at 175 microns dft allow loss factors

### Method of Application
- Brush, Roller or Spray

### Number of Coats
- 1 to 3

### Viscosity
- 80-85 KU

### Drying Times – at 25°C / RH 60%
- Dry to touch: 20 minutes
- Dry to handle: 2 hours
- Dry to re-coat with waterborne: 4 hours
- Dry to re-coat with solvent borne: 24 hours @ 50um
- Fully cured: 1 week
SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination.

New Work
Mild Steel: Degrease with Hydrosolve degreaser. Rinse thoroughly with water. Remove any loose rust by coarse sanding, mechanical grinding etc. or Rust Remover Gel. Prime the prepared surface the same day before oxidation of the steel occurs.
Galvanized Steel: Clean with Galvanized Iron Cleaner to achieve a water break free surface. Rinse thoroughly with water to remove all traces of cleaner. Prime same day.

Repainting
Old painted surfaces: Wire brush thoroughly using a dilute solution of Hydrosolve Degreaser to remove all dirt and contaminants. Rinse with fresh water and allow drying. Abrade any rust spots to clean metal and patch prime these spots first. Allow to dry and then apply an even coat of primer.

APPLICATION

Mixing
Material is supplied in plastic containers. This is a one component product and does not require a hardener.
Agitate/stir the product well before use to ensure a homogeneous mix and no settlement of pigments.

APPLICATION

Thinner
De-Ionized Water

Airless Spray
Recommended
Tip range 15-23 Thou. Pressure at the tip should not be less than 170 bar (2500 PSI)

Air Spray
2.0mm needle

Brush/Roller
Recommended

Work Stoppage
Thoroughly flush all equipment with Water. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered and viscosity re-adjusted before use.

Clean Up
Clean all equipment immediately after use with Water. It is good working practice to periodically flush out the spray equipment during the course of the working day. Frequency of cleaning will depend upon the amount sprayed, temperature and elapsed time, including delays.
Good airflow is essential around the object once coated. If the relative humidity limit of 70% is exceeded, drying and overcoating times will be severely extended. Application below the minimum film forming temperature of the coating and/or poor ventilation will result in poor film coalescence and a powdery cracked film which will require removal prior to re-application.

<table>
<thead>
<tr>
<th>Environment</th>
<th>Surface Temperature</th>
<th>Ambient Temperature</th>
<th>Relative Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>8°C*</td>
<td>10°C</td>
<td>10%</td>
</tr>
<tr>
<td>Maximum</td>
<td>40°C</td>
<td>40°C</td>
<td>80%</td>
</tr>
</tbody>
</table>

*Or 3°C above the dew point

**LIMITATIONS**

- Do not apply at temperatures below 10°C or if the temperature is likely to fall below 10°C within 4 hours after application
- Applying thicker than recommended will result in mud cracking
- Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Speccoats™ representative for specific recommendations
- Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures.
- Test performance results were obtained in a controlled laboratory environment and Speccoats™ makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating.
UNIT SIZE

5, 20Lt

STORAGE

Shelf Life 24 months at 25°C – from date of manufacture
Subject to inspection thereafter. Store in dry conditions out of direct sunlight.
Store at temperature between 5 and 35°C

IMPORTANT NOTE

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user’s responsibility to ensure that this sheet is current prior to using the product.

PRECAUTIONS

For complete safety and handling information please refer to the appropriate Safety Data Sheets prior to using this product.