Commercial Performance Coatings

TINTING GUIDE

TINTER PREPARATION

1. New tinter cans should be shaken for 5-10 minutes prior to fitting the mixing lid and placing on the mixing bank. This ensures there is no settle and the tinters are homogenous (evenly mixed).

2. The mixing bank should be turned on to stir for 10-15 minutes minimum at the start of every day and for 10-15 minutes at least three more times a day (normally coordinated with break times).

TINTER CODE	TINTER DESCRIPTION	TINTER COLOUR CHARACTERISTICS
NP03	NP03 ALUMINUM	Fine dullish aluminium
NP06	NP06 ALUMINIUM 2	Medium coarse aluminium
NP10	NP10 WHITE	High opacity white
NP22	NP22 BRIGHT YELLOW	Green toned yellow (Higher opacity than NP27)
NP26	NP26 CEDAR YELLOW HIGH COVERAGE	Green toned yellow (Higher opacity than NP22)
NP27	NP27 CEDAR YELLOW	Green toned yellow
NP28	NP28 SUN YELLOW	Red toned organic yellow
NP29	NP29 ORGANIC YELLOW HIGH COVERAGE	Bright organic yellow with good opacity
NP30	NP30 OCHRE YELLOW	Red toned yellow oxide with good opacity
NP32	NP32 ORGANIC YELLOW	Bright organic yellow with good opacity
NP34	NP34 TRANSPARENT YELLOW	Yellow for metallic hammertones
NP43	NP43 ORGANIC ORANGE	Bright organic orange with medium opacity
NP45	NP45 ORGANIC ORANGE HIGH COVERAGE	Bright organic orange with good opacity
NP50	NP50 RED OXIDE	Yellow toned red oxide with good opacity
NP51	NP51 LIGHT RED HIGH COVERAGE	Yellow toned organic red with good opacity
NP54	NP54 RED RUBY	Very blue toned red (deep magenta)
NP56	NP56 VIOLET	Blue toned violet
NP57	NP57 BRIGHT RED	Blue toned organic red
NP59	NP59 LIGHT RED	Yellow toned organic red
NP60	NP60 PHTHALO GREEN	Bluish toned organic green
NP71	NP71 PHTHALO BLUE	Reddish toned organic blue
NP92	NP92 BLACK	Yellow toned carbon black

MIXED COLOUR PREPARATION

1. Before weighing, tare an empty can of the same size as the binder to be tinted.
2. Place the prefilled binder can on the scales.
   Binders required to top up binder in prefilled cans should be kept on the mixing bank so they are ready to use.
3. Adjust the binder quantity as required by the formula (usually an addition of extra binder).
4. Add the tinter quantities as per the formula.
5. Mixed colours must be shaken immediately after the colour is made up to ensure the tinters are completely mixed in.

MIXED COLOUR ADJUSTMENT GUIDE

The chart shown below has been designed to assist in tinting over colours that have already been made up using the SELEMIX® Tinter System.
It is very important that binder and tinter ratios are within specification and added in the correct order.

1. Add extra tinter as required and note how much tinter was added (grams).
2. Add extra binder (in grams) AND DRIER AS NECESSARY as shown on the chart below.

PAINT SYSTEM	RDE, PET, ACE	HFE	EXT	PPT	EPS	DM7	CLR	NCL
BINDER : TINTER RATIO (BY WEIGHT)	65 : 30 : 5 DRIER	80 : 15 : 5 DRIER	70 : 30	70 : 30	85 : 15	85 : 15	85 : 15	80 : 20

EXTRA SELEMIX TINTER ADDED (g)	EXTRA BINDER AND DRIER REQUIRED (g)		EXTRA BINDER REQUIRED (g)					
10	22 : 2	53 : 3	23	23	57	57	57	40
25	54 : 4	133 : 8	58	58	142	142	142	100
50	108 : 8	267 : 17	117	117	283	283	283	200
75	163 : 13	400 : 25	175	175	425	425	425	300
100	217 : 17	533 : 33	233	233	567	567	567	400
200	433 : 33	1067 : 67	467	467	1,133	1,133	1,133	800
300	650 : 50	1600 : 100	700	700	1,700	1,700	1,700	1,200
400	867 : 67	2133 : 133	933	933	2,267	2,267	2,267	1,600
500	1083 : 83	2667 : 167	1,167	1,167	2,833	2,833	2,833	2,000
600	1300 : 100	3200 : 200	1,400	1,400	3,400	3,400	3,400	2,400
700	1517 : 117	3733 : 233	1,633	1,633	3,967	3,967	3,967	2,800
800	1733 : 133	4267 : 267	1,867	1,867	4,533	4,533	4,533	3,200
900	1950 : 150	4800 : 300	2,100	2,100	5,100	5,100	5,100	3,600
1,000	2167 : 167	5333 : 333	2,333	2,333	5,667	5,667	5,667	4,000
COMMENTS:	The drier level also needs to be adjusted as per the second amount above. This is on top of any drier already in the mix.							

Commercial Performance Coatings

GLOSS ADJUSTMENT GUIDE

The tables are a guide to achieving various gloss levels in **PPT** - Performance Polyurethane Topcoat, **RDE** - Rapid Dry Enamel, **PET** - Performance Enamel Topcoat & **NCL** - Nitrocellulose Lacquer

1. Look up the colour on the PAINTMANAGER® Colour software.
2. Determine the ratio required of Clear Binder and Matt Binder to achieve the desired gloss level.
3. Convert the clear binder weight on the formula to Matt and Clear binder as per the ratio on the table.

PPT
Performance Polyurethane Topcoat

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION (PUR10/PUR20/ PUR30)
	CLEAR BINDER	MATT BINDER	
90 - 95	100	0	10 - 20 %
80 - 85	70	30	10 - 20 %
75 - 80	60	40	10 - 20 %
65 - 70	50	50	20 - 30 %
50 - 60	40	60	20 - 30 %
35 - 45	30	70	20 - 30 %
15 - 25	20	80	30 - 40 %
10 - 15	10	90	30 - 40 %
5 - 10	0	100	40%

RDE
Rapid Dry Enamel

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION (AER20/AER30)
	CLEAR BINDER	MATT BINDER	
95 - 99	100	0	10 - 30 %
60 - 70	75	25	10 - 30 %
30 - 40	50	50	10 - 30 %
20 - 25	25	75	10 - 30 %
10 - 15	0	100	10 - 30 %

PET
Performance Enamel Topcoat

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION (AER20/AER30)
	CLEAR BINDER	MATT BINDER	
90 - 95	100	0	10 - 30 %
80 - 85	75	25	10 - 30 %
65 - 70	50	50	10 - 30 %
45 - 50	25	75	10 - 30 %
30 - 35	15	85	10 - 30 %
10 - 15	0	100	10 - 30 %

NCL
Nitrocellulose Lacquer

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION (NCR20)
	CLEAR BINDER	MATT BINDER	
90 - 95	100	0	60 %
60 - 70	85	15	60 %
45 - 55	75	25	60 %
30 - 40	65	35	60 %
20 - 30	50	50	60 %
10 - 20	25	75	60 %
7 - 10	0	100	60 %

Note: The final gloss level is influenced by flash off times, application viscosity, film builds and may vary from the ranges above.
Test for suitability before final use. All mixed colours must be stirred or shaken immediately after make-up.

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