

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 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 ALUMINIUM	Medium coarse aluminium
NP06	NP06 ALUMINIUM 2	Fine dullish aluminium
NP10	NP10 WHITE	High opacity white
NP22	NP22 BRIGHT YELLOW	Green tone yellow (Higher opacity than NP27)
NP26	NP26 CEDAR YELLOW HIGH COVERAGE	Green tone yellow (Higher opacity than NP22)
NP27	NP27 CEDAR YELLOW	Green tone yellow
NP28	NP28 SUN YELLOW	Red tone organic yellow
NP29	NP29 ORGANIC YELLOW HIGH COVERAGE	Bright organic yellow with good opacity
NP30	NP30 OCHRE YELLOW	Red tone yellow oxide with good opacity
NP32	NP32 ORGANIC YELLOW	Bright organic yellow with good opacity
NP34	NP34 TRANSPARENT YELLOW	Yellow for metallic Hammer Finish Enamel
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 tone red oxide with good opacity
NP51	NP51 LIGHT RED HIGH COVERAGE	Yellow tone organic red with good opacity
NP54	NP54 RED RUBY	Very blue tone red (deep magenta)
NP56	NP56 VIOLET	Blue tone violet
NP57	NP57 BRIGHT RED	Blue tone organic red
NP59	NP59 LIGHT RED	Yellow tone organic red
NP60	NP60 PHTHALO GREEN	Bluish tone organic green
NP71	NP71 PHTHALO BLUE	Reddish tone organic blue
NP92	NP92 BLACK	Yellow tone 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.**

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.

EXTRA SELEMIX TINTER ADDED (g) BINDER : TINTER RATIO (BY WEIGHT)	EXTRA BINDER : DRIER REQUIRED (g)		EXTRA BINDER REQUIRED (g)			
	RDE, PET, ACE 65 : 30 : 5	HFE 80 : 15 : 5	EXT, PPT, ICF, 1DM, 2DM 70 : 30	ZPH, SLX 75 : 25	NCL 80 : 20	EPS, CLR 85 : 15
10	22 : 2	53 : 3	23	30	40	57
25	54 : 4	133 : 8	58	75	100	142
50	108 : 8	267 : 17	117	150	200	283
75	163 : 13	400 : 25	175	225	300	425
100	217 : 17	533 : 33	233	300	400	567
200	433 : 33	1,067 : 67	467	600	800	1,133
300	650 : 50	1,600 : 100	700	900	1,200	1,700
400	867 : 67	2,133 : 133	933	1,200	1,600	2,267
500	1,083 : 83	2,667 : 167	1,167	1,500	2,000	2,833
600	1,300 : 100	3,200 : 200	1,400	1,800	2,400	3,400
700	1,517 : 117	3,733 : 233	1,633	2,100	2,800	3,967
800	1,733 : 133	4,267 : 267	1,867	2,400	3,200	4,533
900	1,950 : 150	4,800 : 300	2,100	2,700	3,600	5,100
1,000	2,167 : 167	5,333 : 333	2,333	3,000	4,000	5,667

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, **1DM** - 1K Direct To Metal, **2DM** - 2K Direct to metal & **ICF** - Isocyanate Free Topcoat.

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 %

1DM

1K Direct to Metal

GLOSS LEVEL (overnight dry)	CLEAR : SATIN BINDER RATIO		REDUCER ADDITION (AER20/AER30)
	CLEAR BINDER	SATIN BINDER	
90 - 95	100	0	25 %
75 - 80	70	30	25 %
70 - 75	60	40	25 %
65 - 70	50	50	30 %
50 - 60	40	60	30 %
45 - 55	30	70	30 %
35 - 45	20	80	30 %
25 - 35	10	90	30 %

2DM

2K Direct to Metal

GLOSS LEVEL (overnight dry)	CLEAR : SATIN BINDER RATIO		REDUCER ADDITION (PUR10/PUR20/ PUR30)
	CLEAR BINDER	SATIN BINDER	
90 - 95	100	0	25 %
95 - 85	70	30	25 %
85 - 75	60	40	25 %
75 - 70	50	50	30 %
65 - 60	40	60	30 %
55 - 45	30	70	35 %
45 - 35	20	80	35 %
35 - 25	10	90	35 %

ICF

Isocyanate Free Topcoat

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION (ICR20/ICR30)
	CLEAR BINDER	MATT BINDER	
85 - 95	100	0	30 %
50 - 60	70	30	30 %
40 - 50	60	40	35 %
35 - 40	50	50	35 %
30 - 35	40	60	40 %
25 - 30	30	70	40 %
15 - 25	20	80	45 %
0 - 15	10	90	45 %

DULON

Acrylic Lacquer

GLOSS LEVEL (overnight dry)	CLEAR : MATT BINDER RATIO		REDUCER ADDITION
	MIXED COLOUR	515-03038 FLATTING BASE	
80 - 90	100	0	100 %
50 - 60	97	3	100 %
40 - 50	95.5	4.5	100 %
35 - 40	94	6	100 %
30 - 35	93	7	100 %
25 - 30	91.5	8.5	100 %
15 - 20	90	10	100 %
0 - 15	90	10	100 %

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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