



2K Iso-free PU

Isocyanate-free modified acrylic topcoat

6300 - line

Description

- 2-pack modified acrylic finish coat

Properties

- No isocyanate catalyst
- High gloss and good gloss retention
- Excellent exterior durability

Typical Applications

- Steel fabrications
- Truck refinishing

General Data

- Weather resistance Excellent
- Solvent resistance Resists splashes of most common solvents; not recommended for continuous immersion
- Chemical resistance Good
- Abrasion resistance Good
- Heat resistance up to 120°C (dry heat)
- Suitable primers Rhinamel[®] CC Primer

Specifications (at 25°C and 50% relative humidity)

- Resin type..... Acrylic-modified urethane
- Mixing ratio..... 3 : 1
- Solids content..... 40% (by volume)
- Typical film thickness (per coat)..... 30 microns (dry)
75 microns (wet)
- Theoretical coverage..... 12m² / L @ 30 microns dry film thickness
- Touch dry..... 30 - 45 minutes
- Hard dry..... 4 hours
- Full cure..... 5 - 7 days
- Recoating..... after 12 - 16 hours
- Pot life..... 2 hours (depending on temperature and level of thinner added)
- Gloss..... Gloss
- Colour..... White, Black and pastel colours
- Shelf life..... minimum 12 months (in cool, dry conditions; unopened containers)

Surface Preparation

- Bare steel surfaces must be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion with a suitable power cleaning tool (e.g. disc sander)
- Not suitable for application directly to bare metal. Refer to recommendations in Coatings Systems below.

Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 3:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Thin up to 10% by volume with Wagon Paints' T7 Thinner (see Application directions), and stir as above

2K Iso-free PU

Application

- May be spray applied using airless or conventional air spray equipment
- **Airless Spray** nozzle size.....0.33 - 0.38 mm
nozzle pressure.....2800 - 4000 psi (19 - 27mPa)
volume of thinner.....up to 5%
- **Air Spray** nozzle size.....1.8 - 2.2 mm
nozzle pressure.....55 - 70 psi (350 - 450kPa)
volume of thinner.....up to 10%
retarder..... up to 5% T15 Thinner in hot conditions
- **Cleaning solvent** T1 PU Spray Thinner

Coating Systems

Substrate	Primer	Undercoat	Topcoat
Aluminium	Rhinogrip [®] Etch	Rhinamel [®] CC Primer	2K Iso-free PU
Galvanised Iron	Rhinogrip [®] Etch	Rhinamel [®] CC Primer	2K Iso-free PU
Steel		Rhinamel [®] CC Primer	2K Iso-free PU
Zincseal / Zinalume	Rhinogrip [®] Etch	Rhinamel [®] CC Primer	2K Iso-free PU

Caution:

Store 2K Iso-free PU Packs A & B in a cool, dry location. Do not allow water to contaminate the products.
Must not be applied over damp surfaces.
Do not apply when the air/surface temperatures are below, or are likely to fall below, 10°C or the relative humidity is above 70%.

Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group III **UN No.** 1263 (Pack A); 1866 (Pack B)

Pack sizes 3 litre, 15 litre (Pack A)
 1 litre, 5 litre (Pack B)

Authorised: A. De Mello, Sales Manager

June 2008

These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



Wagon Paints

5 Stephenson Road, Bayswater North, Victoria 3153 Australia
Phone: 61 3 97291344 Fax: 61 3 97202179 Email: sales@wagonpaints.com.au