

## 2-K AUTO UNDERCOAT

### PRODUCT DESCRIPTION

2-K AUTO UNDERCOAT is an isocyanate modified acrylic finish, which through a chemical reaction with the hardener - Part "B", cures to form a hard, tough substrate suitable for subsequent finishing coats. It has been designed to form a durable, chemically resistant, easy sanding finish on suitably prepared metals, timber, masonry, composition boards, hardboard, and some plastics (please refer to the manufacturer for specific cases).

### SHELF LIFE

Part "A"	3	years	+	in properly sealed containers
Part "B"	12	months	+	in originally sealed containers

### SURFACE PREPARATION

All surfaces to be coated must be sound, suitably cleaned, degreased and dust free. Major surface imperfections must be rectified before proceeding any further. Previously coated substrates must be de-glossed by lightly scuffing down with a fine grit abrasive paper and minor surface imperfections, embedded dirt, grease & etc. removed. If painting over an existing finish, **ALWAYS** test that the existing finish will not be adversely affected. Remove any sanding dust and etc. by either wiping down with a lint free rag soaked in an appropriate thinner or with a TACK-Rag.

### MIX RATIOS

#### FOR CONVENTIONAL SPRAY AT 25 °C AND 65% RELATIVE HUMIDITY \*

<b>PART "A"</b> (Paint)	4	parts	(by volume)
<b>PART "B"</b> (2-K Hardener)	1	part	(by volume)
<b>UT100</b> Thinner	½	part	(by volume)

Allow the mixed paint to stand for 10 minutes before using to allow any evolved gases and/or entrapped air to escape. Failure to follow this procedure may lead to fine bubbling and/or pinholes in the dried paint film.

The use of any thinner other than those recommended by B.C. COATINGS may interfere with the polyurethane reaction and adversely affect the curing and subsequent film properties of the coating.

### APPLICATION GUIDE

It is inadvisable to apply 2-K Auto Undercoat or other 2-Pack polyurethane finishes at temperatures below 15°C or above 30°C and/or at relative humidities below 45% or above 85%, as these conditions will adversely affect drying and curing properties. Application conditions should be controlled to fall within the indicated ranges for temperature and relative humidity. Temperatures refer to air temperature only, substrate temperatures may vary by up to 10 °C from the air temperature.

Recommended air pressure is 300-450 kPa (45-65 p.s.i.) at the gun allowing for the pressure drop along the air line from the regulator.

Apply up to 3 cross coats in any one application session allowing approximately 15 - 30 minutes flash off between coats. Do **NOT** attempt to speed up the drying process by blowing compressed air onto the job. Excessive wet films are indicated by the formation of a "fatty edge" or "eyebrow" where excess paint has collected on the edges of the article being sprayed. In extreme cases the entire surface may have to be stripped off, re-prepared and re-painted.

Allow to dry overnight under ambient conditions or through a suitable force drying system before attempting to recoat. Sand down the surface with the required grit abrasive paper and remove resultant sanding dust before re-coating.

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### AIR DRY CURING SCHEDULES

Dust Free	- 10 - 15 minutes	Tape Free	- 6 - 8 hours
Tack Free	- 15 - 30 minutes	Hard Dry	- 16 hours
Print Free	- 2 - 4 hours	Dry To Recoat	- 16 hours

- \* UT101 Medium Thinner available for use at air temperatures > 30 °C.
- \* UT123 Fast Thinner available for use at air temperatures < 15 °C.

Curing times are adversely affected by excessive paint film thickness, improper surface preparation, improper drying conditions and incorrect hardener/thinner selection.

The different thinners can be blended to give the required properties to suit application and/or weather conditions.

### **NOTE**

ALL 2-Pack Polyurethanes require 7 - 10 days ambient curing before they attain their full chemical and physical resistance properties.

### **WARNING**

HARDENER PART "B" contains free organic iso-cyanate ( $\approx 0.50$  % w/w).

The use of the hardener as well as the mixed and thinned paint requires special precautions and the use of protective gear for application (APMF).

Long term storage at higher than normal temperatures will increase the free organic iso-cyanate content to  $\approx 0.90$  % w/w maximum.

Please refer to the appropriate Material Safety Data Sheets supplied by the manufacturer for health and safety information on the above products.

The information contained in this bulletin is given in good faith based on our laboratory and field experience. There are no warranties implied or expressed. It is recommended that the user determine the suitability of the product for the particular application under the user's actual conditions and application methods.