

DESCRIPTION

- an ultra-premium, two part recoatable isocyanate cured acrylic polyurethane finish
- conforms to AS/NZS 3750.6

PRINCIPAL CHARACTERISTICS

- excellent colour and gloss retention
- excellent resistance to exterior exposure
- superior colour reproducibility through intermix tinting system
- tough, flexible and abrasion resistant
- unlimited recoatability with suitable preparation
- high opacity white available for improved coverage
- range of hardeners and thinners available to provide flexibility in application
- resistant to splash of mineral and vegetable oils, white spirit, paraffins and aliphatic petroleum products
- resistant to splash of mild chemicals
- can be air dried or force dried up to 60°C on metal to improve throughput

Note: we advise that you test this product to determine if it is suitable for your particular use.

COLOURS AND GLOSS

- AS2700 Colour Card, high opacity white, jet black, coarse and fine metallic colours - full gloss

RECOMMENDED FILM THICKNESS (PER COAT)

	Minimum	Maximum	Typical
Dry film thickness microns	25	35	25
Wet film thickness microns	65	87	65
Theoretical spreading rate m ² /l	16.0	11.4	16.0

BASIC DATA AT 25°C AND 50% RELATIVE HUMIDITY

- vehicle type..... acrylic polyurethane
- solids content approx..... 40 % by volume
- mix ratio 2A:1B by volume
- dust free after 30 minutes (Std Part B)
..... 15 minutes (Fast Part B)
- touch dry after 5 hours (Std Part B)
..... 3 hour (Fast Part B)
- full cure 7 days (Std & Fast Part B)

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- best coating performance will be obtained with the highest degree of surface preparation
- degrease thoroughly to remove all oil, grease and other surface contaminants
- mild steel; remove all rust and any loose material by wire brush or mechanical sander, prime with Colourthane PF330 Primer Filler
- non-ferrous metals, stainless steel, galvanised iron, ZINCALUME[®], abrade using a Scotch-Brite[®] pad or wet and dry sandpaper. Do not use steel wool. Prime with Wattyl Super Etch[®] Primer
- Colourthane C-Series can be applied to suitable existing finishes, provided they are degreased and sanded
- laminates (eg. Laminex[®]); mechanically sand with 320-400 grade abrasive

- substrate temperature should be at least 3°C above dew point
- relative humidity should not exceed 75 % during application and before the dry to handle time

APPLICATION INSTRUCTIONS

- mixing ratio by volume 2A:1B
- mix Colourthane C-series Part A with Colourthane C-series Standard (Std), Fast or Slow Part B only
- induction time - none
- pot life at 25°C 4 hours for Standard (Std) Part B, 2 hours for Fast Part B. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions
- for best results it is recommended to use slow reducer above 25°C and standard reducer below 20°C, blends of the two reducers can be used for intermediate temperatures
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- recoat times for wet on wet; allow for a flash-off time of 5-10 mins between coats, can be recoated within 8 hours without sanding. If recoating after 8 hours sand with P320 - P400 between coats. If higher gloss is required, a coat of Colourthane C-Series Clear may be applied as soon as the colour is dust free. If applied after the coating is hard dry, sand with P400 - P600 before clear coating
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinner Colourthane Reducers or L748
 - volume of thinner up to 5 %
 - nozzle orifice approx. 0.28mm (0.011 inch)
 - nozzle pressure 15 MPa (2100psi)
- **AIR SPRAY**
 - recommended thinner Colourthane Reducers or L748
 - volume of thinner up to 10 %
 - nozzle orifice approx. 1.2-1.5 mm
 - nozzle pressure 350-450 KPa (50-60psi)
- **CLEANING SOLVENT** Colourthane Reducers or L748

REDUCER GUIDE

Temperature	<15 °C	20 °C	25 °C	30 °C	>35 °C
Colourthane Reducer Fast					
Colourthane Reducer Standard					
Colourthane Reducer Slow					
Thinner L748					

* thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- Use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this paint contains 0.023% monomeric diisocyanate when mixed. Provide adequate ventilation during use. Breathing the vapour is dangerous. Avoid breathing of fumes. Where applied by spray, use suitable air-fed respiratory equipment/hood at all times
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Safety Data Sheet (SDS)

ADDITIONAL DATA

Curing Table- using Standard Part B

Substrate temperature	5 °C	25 °C	60 °C
Dust free	50 mins	30 mins	5 mins
Touch free	8 hrs	5 hrs	15 mins
Dry to Handle	16 hrs	12 hrs	40 mins
Hard Dry	24 hrs	20 hrs	50 mins
Ready to Sand	20 hrs	16 hrs	45 mins

Curing Table- using Fast Part B

Substrate temperature	5 °C	25 °C	60 °C
Dust free	25 mins	15 mins	5 mins
Touch free	5 hrs	3 hrs	10 mins
Dry to Handle	8 hrs	6 hrs	20 mins
Hard Dry	16 hrs	10 hrs	25 mins
Ready to Sand	12 hrs	8 hrs	20 mins

* adequate ventilation must be continuously maintained during application and curing

Pot Life Table- (at application viscosity)

Substrate temperature	15 °C	25 °C	35 °C
Standard Part B	6 hrs	4 hrs	2 hrs
Fast Part B	3 hrs	2 hrs	1 hr

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar

STORAGE AND PACKAGING

- shelf life at least 12 months in an unopened container
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging Part A- 4Lts and 20Lts;
Part B- 2 Lts.

For the most up to date Information visit our website or Contact Valspar Customer Service Hotline on:

www.wattylpc.com
132 101 (Australia) or 0800 735 551 (New Zealand)



Quality
ISO 9001

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