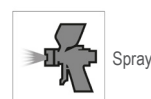


1906 **FORCE K10**

2K PROTECTIVE ACRYLIC FINISHING COAT WITH
TEXTURED EFFECT



Description and Use

Special textured effect finish formulated with acryl-polyurethane resins, semi-gloss, hardened with aliphatic isocyanates. Suitable for painting cycles where high resistance to scratches and weathering is required and typically used in the cargo compartments of pick-ups, vehicle interiors, finishes in general where a particular textured aesthetic effect is required. It can be applied directly on various supports, or in combination with our primers or epoxy bases. The finish has good chemical resistance, impact resistance, scratch resistance and abrasion resistance. It can be coloured using the ADVANCE HT tinting system.

Substrate preparation

IRON SURFACES:

- Remove any trace of rust, iron scale, grease and moisture by sand-blasting SA2.5 grade; otherwise, carry out a careful mechanical cleaning followed by solvent degreasing.
- Applicable directly on the prepared substrate as previously indicated, to obtain a higher overall performance, we suggest applying EPOKAR PRIMER cod. 1385 / FONDO EPOX cod. 1806 and then the finish.

GALVANIZED STEEL:

- Remove iron scale and foreign matters, degrease carefully with organic solvents.
- Applicable directly on the prepared substrate as previously indicated, however given the large variety of galvanizations present on the market, we suggest the application of EPOKAR PRIMER cod. 1385 / FONDO EPOX cod. 1806 and then the finishing.

PLASTICS:

- Clean carefully from foreign waste and degrease perfectly with organic solvents.
- Apply a plastic primer such as TREND cod.1540 or Uniprimer spray cod. 2001, according to the respective technical data sheets, then proceed with the application of the finish.

ALUMINIUM AND LIGHT ALLOYS:

- Chromatising or phosphochromatising treatment; otherwise, slight matting with sandpaper followed by organic solvent degreasing.
- Applicable directly on the prepared substrate as previously indicated, to obtain a higher overall performance, we suggest applying EPOKAR PRIMER cod. 1385 / FONDO EPOX cod. 1806 and then the finish.

OLD HARDENED PAINTS OR OEM FINISHES

- Sanding with P240 / P320 sandpaper, followed by thorough cleaning with ANTISILICONE code 1618.

Application

Application method:

- For fine-peel finishes, we recommend a conventional airbrush with a Ø 2.0-2.5 mm nozzle and a pressure of 2.5-3.0 bar. Depending on the desired embossed-effect, you can use up to a maximum of 10% of ACRYLIC THINNER code 1653.
- For coarse-peel finishes, it is recommended the use of the FORCE K10 gun with a Ø 5 mm nozzle and a pressure of 2.0-4.0 bar. In order to obtain a uniform coverage, it is advisable to apply a first "thinner" coat (with a traditional airbrush), so as not to leave parts of the surface "uncovered".

Product preparation:

- Add the hardener "B" to part "A", shake until the product is uniform, proceed with adding the colour, cap and shake until the colour is uniform.
- To colour FORCE K10, add 90 grams of solvent-based colouring paste to the base package.

	By weight
PRODUCT 1906 FORCE K10 COLORATO	100
HARDENER 4376 INDURITORE UHS STD	20

Recommended thicknesses:

Depending on the desired finish.

Storage life

It is recommended to keep the product away from light and water.

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 12 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with current legislation.

Technical features

Colour	see price list
Appearance of the dry film	semi-glossy
Type of product	two component
Pot-life	1.5 hours. At higher temperatures pot-life decreases.
Viscosity **	thixotropic
Practical cover rate *	depending on the desired finish
Air drying (20°C and 65% R.H.)	30-45 minutes. dust-free
	2-4 hours, touch free
	24 hours, through drying
Oven drying (60°C)	5-10 minutes, flash off
	30-60 minutes, through drying
Maximum chemical resistance	after 7 days
EU limit values for VOC content (Directive 2004/42/EC)	Category B/e, SB: VOC max 840g/l product VOC < 840g/l
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
** May change according to the colour.	
The data are measured at a temperature of 20°C.	

TRIAL	REFERENCE	TEST LIQUIDS	EVALUATION OF RESULTS
CHEMICAL RESISTANCE	UNI EN ISO 2812-4 continuous contact for 24h	Diesel	No changes
		Hydraulic oil	No changes
		Brake oil /DOT 4 type oil	No changes
		Acetic acid /50% w/w aqueous solution	light opacity
		Sodium hydroxide /50% w/w aqueous solution	light opacity
ADHESION	UNI EN ISO 2409	Iron	0*
		Aluminum	0*
		Hot galvanizing	0*
		Electro-galvanized	0*
*Legend: GT = 0 complete adhesion; GT = 5 no adhesion			

Warnings

- For professional use only.
- Always refer to the safety data sheet for the relevant products.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- During application, it is recommended to follow the thicknesses specified for each single coat. Otherwise, and especially in case of high environment temperature, blisters may come up on the film surface.
- Do not apply the product after the specified pot life, as the film that forms may have poor adhesion to the substrate.
- It is recommended to acquire all the material required to finish the work of the same batch.
- Gun and tools cleaning must be done before product get harder, using any thinner. Possible crusts of hardened product can be taken away only by scraping off.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.tecnica@impa.it.