

1923 FINITURA PU 420 UHS

ACRYLIC FINISH



Two-component



Spray

Advantages

- Very high solid contents
- Easy application

Description and Use

High quality non-yellowing glossy acrylic enamel, with a high solid content (VOC less than 420 g/l), characterized by easy application, rapid drying and good surface hardness.

Suitable for finishing industrial and commercial vehicle bodywork.

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.
- Apply FONDO EPOX cod. 1806 or EPOKAR PRIMER cod. 1385.
- In body shop work, in order to obtain a high quality finish, we recommended to use an insulating primer STAR PRIME HT code 1543 or EQUALIX HS code 1513.

GALVANIZED STEEL:

- Carefully clean off any debris and oxidation, degrease thoroughly with organic solvents and apply FONDO EPOX code 1806 or EPOKAR PRIMER code 1385.

ALUMINIUM AND LIGHT ALLOYS:

- Chromatising or phosphochromatising treatment; otherwise, slight matting with sandpaper followed by organic solvent degreasing.
- Apply FONDO EPOX cod. 1806 or EPOKAR PRIMER cod. 1385.

Application

Application method:

- Air spray gun (conventional) with nozzle Ø 1.2-1.4 mm and pressure of 2.0 bar.
- HVLP gun: nozzle Ø 1.2-1.4 mm; follow manufacturer's instructions.

Product preparation:

Stir thoroughly the product to achieve even colour and consistency.

Then add in the following ratio:

	By weight
PRODUCT 1923 FINITURA PU 420 UHS	100
HARDENER 4386 INDURITORE SLOW UHS or 4376 INDURITORE STANDARD UHS or 4396 INDURITORE FAST UHS	50
THINNER 1653 DILUENTE PER ACRILICI	0 - 5 %

The choice of hardener to use depends on the environmental application temperature and the size of the surface to be painted.

Storage life

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 18 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	glossy	
Gloss	>90 gloss (Gardner 60°)	
Type of product	two component	
Pot-life	60 minutes. At higher temperatures pot-life decreases.	
Application viscosity**	18 - 22 sec. cup FORD 4	
Number of coats recommended	2 waiting 5-10 minutes between 1st and 2nd coat	
Recommended wet thickness	approximately 100 µm per coat	
Recommended final dry thickness	50 - 60 µm	
Theoretical cover rate *	50 - 60 µm	
Theoretical consumption ***	Air spray gun (conventional)	190 g/m²
Air drying (20°C and 65% R.H.)	10-15 minutes, dust free	
	3-4 hours, dry to touch	
	8-10 hours, through drying	
Oven drying (50°C)	If necessary 20 min @ 50°C	
Maximum chemical resistance	after 7 days	
EU limit value of VOC content (Directive 2004/42/EC)	Category B/d, SB: VOC max 420g/l product VOC < 420g/l	
AFNOR NF T 36-005 classification	Family I - Category 7b1	
*The cover rate has been calculated based on the recommended dry thickness of 60 µm, on flat and regular surfaces without taking into account the variables facing during the application phase.		
** May change according to the colour.		
***The theoretical consumption calculated to achieve the recommended dry thickness of 60 µm.		
The data are measured at a temperature of 20°C.		

Warnings

- For professional use only.
- Always refer to the safety data sheet for the relevant products.
- Apply only the suggested thickness. Otherwise, and especially in case of high environment temperature, blisters may come up on the film surface.
- Do not apply at temperatures below +10°C.
- Do not apply the product after the specified pot life, as the film that forms may have poor adhesion to the substrate.
- 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.
- 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 and the tinting of the product can lead to slight deviations in the declared values, in the colour and in the aesthetic effects obtained. 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.technica@impa.it.