Metalux™ 2K Polyurethane Single Stage

COMPONENTS	2K Polyurethane Single Stage Hardeners 9082, 9091, 9092, 9093 Reducers 1156, 1157, 1158
APPLICATION	2 single coats 5 - 10 minute flash between coats
MIX RATIO	3 : 1 : 10-20%
DRY TIME	30 Minutes
VISCOSITY	Ford #4 15 - 18 seconds 77° F / 25° C
VOC	599 grams / liter 5.0 lbs / gallon

GENERAL

DESCRIPTION

This 2K Polyurethane Single Stage has been formulated for use in restoration of passenger cars. Designed for universal application and repairs. The outstanding durability, high gloss and excellent flow make this product an excellent choice for the car refinisher.

COMPATIBLE COATINGS

Compatible with Metalux™ primer, sealer, and clearcoat products

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Mix 3 parts Metalux 2K Polyurethane Color to 1 part Metalux Hardener. Thin 10 - 20% using Metalux Universal Reducers (15 - 18 secs with #4 Ford @ 77°F/25°C). Mixed VOC NR 5.0 lbs/gal.

Note: When using Metalux accelerator, first, add 1 - 2% to color, then add hardener and reducer as required.

Component	Volume
Metalux 2K Polyurethane Color	3
Metalux Hardener (9082 Ultra Fast, 9091 Fast, 9092 Medium, 9093 Slow)	1
Metalux Universal Reducers	20%

Package Sizes
- 1 gallon (3.75 liters)
- 1 liter (1 liter)

INITIAL APPLICATION VISCOSITY
Ford #4 Viscosity 15 - 18 seconds @ 77°F/25°C

APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.5 mm	2.0 - 2.5 (Bar)	8-10 PSI	*At the cap
High Efficiency	1.3 - 1.5 mm	2.0 - 2.5 (Bar)	29-40 PSI	At gauge

Note: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

APPLICATION
Apply 2 single coats with 5 - 10 minute flash off between coats.

RECOAT
Can be re-coated before 8 hours or after 24 hours. Also may be topcoated with Metalux Clears after 30 minute flash at 75°F/24°C. Cooler temperatures may require longer flash times.

DRY TIMES

AIR DRY
75°F (23°C) at recommended film thickness

Hand Slick	10 Minutes
Dust Free	30 Minutes
Tape Free	4 – 6 Hours
To Clearcoat	30 Minutes
Dry to Handle	Overnight (after clear)
Flash Before Force Dry	5 – 10 Minutes
Force Dry Time	30 Minutes @140°F/60°C Metal Temperature
To Sand/Buff	After Cool Down (1 – 2 Hours)

PHYSICAL PROPERTIES

Recommended Film Thickness	± 25 Micron / 1.0 mils per coat
Mixed Volume Solids	34% (Average)
Theoretical Coverage	Approx. 546 Sq. Ft. @ 1 Mil DFT/mixed gallon
Recommended Coats	2 (x1)
DFT per Coat	Approximately 1.0 mil
Ford #4 Viscosity	15 – 18 seconds

PERFORMANCE PROPERTIES

Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6 hours Base (NaOH) – No effect, 6 hours
Film Hardness	2H
Impact Resistance	Forward – 80 in/lbs Reverse – 40 in/lbs

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

VOC REGULATED AREAS

VOC as Applied	599 grams/liter | 5.0 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States and Canada:
1.855.6.AXALTA
metalux.us