



2K URETHANE—TOP COAT

(FORMER HARDNOSE)

Application Information

IF USING MORE THAN ONE CAN MIX ALL THE CANS TOGETHER TO ENSURE THE COLOUR IS UNIFORM.

Warning: Please read and understand the following instructions thoroughly. Failure to do so can result in premature coating failure and / or a big mess!

- **Mix 1 part Hardener to 3 parts 2k Urethane**

Colours: Black, Dark Blue, Light Blue, Safety Red, Dark Yellow, Light Yellow, Orange, Dark Green, Light Green, Dark Gray, Light Gray.

PRODUCT DESCRIPTION:

2K Urethane Top Coat Is a high gloss rock hard coloured topcoat that can be applied over a number of surfaces, including heavy-duty vehicle chassis and trailers, floor pans, agricultural machinery, and many marine applications as well, including motors, heat exchangers, pumps, masts, decks and handrails. Hardnose coatings can also be used to protect equipment from strong acids, alkali, and other aggressive materials. It can be applied over existing single and two component primers as well as in a complete POR-15 paint application which would include POR-15 Rust Preventive Paint as a primer and POR-15 Tie Coat Primer or U-POL Acid 8 as a linking coat.

2K Urethane Top Coat will not leave brush marks, if painted correctly and will dry in less than 1 hour, but will take 3 or 4 days to reach maximum hardness.

When 2K Urethane Top Coat is first dry to the touch, it will appear very soft. Avoid touching it for several days until it becomes hard and tough. Accidental contact could damage the surface before full cure has taken place.

Like many other POR 15 coatings, 2K Urethane is a moisture cured coating.

PRODUCT COMPOSITION

Your 2K Urethane Top Coat purchase consists of two items:

- 1) A can, labelled 2K Urethane Top Coat, the Resin/ paint
- 2) A smaller can, labelled Hardener/Activator.

SURFACE PREPARATION

Surface to be coated should be dry and free of grease, oil and other contaminants. Use POR-15 Marine Clean diluted 1 part POR-15 marine Clean to 8 parts water to remove light contamination, then rinse with water and dry well.

PRODUCT BLENDING / MIXING

- Mix the two products together by blending together in a separate, resealable clean container, a clean glass jar works best. (3: 1)
- Stir the combined contents thoroughly.

Your can of Hardener/Activator is sealed tightly. Remove lid carefully to avoid spillage or splash.

Your Hardener/Activator is very sensitive to moisture and humidity, so try to open it in a dry area. Keep it tightly capped when not in use.

Partial Blending

- You may mix partial quantities of Hardnose for small jobs, use any measuring device you happen to have around (coffee scoop, measuring spoon, cup etc.).
- All you have to do is follow this formula:
- **Mix 1 part Hardener/Activator with 3 parts 2K Urethane Top Coat MIX WELL .**

2K Urethane Top Coat can remain useable for up to 4 hours if the lid is kept on the mixed batch when not in use. (Min. air in the can)

APPLYING 2K URETHANE TOP COAT OVER OTHER PRIMERS:

- 2K Urethane Top Coat can be over coated on both single and 2 Pack primers.
- Clean surface with POR-15 Marine Clean (ratio of 8 parts water to 1 part POR-15 Marine Clean for light contamination).
- Rinse with clean water, and dry.
- Key with 300 /600 grit Wet and Dry paper.
- Tack wipe with dry tack cloth.
- Apply 2 coats of 2K Urethane 20-30min apart.

TO PAINT OVER A CURED POR-15 SURFACE

- Key with 600 W&D grit sand paper.
- Clean with POR-15 Marine Clean (ratio of 8 parts water to 1 part POR-15 Marine Clean) for light contamination.
- Then apply one light coat of POR-15 Tie Coat OR
- U Pol Acid 8; allow to cure for 1hr at 20°C
- POR-15 Tie Coat allow to cure for 1 - 2 days (longer in cooler temperatures).
- Sand if necessary with 600 grit W&D
- Tack wipe with dry cloth.
- Apply 2K Urethane Top Coats as final finish.

AS A COMPLETE POR-15 PAINT SYSTEM:

- Apply two coats of POR 15 Rust Preventive Paint over a sandblasted surface or a surface prepared with POR-15 Marine Clean and POR-15 Metal Ready.
- Then apply one light coat of POR-15 Tie Coat (or Acid 8), as soon as POR 15 Rust Preventive Paint has cured (12-24hrs), to maximise adhesion.
- Allow the POR-15 Tie Coat to cure for at least 24 hours at 20°C or 1hour for the Acid 8 for .
- Then sand smooth and finish off with 300 grit sandpaper if necessary.
- Wipe down with dry tack cloth.
- Apply 2K Urethane Top Coats 20-30min apart.
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PRODUCT APPLICATION:

- Apply a minimum of 2 full coats for general automotive use, and a minimum of 3 full coats for marine use, (plus a dust or tack coat if spraying).
- 2K Urethane Top Coats may be applied with any type of brush you prefer or roller. It will flow out immediately, eliminating brush and roller marks.
- Lay down a medium coat, work from one side away from the start don't backtrack.
- **A second coat may be applied when touch dry, usually 20 - 30 minutes later at 20C.**
- The second coat may be left up to 2 days before re-coating without sanding

Best method—recoat at 2 - 3 hourly intervals. In temperatures below 180C drying times will be extended and consequently runs maybe more likely.

- To minimize this in colder temperatures, small items can be warmed with a heat gun, or air temperature raised for larger items. DO NOT over-heat items above 24°C
- Thin only with PPC Solvent, if required, for brushing you may need up to 5% if it's not flowing smoothly. PPC Solvent or GP thinners may be used for clean up.

Note: When applying a second or third coat by brush, surface tension may increase between coats add up to 5% PPC Solvent.

SPRAY PAINTING:

(Note: it is illegal to spray a two pack paint in Australia without a spray booth)

- 2K Urethane Top Coats prefers low pressure application.
- Syphon or Pot Gun application use approx. 25 psi (180 kpa).
- HVLP or top container gun use approx. 15 -18 psi (120 kpa).
- At 16°C –22°C thin with POR-15 Solvent 5-15%.
- At 22°C-28°C thin with POR-15 Solvent 15-25%.
- Avoid temperatures over 280C where possible

Spray Booth:

Best temperature 220C, 50% humidity, low air flow.

Note:

- Remember thinning rates are a guide only, consider the type of gun, nozzle size, air temperature and humidity.
- Cured 2K Urethane Top Coats can be cut with regular compounds if you have a run or imperfections, though it is best if you leave it for a week or two before cutting to make sure coating is hard (runs may take longer to fully cure due to added thickness).

Humidity Control when spraying 2K Urethane Top Coats :

- Humidity should be 60% or lower when spraying
- Higher humidity may cause it to set too quickly before it has a chance to flow out evenly, thus resulting in a wavy appearance. Whenever possible, spray in a humidity-controlled (air conditioned) environment.
- Best temperature 18 – 24 C. If this is not possible apply 2K Urethane Top Coating the morning when temperatures are at their lowest.
- 2K Urethane Top Coats can be applied successfully in higher humidity, but temperatures must be below 25° C. In temperatures over 30°C the humidity must be low. Avoid high humidity and high temperatures.

CURING:

- Remember 2K Urethane Top Coats will not perform as specified until it has cured for a minimum of 4 days at an average temperature of not less than 18°C.
- Do not put engine parts and the like into service before the 4 day cure time.

Elevated temperatures will not speed up cure.

QUESTIONS & ANSWERS

Can I apply 2K Urethane Top Coats directly over metal?

Yes, you can, but you won't get the same adhesion or levelling as you do with Rust Preventive Paint as a primer.

Can I apply 2K Urethane Top Coats directly over POR-15 Rust Preventive Paint without POR-15 Tie Cote?

Yes, you can, but adhesion problems might occur on edges or corners. Also, runs are more likely.

What if I have different size cans or cans with different batch numbers? I want to make sure my final coat is 100% colour uniform. Make sure that at least one can will be enough for the entire final coat. If not, you will need to blend all of the resin cans together so you will have enough for the entire final coat.

Please remember these instructions are general guide lines only and cannot and do not cover every application and environment. If you remain unsure how to proceed, please call toll-free for technical advice at 1800 643 229

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PERMANENT PAINTED COATINGS LTD

Unit 1 / 4 Prosperity Parade

WARRIEWOOD NSW 2102

Phone free: 1-800 643 229

Telephone: 02 9999 0122

Fax: 02 9999 0394

Website: www.ppcco.com.au

Email: sales@ppcco.com.au



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