

TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

SQ-216 2:1

2K URETHANE CLEARCOAT

PRODUCTS

SQ-216 2:1 2K Urethane clearcoat
Hardener MEDIUM 1:2 for SQ-216 2K Urethane clearcoat
Urethane Reducer INTER TROTON

PRODUCT DESCRIPTION

2K clear coat 2:1 recommended for fast partial or complete car body repair. Features easy use, perfect transparency and high gloss. Its main characteristics are fast drying time, high gloss durability and scratch resistant coating.

- Easy application and universal use.
- Hard and durable finish.
- Good fluidity.
- High scratch resistance.



COLOUR: transparent

GLOSS GRADE: high gloss

VOLATILE ORGANIC COMPOUNDS

VOC for the mixture = 535 g/l - 4.465 [lb/gal]

SURFACE PREPARATION

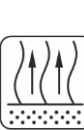
Urethane clearcoats can be applied over:

- Basecoats.
- Properly cleaned and sanded OEM finishes

For application over recommended basecoat system:

- Allow basecoats sufficient dry times.
- Over OEM sand finish dull with P800 or gray scuff pad.

APPLICATION PROCESS

	USE		SPRAYING VISCOSITY
	For automotive refinishing repairs that require a durable finish.		15÷17 seconds at 68°F (20°C)/DIN4
	MIXING RATIO By volume		POT LIFE
	Clear coat Hardener Reducer		about 5 hours at 68°F (20°C)
	NUMBER OF COATS & SPRAY GUN SETTINGS		DRYING TIME
	Number of coats 2-3 full coats, about 40 µm (1.6 mils) of dry coat Compliant (RP) spray gun: 1.3÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) HVLP spray gun: 1.3÷1.4 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar). Note: follow the gun producer's recommendations.		At temperature of 68°F (20°C) Dust free: after about 35-40 min Ready to polish: after drying overnight. At panel temperature of 140°F (60°C) Clear coat is ready to polish after about 30 minutes of baking and cooling down (about 2 hours). Temperatures below 20°C (68°F) significantly increases the drying time.
	FLASH OFF TIME		IR DRYING
	Between coats: Approx. 5 minutes Before baking: Approx. 10 minutes		15÷20 minutes under short waves, depending of the layer thickness and type of radiator. Do not exceed temperature of 140°F (60°C). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting IR drying.

EFFICIENCY

1 liter of mixture is enough to cover a surface of 9 m² , yielding a dry film thickness of 50 µm (1.97 mils).

POLISHING AND ELIMINATING DEFECTS

Usually polishing is unnecessary, as the SQ-216 2:1 Urethane clearcoat gives the surface a perfect finish immediately after application. However, if some dirt inclusions appear, we recommend removing them and then polishing the surface with an abrasive compound.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
 - The best repair results can be achieved by painting at room temperature. The temperature in the body shop and the temperature of the product should be similar.
 - When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and airways.
 - The rooms should be well ventilated.
 - Clean the guns and equipment immediately after use.
- Caution: To maintain safety, always follow the instructions given in the MSDS for the products. Do not exceed recommended doses of hardener!

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STORAGE

Store the product components under temperatures of 59 to 77°F (15 to 25°C) in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use close the container with products immediately.
2. Protect the hardener against Frost and humidity!

WARRANTY PERIOD

SQ-216 2:1 2K Urethane clearcoat	- 24 months from the date of production
Hardener MEDIUM 1:2 for SQ-216 2:1 2K Urethane clearcoat	- 12 months from the date of production
Urethane Reducer INTER TROTON	- 24 months from the date of production

PRODUCTS	ART. No.
SQ-216 2:1 2K Urethane clearcoat	14538; 14539 (1l; 5 l)
Hardener MEDIUM 1:2 for SQ-216 2K Urethane clearcoat	14540; 14541 (0,5l; 2,5l)
Urethane Reducer INTER TROTON	300009942; 300009943 (1l; 5l)

LIMITATION OF LIABILITY

The information contained in this TDS sheet is up-to-date and correct on the day the information is released.

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