

TECHNICAL DATA SHEET

FOR PREFESSIONAL USE ONLY

SQ-538 4:1

2K URETHANE CLEARCOAT

PRODUCTS

SQ-538 4:1 2K urethane clearcoat

Hardener MEDIUM 1:4 for SQ-538 clearcoat

Hardener SLOW 1:4 for SQ-538 clearcoat (for application at temp. > 25°C/77°F)

Hardener FAST 1:4 for SQ-538 clearcoat (for application at temp. < 18°C/64.4°F)

PRODUCT DESCRIPTION

2K urethane clearcoat with high gloss and increased resistance to scratches SR (Scratch Resistant). Characterized by its universal use. Features easy application and is ready to use without the addition of reducer. The availability of 3 versions of hardener (medium, fast, slow) allows working in different temperature conditions.

- Ready to use without the addition of reducer.
- Easy application and universal in use.
- High gloss.
- Hard and durable finish.
- High scratch resistance.
- Good fluidity.


COLOR: transparent

GLOSS GRADE: high gloss

VOLATILE ORGANIC COMPOUNDS

VOC for the mixture = 594 g/l - 4.96 [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.		14÷16 seconds at 68°F (20°C)/DIN4
MIXING RATIO		POT LIFE	
	By volume		about 8 hours at 68°F (20°C)
	Clearcoat 4		
	Hardener 1		
	Reducer 0%		
NUMBER OF COATS & SPRAY GUN SETTINGS		DRYING TIME	
	Number of coats 2-3 full coats, about 30 µm (1.18 mils) of dry coat		At temperature of 68°F (20°C) Dust free: after about 30-35 min Ready to polish: after drying overnight.
	Compliant (RP) spray gun: 1.3÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)		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).
	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).		Temperatures below 20°C (68°F) significantly increases the drying time.
	Note: follow the gun producer's recommendations.		
FLASH OFF TIME		IR DRYING	
	Between coats: 5÷10 minutes		15÷20 minutes under short waves, depending of the layer thickness and type of radiator.
	Before baking: Approx. 10 minutes		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 7,5 m² , yielding a dry film thickness of 50 µm (1.97 mils).

POLISHING AND ELIMINATING DEFECTS

Usually polishing is unnecessary, as the SQ-538 4:1 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-538 4:1 2K urethane clearcoat	- 24 months from the date of production
Hardener MEDIUM 1:4 for SQ-538 clearcoat	- 12 months from the date of production
Hardener SLOW 1:4 for SQ-538 clearcoat	- 12 months from the date of production
Hardener FAST 1:4 for SQ-538 clearcoat	- 12 months from the date of production

PRODUCTS

ART. No.

SQ-538 4:1 2K urethane clearcoat	14785; 14786 (1; 3,78l)
Hardener MEDIUM 1:4 for SQ-538 clearcoat	14787; 14788 (0,25l; 0,945l)
Hardener SLOW 1:4 for SQ-538 clearcoat	14783; 14875 (0,25l; 0,945l)
Hardener FAST 1:4 for SQ-538 clearcoat	14782; 14874(0,25l; 0,945l)

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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