



GLOBAL PAINT COMPANY



2K POLYURETHANE

Description:

Two-pack Polyurethane for passenger cars, commercial vehicles and equipment. Designed for universal application. For new work and repairs. The outstanding durability, high gloss and excellent flow make this product and excellent choice for the car refinisher and DIY enthusiast.

Product and Additives

METALUX 2 2K Polyurethane
METALUX 2 Normal Hardeners 8749, 8750, 8767, 9072 or
METALUX 2 MS Hardeners 9082, 9091, 9092, 9093
METALUX 2 Thinner Fast, 1177 / Normal, 1159 / Slow, 1171

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784

Basic Raw Materials:

METALUX 2 2K Polyurethane: acrylic resin
METALUX 2 Hardeners: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K Polyurethane can be applied over:
- Existing Finishes except Thermoplastic Acrylics, lacquers and NC products.
- All METALUX 2 primers.

Surface Preparation:

Degrease then wet flat P800 – P1000 grit or dry flat P400 – P600 grit (DA).
Wipe surface after sanding with wax and grease remover.

Mixing Ratio:

3:1 by volume with MS Hardener or 2:1 by volume with Normal Hardener
10-20% by volume METALUX 2 2K Thinners, to spray viscosity of
16-18 seconds with # 4 Ford Cup @ 25°C / 77°F.

Note: If mixed 3:1 and thinned with 0 VOC reducer, then RFU VOC is
below 5.0 lbs/gallon.

Note: When using METALUX 2 Accelerator, add 2 to 5% to colour first and then
add hardener and thinner as specified
(NOT recommended with Ultra Fast Hardener, 9082).

Pot Life:

When mixed, 4 hours @ 25°C / 77°F.

Note: Accelerator will shorten pot life.

Process:

Apply 2 single coats allowing 5 to 10 minutes flash between coats.
An additional coat may be required with colours difficult to cover.

Spray gun settings:

HVLP Gravity:	1.3 – 1.5mm	0.5 – 0.6 BAR / 8 – 10 PSI	At the cap
High Efficiency:	1.2 – 1.5mm	2.0 – 2.7 BAR / 30 – 40 PSI	Inlet pressure
Conventional:	1.4 – 1.6mm	3.0 – 4.0 BAR / 40 – 60 PSI	Inlet pressure

Note: Refer to spray gun manufacturer for further information regarding
inlet pressures.

Film Thickness:

± 25 microns / 1.0 mil per coat



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Drying Times: Dust free: 20 minutes @ 25°C / 77°F
Hard Dry: 24 hours @ 25°C / 77°F
Force Dry: 40 minutes @ 60°C / 140°F

Infrared Waves (IR): 20 minutes @ 75°C / 165°F.

Note: Always refer to IR manufacturer's instructions and TDS.

Recoatibility: 24 hours. Best after full cure (\pm 7 days @ 25°C / 77°F)

Cleaning of Equipment: Clean equipment immediately with quality lacquer thinner.

Health & Safety: Refer to text on label and MSDS. Flammable – keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.