

**PRODUCT DESCRIPTION**

A high performance, two-component Acrylic Polyurethane designed for application on a variety of substrates including fiberglass, ferrous metals, properly prepared non-ferrous metals, and a variety of plastics.

**Sheen:** Gloss

**PRODUCT AND PERFORMANCE DATA**

**Product Data**

Property	Result
Volume solids (%)	48 ± 2
Weight solids (%)	62 ± 2
VOC	475 g/l 3.96 lb/gal
Recommended dry film thickness	1.5 – 5 mils
Recommended wet film thickness	3 – 10 mils
Theoretical Coverage (1.0 mil)	770 ft <sup>2</sup> /gal
Dry to Handle @ 75 F. and 50% RH	1 hour
Recoat @ 75 F. and 50% RH	<45 min or after 8 hours
Full Cure @ 75 F. and 50% RH	1 week
Pot Life @ 75 F. and 50% RH	2-3 hours

**Performance Data**

Test Method	Standard	Result
Gloss @ 60°	ASTM D523-14	90+
Adhesion	ASTM D3359	5B
Impact Resistance	ASTM D2794-90	>120 in-lbs
Pencil Hardness	ASTM D3363	5H

*Testing performed on 35U100 (white) after 15 min @200°F on CRS*

**SURFACE PREPARATION**
**Pre-cleaning:**

Clean all surfaces to be coated in accordance with SSPC-SP-1, Solvent Cleaning prior to additional surface preparation or coating application. Surface must be clean, dry and free of any dirt, dust, oil, and all other visible contaminants.

**Surface Preparation**

Recommended	SSPC SP 6 (Commercial Blast Cleaning)
Minimum	SSPC SP 2 or SP 3 (Hand or Power Tool Cleaning)

**MIXING AND THINNING**

Before application, mechanically mix for 5 minutes at the ratio of **3:1**.

*3 parts 35U to 1 part U-99 catalyst*

Catalyst	46K001 (U-99)
----------	---------------

**Mix Directions**

Stir thoroughly before and occasionally during use.

**Thinning Directions**

Product packaged ready to apply. If needed thin up to 10% maximum with Forrest's 81T007, Polyurethane Thinner.

Accelerated cure	03U001 (0.5 – 2 oz./gal)
Retarded cure	03U000 (5 – 7 oz./gal)

**APPLICATION**
**Application Parameters**

Relative Humidity	<70%
Minimum Temperature	50°F (10°C)
Maximum Temperature	80°F (27°C)

*The application temperature must be a minimum 5°F above the dew point.*

**Force Cure Schedule**

Temperature	200°F (93°C)
Time	15 minutes

**Application methods**

The product can be applied by

**Spray**

Airless spray: 0.009" - .015"

Conventional spray: 1.0mm – 1.8mm

**Brush/Roll**

Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

**STORAGE****Storage**

The product must be stored in accordance with local and national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 73°F (23 °C) = a minimum of 12 months \*

\*When kept in recommended storage condition and original unopened containers.

**CAUTION**

Adequate health and safety precautions should be observed during storage, handling, use and curing periods.

**READ SAFETY DATA SHEETS BEFORE USING THIS PRODUCT**

**DISCLAIMER**

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstances are we liable for incidental or consequential damages.