

1 PACK POLYURETHANE Q.D.

INTENDED USE

VEHICLE REFINISH and ORIGINAL COATING of VEHICLES or TRAILERS

A high performance fast drying, high build, high gloss durable finish for commercial transport. Typically dries with a tack free time of 2 - 3 hours, and can be taped up, using low tack tape within 6 to 8 hours for 'same day two-tone work'.

VOC classification is 2004/42/IB(d)(420)(420). Do not add thinners

METAL FINISHING – particularly Agricultural & Construction Equipment (ACE).

Widely used in the Agricultural & Construction Equipment sectors, where it is usually applied by airless spray. It is only occasionally used in the general METAL FINISHING sector instead of Fast Enamel or QD Enamel when an 'exhibition finish' is required or if there is a need for more resistance to cutting oils and mild chemicals.

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

SUITABLE SUBSTRATES AND PREPARATION

Surfaces must be dry, sound and free from dirt, dust, oil and grease. Prime / Undercoat with Manor UPF for conventional spray and Manor Agriprime CT for airless, and air assisted spray. Previously painted glossy surfaces should be lightly abraded prior to application of the primer / undercoat to gain adhesion. Any non-ferrous metals should first be pre-treated with Manor Wash Primer or Manor 1 Pack Etch Primer CT

AVAILABILITY

5 and 20 litres, available in an extensive range of BS, RAL, and other colours from the MANORMIX scheme.

PRODUCT INFORMATION (TYPICAL FIGURES)

Composition	Based on a polyurethane modified medium oil alkyd resin and pigments selected for their light fastness and exterior durability.
Volume Solids	49%
Weight Solids	54 - 65%
VOC content	420 gm/litre
Typical film thickness	40 microns dry at 80 microns wet
Theoretical Coverage	12.5 sq. metres/litre at 40 microns dry.
Dry heat resistance	80°C
Flash Point	HIGH FLASH in the range 32 – 55°C (flammable)

APPLICATION DETAILS**PREFERABLY BRING PAINT TO 15-25°C AND STIR WELL BEFORE USE.**

Airless spray Ready for use for vehicle chassis.
For METAL FINISHING or ACE up to 5% thinners may be added to suit equipment. For ACE, hot airless spray is often used.

(hot or cold) Typical tip size 11-13 thou. or 0.27-0.33 mm.
Typical fluid pressure 140 kg/sq. metre or 2000 p.s.i.

Conventional spray Add no thinners for vehicle refinish use. A pressure pot, or hot spray at 60-80°C must be used

For METAL FINISHING or ACE , up to 15% thinners may be used

Brush/Roller Only small areas.

Thinner Synthetic Thinner CV

Film thickness per coat

	Dry	Wet
Minimum	30 microns	60 microns
Maximum	50 microns	100 microns

DRYING AND RECOATING

Approximate drying times at 40 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10°C	4-6 hours	16 hours	3 Days (see note)
20°C	2-3 hours	6 hours	

Environmental Conditions The air temperature should be at least 5°C with a surface temperature 3°C above dew point and the relative humidity below 90%. The drying times will be significantly extended in cold, damp conditions.

Overcoating/Repainting Usually applied wet on wet
If left for more than 3 days between coats, it is important to lightly abrade the coating to ensure good intercoat adhesion. To repair runs and sags allow the first coat to dry such that the film can be lightly abraded to remove the defect, then leave the flatted surface to "heal up" overnight before re-coating.

SHELF LIFE

Store in cool, dry conditions, typically 5-25°C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

SAFETY PRECAUTIONS

REFER TO THE MANOR SAFETY DATA SHEET

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