



**TECHNICAL
DATA SHEET**

Factory Pack 2K Single Stage Paint

Acrylic Urethane Single Stage Coating - 2.8 VOC



Description

High Teck Factory Pack 2K Single Stage 1400 Series Colors are Direct to Metal (D.T.M.), high solids, high gloss, 2.8 VOC coatings intended for use in automotive and industrial applications. Offers superior protective maintenance for surfaces exposed to humidity, chemicals and corrosive elements. Available in 18 colors.



Surface Preparation

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively.
2. Clean area with Wax and Grease Remover or low VOC cleaner.
3. Use a tack cloth to remove any surface contaminants that may have settled on the repaired areas prior to paint application.
4. Apply 1400 series High Performance Factory Color.

****DIRECT TO METAL ADHESION: Performance is better when using 7330 DTM Primer under 1400 Series.****



Pot Life

Pot life will be a minimum of 2 hours at 77° F.



Mixing Directions (4:1:1)

4 PARTS 1400 Series Paint
1 PART 1020 Catalyst
1 PART 1070 Zero VOC Reducer or other quality low VOC urethane reducer



Application Directions

Adjust air pressure to 40-50 psi at gun for gravity or siphon feed guns. HVLP use 6-10 psi at air cap. Apply 2 medium coats or until hiding is achieved. Allow a 15-20 minute flash time between coats and before force drying.



Dry Times at 77° F

Flash Time: 10-15 MINUTES
Tack Free: 30 MINUTES
Dust Free: 1 HOUR
Tape Free: OVERNIGHT



Bake Times at 140° F

Purge Time 15 MINUTES
Bake Time 40 MINUTES



Recoating

1400 Series Acrylic Urethane Single Stage Color may be recoated after 16-24 hours at 77° F. After 16-24 hours it must be lightly sanded/ scuffed before additional color or clearcoat may be applied.



Accelerator & Fisheye Eliminator

Accelerator and/or Fisheye Eliminator is not recommended for use in this product.



Clean-up

Clean spray equipment immediately after use with gun wash, or a high quality lacquer thinner, or compliant solvent depending on area regulations.



Technical Data

Clean spray equipment immediately after use with gun wash, or a high quality lacquer thinner, or compliant solvent depending on area regulations.

Color:	Various
Catalyst:	1020
Low VOC Reducer:	1070
Mixing Ratio:	4:1:1
Weight Solids:	54-66%
Viscosity:	18 - 24 seconds #2 Zahn
Pot Life:	Minimum of 2 hours at 77°F
Film Build per coat:	1.4-2.2 mils per medium wet coat
Coverage:	850 sq.ft. per gallon @ 1 dry mil (average)
Disposal/Safety:	See SDS for this product and components

For industry use only

Read SDS Before Use

1400 Series Factory Color must be blended with other components before the product can be used. Any mixture of the components will have the hazards of all the components. Before opening the packages, read all warning labels and material safety data sheets. Follow all precautions. This material is designed for application by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

NOTE: High Teck products are not recommended for use in temperatures below 65°F. Using High Teck products below these temperatures will effect dry times and product performance characteristics.