

COMPLIANT COATINGS SYSTEM

POLYURETHANE COATING



ENVIRO-FINISH

POLYURETHANE COATING

VOC: 340 g/l – 2.8 lb/gal (Combined Components)



ENVIRO-FINISH Polyurethane Coating is a non-yellowing, high quality polyurethane, manufactured from the finest raw materials available. Enviro-Finish is designed to provide a high gloss, extremely durable, chemical-resistant topcoat. This tough, wet-look finish will far surpass the performance of acrylic enamels and epoxies. Enviro-Finish is lead and chromate-free.

ADVANTAGES:

- ◆ Meets air quality regulations
- ◆ Lead and chromate-free
– *durable polyurethane*
- ◆ High gloss
– *easy to use*
- ◆ Multi-market system
– *2.8 and 3.5 VOC for Group I and Group II vehicles*

Product Numbers: PART A BASE 6400 SERIES & 6340-98 CATALYST





COMPLIANT COATINGS SYSTEM

ENVIRO-FINISH POLYURETHANE COATING

DIRECTIONS FOR USE

ENVIRO-FINISH Part A must be mixed with ENVIRO-FINISH Part B CATALYST before the product can be used. Any mixture of ENVIRO-FINISH Part A and ENVIRO-FINISH Part B CATALYST will have the hazards of both components. Before opening the packages, READ ALL WARNING LABELS. FOLLOW ALL PRECAUTIONS.

SURFACE PREPARATION

Prior to application, the surface must be dry, clean and free from wax, grease, oil, rust, dirt or any other foreign matter. Use 1071 Compliant Surface Cleaner on unpainted surfaces. Sand and featheredge original finish with 220 or 320 wet or dry sandpaper. Use 195 Pro Etch over bare metal for additional corrosion protection. Prepare all bare metal with appropriate PCL Undercoat System. Sand as necessary and follow with 1071 Compliant Surface Cleaner.

MIXING

ENVIRO-FINISH POLYURETHANE COATING Part A Base to be used only with ENVIRO-FINISH 6340-98 Part B Catalyst.

Mix one part of ENVIRO-FINISH POLYURETHANE COATING Part A Base with one part ENVIRO-FINISH 6340-98 Part B Catalyst. Stir thoroughly to a uniform mixture. Strain mixture prior to application. Spray viscosity of mixture is approximately 20–22 seconds, #2 Zahn cup at 77°F. Mix no more material than will be used in a 2-hour period.

THINNING

For 2.8 VOC application, no reduction required.

For 3.5 VOC application, use 15% of one of the following:

- 6007 Fast Urethane Reducer
- 6009 Medium Urethane Reducer
- 6011 Slow Urethane Reducer

or use one of the following Zero VOC Compliant Reducers:

- 2010 Acetone
- 8025 Fast Universal Exempt Reducer
- 8050 Medium Universal Exempt Reducer
- 8075 Slow Universal Exempt Reducer

APPLICATION

Apply 2 medium wet coats. Apply first coat, then allow 10–15 minutes flash-off time, then follow with full second coat.

ACCELERATOR: To accelerate dry time, add 6499 Accelerator to the mixed material. Follow label directions. Pot life will be reduced to 1 hour at 77°F.

FISH EYES: To eliminate “fish eyes,” add 6496 Fish Eye Eliminator to the mixed material. Do not use commercial fish eye eliminator as it may not be compatible with the ENVIRO-FINISH mixture.

APPLICATION (continued)

TAPE: Overnight.

FORCE DRY: Flash-off 20 minutes. Dry Time 20–25 minutes at 140°F.

RECOAT: Within 48 hours @ 70–80°F.

CUT & BUFF: After 24 hours.

CLEANING

Equipment should be cleaned immediately after use with 3520 Universal Compliant Solvent or 7002 Compliant Gun-Cleaning Solvent in an enclosed system.

TECHNICAL DATA

VOC:	340 g/l – 2.8 lb/gl (combined components)
Color:	Assorted
Finish:	High gloss “wet look”
Solvent:	Esters/Ketones/Aromatic Hydrocarbons
Flash Point:	40°F TCC
Dry-to-Touch:	1–2 hours @ 77°F
% Solids by Volume:	59–60
% Solids by Weight:	65–71
Coverage:	950–970 square feet per gallon @ 1.0 mil dry
Pot Life:	Approximately 2 hours @ 77°F
Viscosity:	20–22 seconds #2 Zahn cup
Recoat Time:	48 hours @ 70–80°F
Shelf Life:	1 year from date of manufacture

FILM PROPERTIES

ADHESION:	ASTM D-3359	Cross-hatch – 100% adhesion
FLEXIBILITY AND ELONGATION:	ASTM D-1737	1/2" Mandrel, no cracking
MAR RESISTANCE:	Comparative Test	Excellent
HARDNESS:	ASTM D-3363	H – 2H
ULTRAVIOLET WEATHERING:	ASTM G-53	1,000 hours, no loss of gloss
PRINT AND BLOCK RESISTANCE:	ASTM D-2793	Pass
	ASTM D-3003	Pass
DIRECT IMPACT:	ASTM D-2794	160 in-lbs, no cracking
REVERSE IMPACT:	ASTM D-2794	160 in-lbs, no cracking
MEK 100 RUB-UP:		Pass, no change



NOTE: FOR USE BY PROFESSIONAL, TRAINED PERSONNEL, USING PROPER EQUIPMENT WITH STANDARD SAFETY PROCEDURES. NOT INTENDED FOR SALE TO THE GENERAL PUBLIC. FOR PROFESSIONAL USE ONLY. NOT FOR RESIDENTIAL USE.

SEE LABEL FOR ADDITIONAL SAFETY INFORMATION.

