

SPEEDOKolor™

Technical Data



2.8 VOC

Single Stage Acrylic Urethane Paint

PRODUCT DESCRIPTION

SpeedoKolor Single Stage Acrylic Urethane Paint is a high quality, two-component acrylic urethane formulated to withstand long-term exposure to extreme environmental conditions. Its fast dry time and exceptional gloss level make for the ideal coating for various industries. Use SPK Series **Activators** and **SpeedoKote Zero V.O.C. Reducers**.

- Outstanding color and gloss retention
- Excellent corrosion resistance
- Available in a wide range of colors
- VOC 2.8 lbs./gal.
- Excellent hardness
- Excellent mar and abrasion resistance
- Excellent chemical resistance
- No reportable HAPS

COMPATIBLE SUBSTRATES

SpeedoKote DTM Primers, Epoxy Primers, Urethane Primers, Self-Etch Primer.

SURFACE PREPARATION

The surface must be clean and free of all surface contamination. A chemical pretreatment or pretreatment primer will improve the performance properties of the coating system. See your SpeedoKote Representative for recommendations.

MIXING

4 Parts: SPK Series Single Stage Acrylic Urethane Paint

1 Part: SPK60 Fast Activator
SPK75 Medium Activator
SPK85 Slow Activator
SPK95 X-Slow Activator

5% Optional: Zero VOC Reducer

NOTE: Mix by volume and stir thoroughly. Make sure product is at room temperature (72°F/22°C) before mixing.

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APPLICATION

Apply 2-3 wet coats or until adequate coverage is achieved. Cross coating is recommended to achieve a uniform finish. Allow 10 minutes flash time between coats. See spray equipment setup and recommendations.

- Do not apply at temperatures below 50°F
- Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity, and degree of air movement.
- Excess film thickness will retard dry times and affect the recoat window
- In-Service Temperature: 150°F. (As you approach 150°F depending on the pigmentation, the color may change, but the film integrity will be maintained up to 150°F.)
- Avoid moisture contamination with the Activator – moisture can gel the material and affect the performance properties

GUN SETUP

HVLP gravity 1.2mm -1.4mm 8-10 psi @ gun

CURE TIMES

Air-dry (77°F & 50% Relative Humidity)

To Touch: 30 minutes
To Handle: 4 hrs.
To Recoat: Next Day (Light scukk and clean)

Bake / Force Cure

Purge Time: 10 min. (ambient)
Substrate Temp: 130°F (60°C)
Bake Time: 20 min.

See Safety Data Sheet and labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.
- For additional health and safety information refer to the SDS which can be found at www.speedokote.com

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