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## PRODUCT INFORMATION SHEET

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# 2 PACK COLOUR

### Description

*HiChem 2 Pack Colour* is a 2 pack acrylic urethane enamel which has been specifically formulated for low bake oven curing. It will also air-dry under normal conditions.

### Uses

*HiChem 2 Pack Colour* is suited for the refinishing and repair of, trucks, cars and buses or whenever a high quality, high gloss finish is required. *The HiChem 2 Pack Colour Tinting System* consists of a range of tinters based on automotive grade pigments. Colour formulations are available for most vehicles and the range is updated continually as new colours are introduced.

### Properties

*HiChem 2 Pack Colour* demonstrates the following outstanding characteristics:-

- High initial gloss & gloss retention
- Excellent colour retention
- Excellent hardness & chemical resistance
- Ease of application

### Suitable Substrates

*HiChem 2 Pack Colour* may be applied over the following substrates:-

- *HiChem 2 Pack High Build Primer/Filler 4:1*
- *HiChem 2 Pack HS Ezi-Sand Primer/Filler 4:1*
- *2Pack Red Primer*
- *2Pack Iso-Free Primer-Isolator*
- Degreased and sanded Baked Enamel
- Degreased and sanded 2 Pack Enamel
- *HiChem Flexi Prime Plastic Primer*
- *HiChem 1K Primer*

### Mixing Ratio

Mix 2 parts by volume of *HiChem 2 Pack Colour* with 1 part by volume of *2 Pack Hardener (Fast, Medium or Slow)*. Use the HiChem Measuring Stick (Yellow).

### Thinning

Thin the mixed material with approximately 10-15% by volume of the appropriate *2 Pack Thinner (2PTF-Fast, 2PTN-Normal or 2PTS-Slow)*. For most applications use normal thinner. Application viscosity should be in the range 20-24 seconds Ford No 4 cup at 20°C.

To speed up baking, drying, and cure replace *2 Pack Thinner* with *2K Accelerator* as instructed in the Product Information Sheet for *2K Accelerator*.

To overcome problems in hot conditions (boiling marks, overspray, orange peel, air draught sensitivity) replace the *2 Pack Thinner* with *2 Pack Retarder* as instructed in the Product Information Sheet for *2 Pack Retarder*.

### Application

Apply two to three coats (depending on colour selected) allowing 10-15 minutes flash-off time between coats according to thinning and temperature.

Recommended Dry Film Thickness is 75-100 micron.

For blending in 2 Pack Colours either procedure listed below is an acceptable method.

- Add the same amount of Fade Out Reducer 410 to the mixed colour and hardener (no thinner) be sure to mat the whole blend in area prior to spraying. Then proceed as per application method above
- Blend out with your made up Mixed Colour (Colour + Hardener + 2 Pack Thinner). Within ten minutes apply onto the blend out area a light coat of Fade Out Reducer 410 followed by a second light coat after 10-15 seconds.

**Pot Life**

After mixing and thinning, *HiChem 2 Pack Colour* will have a useable life of approximately 4-6 hours at 25°C, depending on which hardener is used. Higher temperatures will reduce the useable life considerably.

**Coverage**

Approximately 9m<sup>2</sup>/litre when applied in two coats.

**Drying Times****(A) Air Dry:-**

*HiChem 2 Pack Colour* will dry at ambient temperatures of 20-25°C. Under these conditions the paint film will be:-

*	Dust free	30-35 minutes
*	Touch Dry	2-3 hours
*	Hard Dry	24 hours

Full cure will be achieved in approximately 7 days.

**(B) Oven Bake:-**

The temperatures shown below are for metal body temperatures not booth ambient temperatures:-

		<b><u>40°C</u></b>	<b><u>60°C</u></b>
*	Dust free	15 minutes	5 minutes
*	Touch Dry	20 minutes	10 minutes
*	Hard Dry	60 minutes	45 minutes

**Clean up**

Clean all equipment with *Superglow (multi purpose) thinner*.

**Storage**

Store in a cool dry place. Always replace lid securely after use. Stir tinters regularly.

**Compounding/Polishing**

Defective areas may be compounded lightly and polished after 45 minutes low baking at 60°C (allow a 20 minute cool down period) or after 24hrs drying at 20-25°C.

**Health & Safety**

Read safety directions/warnings on cans and refer to the Material Safety Data Sheet before using this product.

**Standard Packaging*****HiChem 2 Pack Colour tinters:-***

1 litre and 4 litre

***HiChem 2 Pack Hardener:-***

	<u>Fast</u>	<u>Medium</u>	<u>Slow</u>
4 Litre	2PHF4	2PHM4	2PHS4
1 Litre	2PHF1	2PHM1	2PHS1
500 mls	2PHF500	2PHM500	2PHS500

***HiChem 2 Pack Thinner***

	<u>2PTF-Fast</u>	<u>2PTN-Normal</u>	<u>2PTS-Slow</u>
20 litre	2PTF20	2PTN20	2PTS20
4 litre	2PTF4	2PTN4	2PTS4
1 litre	2PTF1	2PTN1	2PTS1

***HiChem Fadeout Reducer 410***

4 litre	FOR4
1 litre	FOR1

*The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.*