

Technical Data Sheet Metal 920 Top Coat

1. Product and Storage Information

Product Description: A UV Curable Metal Top Coat. For use as a top coat for metal and synthetic substrates. Upon exposure to UV light, the coating cures tack-free within 4 minutes or less. The cured coating has excellent adhesion and compatible with most primers / sealers. The formulation is 100% solids containing zero solvents or HAPs (100% VOC free). The product exhibits no off-gassing, resulting in low to no shrink (superior wetting). The product does not require a catalyst or reducer and is ready to use as is.

Storage: The product should be stored within the temperature range of 50°F to 90°F and in the original container. Do not return unused material into the original bottle.

2. Application



Use suitable respiratory and PPE equipment

See Section 6 (Liability/Hazard Info) for more details

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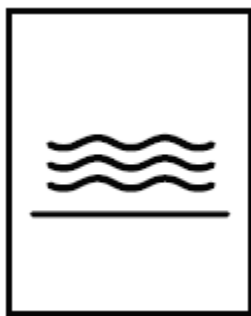


Preparation Process: Use 90-99% isopropyl alcohol (IPA) to prep before application of the coating.

You may use a wax and grease remover or tack cloth, to prepare the surface to be coated, but it must be followed up with a 90-99% isopropyl alcohol (IPA) prep prior to application of the coating.

Application Process: Shake or Stir well before use. Apply in a well-ventilated area, use appropriate PPE and a respirator (full / half mask) for spray coating (refer to SDS). Brush, roll, or spray onto substrate. Product can be applied at temperature ranges of between 60°F and 112°F as well as humidity between 20% and 97%. Product temperature should be at minimum 72°F. Depending on spray equipment, product may need to be reduced no more than 20% to spray viscosity with 90-99% isopropyl alcohol. Substrate temperature should be at minimum 60°F. Any spray equipment may be used. The recommended tip size is 1.0 - 1.6 mm. Follow standard shop practice when spraying. The remaining unused polymer should be stored in an opaque container and may be reused as long as the viscosity has not increased. Unused polymer should not be returned to the original container. The spray equipment can be cleaned with isopropyl alcohol or acetone.

WARNING: material will start curing immediately when applied in direct or indirect sunlight.



Build Coats:

1. Apply 1 to 2 mils per application.

*Note: For vertical applications recommended coverage 1-1.5 mil.

2. Allow flow out to desired profile.

3. Cure for 2-4 min with UVA curing light or direct sunlight.

4. Allow 5 minute post cure before next coat.

5. For additional coats sand with 220 grit, or finer, paper between coats. Use shop air and prep with IPA.

Repeat steps 1-4 for additional coats.

Can be sanded / polished using traditional and modern methods.

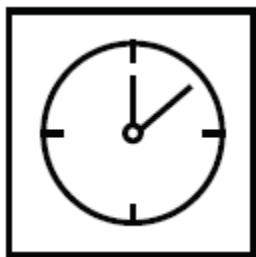
Spray Gun Set-Up / Application Pressure:

RP - Gravity Feed	1.0 - 1.4 mm	29 -35 psi
HVLP - Gravity Feed	1.0 - 1.6 mm	Max 20 psi (cap)

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3. UV Through Cure Verification

Use this procedure to verify your UVA curing light is adequate to thoroughly cure the product. The UVA range to be used is between 365 - 405 nm.



1. Use a test article and apply a 3 mil coat.
2. Cure with UV light 2 minutes.
3. Let rest for 10 minutes.
4. Check for a tack free surface. If it's not tack free then it has insufficiently cured*.
5. Take 220 grit sandpaper and sand completely through looking for dry powder all the way through. If you encounter gummy material or clogged sandpaper then it has insufficiently cured*.

***An insufficient cure indicates that the UVA light is unable to cure the product.
(This could be due to the distance or total output power of the light)**

4. Cleaning Process

Use isopropyl alcohol and/or acetone to clean tools and equipment. Cure excess or unwanted material on surfaces or filters with UV light.

5. Material Details

Solid Content	100%
Volatile Organic Content	0%
Coverage @ 1 mil	1608 sq. ft./gal

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6. Liability/Hazard Info

See SDS for complete information.

Although the product is VOC free it should be used in a well-ventilated area.

If skin contact occurs immediately wash with soap and water.

Harmful if swallowed.

Causes skin and eye irritation and may cause an allergic skin reaction.

WARNING: Exposing open containers or barrels of product to direct or indirect sunlight will result in a runaway exothermic reaction. Product is unstable until properly cured.

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Personal Protective Equipment: Eye/face protection: Face shield and safety glasses Use equipment for eye protection tested and approved under appropriate government standards such as NIOSH (US) or EN 166(EU).

Skin protection: Handle with gloves. Gloves must be inspected prior to use. Use proper glove removal technique (without touching gloves outer surface) to avoid skin contact with this product. Dispose of contaminated gloves after use in accordance with applicable laws and good laboratory practices. Wash and dry hands.

Body Protection: Use full paint suit with hood, The type of protective equipment must be selected according to the concentration and amount of the dangerous substance at the specific workplace.

Respiratory protection: Where risk assessment shows air-purifying respirators are appropriate use a full-face respirator with multi-purpose combination (US) or type ABEK (EN 14387) respirator cartridges as a backup to engineering controls. If the respirator is the sole means of protection, use a full-face supplied air respirator.

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Use respirators and components tested and approved under appropriate government standards such as NIOSH (US) or CEN (EU).

Control of environmental exposure: Do not let product enter drains.