

TECHNICAL DATA SHEET: Urethane Acrylic Single Stage Paint Kit



PRODUCT FEATURES:

Easy to apply ◇ Superior flow-out and leveling ◇ Outstanding durability ◇ Extremely flexible ◇ High gloss & "mirror like" quality ◇ Economical to use ◇ Excellent abrasion & chip resistance ◇ Outstanding chemical resistance

COMPONENTS:

- AU-Acrylic Urethane Color 1 Gallon
- Rayflex Urethane Activator 1 pint
- 5-Star Urethane Reducer 1 quart

RECOMMENDED BARE METAL PRIMERS:

5-Star Direct To Metal Self-Etching Primer Product # 5414

RECOMMENDED PRIMER SURFACER:

Trinity Hot Rod Black Lacquer Primer Surfacer
Five-Star Urethane 2K Primer #5453

Physical Properties:

Mix Ratio	8:2:1
Pot Life	2 ½ - 3 hours
Flash Point	>22°F
Color & Gloss Retention	Excellent
Flexibility	Excellent
Chip Resistance	Excellent
Gloss (Metallic Colors)	85-90%
Gloss (Solid Colors)	90-95%
Gasoline Resistance	Excellent
Repair ability	Excellent

VOC. INFORMATION

Material	V.O.C.: <380g/l (3.15#/gal)
Coating	V.O.C.: <380g/l (3.15#/gal)
RTS coating	V.O.C.: <420g/l (3.5#/gal)

MIXING RATIO

8 parts	Color
2 parts	Urethane Reducer
1 part	Rayflex Urethane Activator

SURFACE PREPARATION:

General Procedure

- Clean vehicle with soap and water to remove any dirt or grime.
- Wipe vehicle with a Wax & Grease Remover, using generous amounts and changing rags frequently.
- Sand area as necessary by hand or machine to remove any rust or corrosion, repair all body damage.
- Prime bare metal with any of the recommended bare metal primers. Use a 2K or Lacquer sandable primer surfacer when needed to fill sand scratches
- Final sand all areas with Machine / D.A. (#320 grit or finer) sandpaper.
- Re-wipe vehicle with a Wax & Grease Remover.

GUN SETUP:

Gravity HVLP 1.3–1.4 mm	7-10 PSI
Siphon HVLP 1.3–1.4 mm	10 PSI
Conventional 1.3–1.4 mm	50-55 PSI

Note: The pressure on a HVLP gun is measured at the cap, on a conventional gun, pressure is measure at the gun.

APPLICATION INSTRUCTIONS:

- Adjust air pressure to 50-55 psi at the gun if using a conventional gun or 10 PSI at the cap for HVLP's
- Apply 2-3 medium wet coats of Rayflex urethane color, as needed, allowing 20 minutes flash time between coats.
- On metallic colors a cross coat might be necessary to even out the metallic's and to avoid mottling.

DRY TIMES:**By Air @ 77°F**

Flash	15 - 20 minutes
Tack Free	2 hours
To Deliver	8 - 10 hours

CLEANING:

Clean equipment with a quality lacquer thinner or a quality urethane reducer. Do not leave catalyzed product in the gun more than 8 hours @ 55-70°F or more than 4 hours @ >70°F.

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 75°F. Temperatures below 60°F will severely retard dry times and thorough cure.

PRODUCT SAFETY INFORMATION:

Before using any Rayflex product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive- pressure, supplied air

respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. Only professional, trained painters intend this product for industrial use. For more information CONSULT MATERIAL SAFETY DATA SHEET.

Limited Warranty

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