

TECHNICAL DATA

HI-GLOSS ACRYLIC LINEAR POLYURETHANE TOPCOAT- BUFFABLE- FLAME RETARDANT **EXTREME PERFORMANCE XP-N-C91**

September 2011

PRODUCT DESCRIPTION:

This two component clear coating covers hi-gloss acrylic fortified polyurethane topcoats and some wood substrates. It is designed for exotic woods requiring maximum gloss and UV protection. When fully cured, this coating exhibits excellent flame resistance and exceptional resistance to staining, fluids and marring. The **XP-N-C91** offers the hardness, flexibility and D.O.I. (distinctness of image) of linear polyurethane with the reparability of acrylic topcoats.

SURFACE PREPARATIONS:

Surfaces to be painted should be sanded, using #180-220 sandpaper, and solvent wiped with SR-40 to remove any residue from the surface. For wood finishing, insulate using ISB-910/ ISC-909 Insulator. Primer prepare surfaces with PST-917 or one of Axon's PSP-Series Sealers. Sand with a minimum 320 grit sandpaper and clean thoroughly with SR-40 wipe solvent.

MIXING INSTRUCTIONS:

Shake or stir base component well. Then:

1. Pour the base component of the paint into a container that is large enough to accommodate the base plus the hardener and reducer. Slowly pour the hardener, XPH-14 hardener, into the base, slowly stirring the mixture until you have reached a 1:1 mix ratio.
2. If reduction is necessary or desired refer to the chart below.
3. Let the mixture stand for about 15 minutes before application.

REDUCTION-VISCOSITY

Temperature	Reduction Percentage	Reducer to be used
Below 65°F	Up to 25%	SR-12
65-85°F	Up to 25%	SR-45
Above 85°F	Up to 25%	SR-48

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SPRAY APPLICATION:

Most spray equipment can be used, but an understanding between fluid flow and air pressure at the air cap is necessary to reduce texture and obtain the best appearance of the paint. We have tested the DeVilbiss equipment and recommend the following models. (all the guns are pressure fed)

- Conventional-DeVilbiss JGA 510 with 1.0 fluid tip and 777 and 797 air caps 40 to 60psi at the gun.
- HVLP-DeVilbiss Gti with 1.0 fluid tip and 2000 air cap 30psi at the gun.
- High transfer-DeVilbiss Plus with 1.0 fluid tip and 414 air cap 40psi at the gun.

Turn the pressure in the feed tank to between 7 to 10 psi and turn the fluid control on the gun all the way in. Then adjust the fluid control out one turn and turn up the air pressure to the recommended PSI. Test the fluid pattern and flow rate on a piece of masking paper. Due to the high solids nature of the paint system, coverage is much greater than other lower solids paint systems. Apply it in wet uniform coats. It is important to allow the energy at the air cap to break up the paint for it to flow out with little or no texture.

For high build directly over wood, PST-917 or PSP-Series sealer can be applied in multiple coats. Coats should be sprayed 3-4 wet mils with 20-60 minutes dry time between coats (depending on temperature). Wait for first coat to "tack" before applying subsequent coats. No more than 6 coats in one day should be applied. If more coats are required allow to dry overnight. Before applying more coats, sand with 320 grit sandpaper once overnight dry time is complete.

BUFFING and REPAIR:

Depending on the temperature, wait at least 24 hours before attempting a repair. A suggested buffing process is to determine the size of the application error and start the repair with as low as 400 grit sandpapers. Next use a series of grits, stepping up from 800 through 1500, removing the sand scratches from the previous grit. After 1500 grit, use 3m Trizact™ 300 grit and water to remove the 1500 scratches. Buff the repair with 3m Perfect-It™ 3000 extra cut to remove scratches and finish the repair with 3m Perfect-It 3000 Final Glaze.

PHYSICAL PROPERTIES:

Appearance:	Gloss, Clear
Gloss:	>90 plus @ 60° photo gloss meter
Coverage:	600 – 800 sq. ft./mil/gallon@ 100% transfer depending on color
Admixed Viscosity:	17 – 18 seconds, #2 Zahn cup.
Pot Life:	*4 hours @ 75° F
Tack Free:	*1 – 2 hours @ 90°F
Hardness	5H minimum ASTM D-3363
Mix Ratio	1 to 1 with XPH-14 hardener

PRECAUTIONS:

Use with adequate ventilation and proper respiratory protection. See MSDS for complete details of composition and precautions.