



Specialist suppliers to the Automotive Refinishing and Industrial markets

Guidance for using 2K Acrylic Car Paint



2K Acrylic Car Paint

2K Acrylic Direct Gloss (also known as 2 pack) is a two component paint system. You have the Acrylic solid enamel colour that requires an activator/ hardener to cure the paint. Usually a small amount of 2K thinners might be required to adjust the viscosity for spraying. This paint system should only be applied by spraying and quantities mixed should be measured. **Important** the spray gun and pot needs to be cleaned out immediately after spraying as the paint will cure in the pot i.e. harden. The activator/ hardener used with this paint contains poly isocyanate. The paint finish provides a hard and durable coating suitable for cars and commercial vehicles.

Health and Safety.

This paint system is for professional use only. Requiring a spray booth, normally heated with adequate ventilation and air flow or low bake oven. Important the paint sprayer is required to wear an air feed respirator or similar compliant protection. The spray particles containing the hardener can effect the respiratory system. Before using this material it is advised that the Manufacturer's data, technical, health and safety sheets are read and instructions followed. Product can be cured air dried, infra red or low baked.

Preparation

Before applying 2K solid colour to a painted panel make sure the panel has been thoroughly cleaned with a degreaser, and the surface has been sanded to provide a good key. Normally P600 grit should be sufficient to provide a good key. Mix only sufficient paint for the area to be painted, normally 2 parts colour + 1 part 2K hardener + 10% 2K thinners. Two to three coats are normally required, note 2K coverage is usually excellent.

Damaged areas on the vehicle panels.

Remove the existing paint by grinding the area with a fibre disc P36 grit. Treat any rust areas with a quality rust remover. Apply a body filler by mixing the hardener and paste in accordance with the manufacturers instructions. Apply the filler, allow to harden and then sand to required shape to the vehicles contours. Sanding the filler is best done using P80/ P120 grits, coarse grades are available but if used further filling might be required. If there are small imperfections fill in with a knifing stopper and sanded with P180 grit.

Any bare metal areas should have a self-etching primer applied. Mixing ratios are normally 1 part primer + 1 part solution (follow manufacturers instructions)

Once the repairs have been completed apply a 2K primer, over the filled areas, commonly known as spot priming. If the substrate of the whole vehicle panel is poor you might decide to the primer the whole panel. In this situation make sure that the area to be painted has been cleaned and sanded prior to the primer being applied. In this case apply a wax and degreasing solution over the panel having sanded with P600 grit.

Apply the 2K primer :

Mixing ratio depends on each manufacturer. 4 parts primer (or 5 parts primer) + 1 part hardener plus 10-20% 2K thinners. Apply 2- 4 coats allowing a flash time between coats of 5 to 10 mins. Thinning ratio's can change depending on the spray gun set up. Once the primer has dried wet sand with Grit P600 prior to applying the 2K colour coat. It can help prior to sanding the Primer to apply a guide coat. This is light misty spray of black so that it is easier to see the sanding process. After sanding blow off any dust and use a tack cloth to remove any small residue or dust particles.

Applying 2K Solid Colour

Check colour is correct having stirred the paint thoroughly. Mix sufficient paint to do the job in hand, as it will harden. Mix 2 parts colour + 1 part 2K hardener + >10% 2K thinners. Two to three coats are normally required, note 2K coverage is usually excellent.

Spray gun set up will depend on your equipment. Normally a high pressure spray gun is used at around 45-50psi.

In the right conditions the paint should be fully cured in about 20 hours when air dried, (leave overnight). Low bake ovens cure the paint in about 30mins. Infra red panels can be used to speed drying times on part panel repairs 15-20mins.

Once fully cured it is possible to remove any imperfections or small runs. Rectification work: use P1500-P2000 waterproof paper and polish area with compliant polish suitable for 2K Paint.

Things to do:

Use a water trap between air compressor and spray gun.

Keep the workshop area warm.

Keep surface clean.

If possible to avoid static try and earth the metal panels.

If dry sanding use P400 Grit, wet sanding use P600 Grit.

Things to avoid:

Make sure your air lines are clear of water. Use a water trap, between the compressor and spray gun. Ignoring the above can result in something called micro-blistering.

Cold and draughty workshop can result in extending curing times.

Mixed paint pot life approx 3 hours.

Check out our range of [2K Acrylic Paints](#) available from our website.

Disclaimer

This information is given as a general guidance without any warranty and it is advised that reading the manufacturers data and technical sheets is always advised.

Colourtone Ltd

Colourtone House
Horton Street
Higher Hillgate
Stockport
Cheshire
SK1 3LR

Tel:- 0161-477-6970

Branches:
STOCKPORT (H.O.)
Manchester
Southport
Wirral

Website: www.colourtone.com