

Date: 5th August, 2021

Technical Data Sheet

Version: 02

Product Name	
Full Product Name	Unicote 324 2K PU Economy Base
Type of Product	2K fast drying acrylic urethane topcoat
Description	Concept Unicote 324 2K PU Economy Base is a 2K acrylic urethane topcoat, characterised by its durability, excellent flow and gloss. It is suitable for most industrial and commercial applications. This product is designed for cost saving applications.

Tinters						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
341 White	70.0	84.7	1.909	15.93	291.2	2.43
342 Yellow Ochre	63.5	79.0	1.689	14.10	354.6	2.96
343 Black	60.2	64.5	1.083	9.04	384.1	3.21
344 Bright Blue	52.6	53.8	1.163	9.71	537.5	4.49
345 Green Blue	56.7	61.4	1.088	9.08	419.8	3.50
346 Violet	53.9	54.4	1.122	9.36	512.0	4.27
347 Bright Red	58.1	64.4	1.141	9.52	406.8	3.40
348 Magenta	58.6	62.6	1.072	8.94	401.4	3.35
349 Bright Yellow	56.2	62.2	1.125	9.39	425.4	3.55
350 Mid Yellow	44.2	50.1	1.085	9.06	541.8	4.52
351 Scarlet	59.8	68.5	1.240	10.35	390.3	3.26
352 Green	55.6	59.5	1.234	10.30	500.3	4.18
353 Dark Red Oxide	61.6	76.9	1.612	13.46	372.6	3.11
354 Jet Black	53.1	56.7	1.053	8.78	455.5	3.80
355 Red	63.1	66.1	1.187	9.91	402.4	3.36
371 Reduced Yellow Ochre	62.5	68.7	1.161	9.69	363.9	3.04
372 Reduced Black	61.8	65.0	1.059	8.84	370.3	3.09
373 Reduced Green Blue	60.6	64.3	1.060	8.85	378.9	3.16
374 Reduced Scarlet	61.8	66.0	1.093	9.12	371.2	3.10
375 Reduced Green	60.8	63.8	1.092	9.11	395.5	3.30
381 Silver	41.4	54.4	1.171	9.78	533.7	4.45
382 Coarse Silver	42.5	51.4	1.116	9.31	541.4	4.52
399 Flattening Base	35.9	43.2	1.094	9.13	621.5	5.19

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Products

Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
324 2K PU Economy Base	34.3	40.2	0.967	8.07	590	4.9
324 Hardener (8:1)	65.9	70.0	1.64	8.23	301.1	2.52
831 2K Thinner Slow	0.0	0.0	0.893	7.45	892.7	7.45
831 2K Thinner	0.0	0.0	0.882	7.36	881.9	7.36
831 2K Thinner Fast	0.0	0.0	0.872	7.27	871.5	7.27


Properties

- Superior performance
- High gloss
- Quick and easy application




Substrates

- Mild Steel
- Aluminium
- Galvanised Iron
- Glass Reinforced Plastics (GRP)
- Previously painted substrates in sound condition

Substrate Preparation

 Mild Steel	DTM: Sand with 240 Frecut Primer: <u>Optimal:</u> Concept HS 2K Primer or Concept 136 Epoxy Urethane Primer or Concept 141 Epoxy Primer Standard: Apply Concept 103 Etch Primer or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
Aluminium	<u>Optimal:</u> Apply Concept 141 Epoxy Primer or Concept 132 2K Etch Primer with Concept HS 2K Primer Standard: Apply Concept 103 Etch Primer or Concept 110 Metal Etch or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
Galvanised Iron	<u>Optimal:</u> Apply Concept 141 Epoxy Primer, or Concept 132 2K Etch Primer with Concept HS 2K Primer Standard: Apply Concept 103 Etch Primer or Concept 110 Metal Etch or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
Glass Reinforced Plastics (GRP)	<u>Optimal:</u> Apply Concept 141 Epoxy Primer or Concept HS 2K Primer Standard: Apply Concept 103 Etch Primer or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
Previously painted Surfaces (in soundcondition)	Sand with P600 wet or dry
Special Notes: <ul style="list-style-type: none"> • All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. • Use white or light coloured primers under bright yellows, oranges and reds, if required. • The above systems are examples only. For further information, please contact Concept Paints Technical Representative. 	

Product Preparation












	<ul style="list-style-type: none"> • Weigh the concentrates into the required base in accordance with the relevant colour formula. • A maximum of only 10% reduced concentrates is allowed and a maximum of 35% for all concentrates, in total. • Stir or shake for a minimum of 10 minutes • Never leave the mixture stand for more than 30 minutes before mixing. 		
 Mixing Ratio 8:1 (by volume)		Unicote 324 2K PU Economy Base 8 parts	Unicote 324 Hardener (8:1) 1 part
 Reducer	Up to 20% (v/v) Concept 831 2K Thinner, if required		

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Product Preparation cont

 Matting (if required)	Satin Finish: Add 30% of 399 Flattening Base. Matt Finish: Add 45% of 399 Flattening Base. Notes: • Never add more than 50% of 399 Flattening Base. • 399 Flattening Base must be added before adding a hardener or thinner. • The addition of 399 Flattening Base will reduce coverage.				
 Pot life @ 25°C (77°F)	2-3 hours				
 Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	17-19 s 15-17 s			
   HVLP 	Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
	Gravity Feed	1.2-1.4 mm 0.047-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	Suction feed	1.5-2.0 mm 0.059-0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	HVLP	1.2-1.3 mm 0.047-0.051"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch	
	Airless, Air Assisted, Electrostatic	Consult the manufacturer's instructions.			
 Number of coats	2-3	Apply one light coat followed by one or two even full coats. Avoid heavy wet coats.			
 DFT Recommended	50 µm 2.0 mils				
 Flash off time @ 25°C (77°F)	5-10 min between coats (15-20 min for Unicote 324 2K PU Economy Base)				
 Drying	Air Dry @ 25°C (77°F)	Tack Free: 3-4 hours for Unicote 324 2K PU Economy Base (Recoat-able with itself after any time)			




This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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Remarks

	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Before application a colour comparison is recommended
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Equipment Cleaning

Use Concept Paints cleaner such as Concept 035 Gunwash or 808 Multi-Thinner

Dry Film Properties

After 7 days drying,
when compared to similar technology products.

Gloss 60/20°	94/87
Water resistance	Excellent
Petrol resistance	Excellent
Durability	Excellent

Product Data

Theoretical Coverage	Approx. 8.0 m ² /L (325 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature, away from sunlight.

Product Packaging

Product Code	Product Name	Package Size
INXXXXXXXXXXXX	Unicote 300 Tinters	1L, 4L
INXXXXXXXXXXXX	Unicote 300 Metallic Tinters	1L, 4L
INXXXXXXXXXXXX	Unicote 300 Reduced Tinters	1L
IN39990030004	399 Flattening Base	1L, 4L
IN32490000020	324 2K PU Economy Base	20L
IN3249200000X	324 Hardener (8:1)	500mL, 1L, 2.5L
IN83191000020	831 2K Thinner Slow	20L
IN83192000020	831 2K Thinner Normal	20L
IN83193000020	831 2K Thinner Fast	20L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

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