

NUMIX 2K TOP COAT

PRODUCT DESCRIPTION

Numix Top Coat 2K is two components system Based on hydroxyl functional acrylic resin, Includes 35 basic colors and used as a Finishing coat in car refinish system. An ideal Top coat finish with optimal flow and superior Quality behavior.

FEATURES

01. Excellent gloss and less polishing required.
02. Easy to apply with no sagging effect.
03. Good hiding and low consumption.
04. Long time durability.
05. Outstanding DOI and appearance.
06. Better holdout and hardness.







SUITABLE SUBSTRATES:

Numix 2K top coat is suitable to apply over 1K Numix Primer, 2K Numix Primer, old or original paint work, all existing OEM finishes. All cleaned and sanded sound old finishes.

SURFACE PREPARATION:

Clean surface with water and soap rinse and dry. Numix cleaner wipe dry with a clean cloth. Repair according to damage. Dry mechanical P320 - P400 (finally with P500 will give best results) wet P800 - P1000 Remove all traces of sanding dust, blowing oil-free compressed air. Numix cleaner wipe dry with a degreasing cloth. Respect 100 grit maximum jumps in dry sanding steps and 200 grit maximum jumps in wet sanding steps. Use guide coat to control sanding.

Technical Tips:

	It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.
	Use Numix Cleaner to remove grease, oil and other contaminants. Use clean quality tack rags or wiping towels, one for wetting and one for drying
	Stirred the colors properly before use.
	Product Mixing: The choice of Hardener and Thinner should be made according to application temperature and size of repair. For Mixing use Numix scale.
	Always Use filter paper to avoid the risk of dust particles.
	Clean the gun properly after usage.









TECHNICAL DATA SHEET

(Professional Use Only)

TECHNICAL DATA

Color	As per, RAL, BS, NCS shade card, (Special color can be prepared on request)
Finish	Glossy (96 – 98 @ 60°).
Viscosity (25°C)	Approx. 8.75 Poise
Specific Gravity	Variable and dependable on the color
Solid by Weight %	Dependable on the color
Theoretical Spreading Rate	6 - 8 M2/Lit
Drying time	Dependable on the hardener
Flash Point	Approx 22°C
Volatile organic compounds (VOC)	414 g/L

PRODUCT PREPARATION:

	Mixing ratio	Numix 2K Top Coat Numix 2K Hardener Numix 2K Thinner	Mix By Volume				
			2 1 20-30%				
	Pot life at 25°C	5Hrs					
	Spray viscosity at 25°C	DIN 4 FORD 4 AFNOR 4	26-30s 26-30s 28-32s				
	Spray equipment	Type of Gun	Nozzle Size	Distance	Pressure		
		Gravity Feed	1.4-1.5	15-20	3-4 bar		
		Suction feed	1.4-1.5	15-20	3-4 bar		
		HVLP	1.3-1.4	15-20	2 bar		
	Number of coats	2-3 Coats					
	Flash time	5-10 min between coats or wet-in-wet 15min before bake.					
	DFT	30-35 microns ≈ 1.4 mils. Depends No. of coats					
	Drying time 25°C	2K Hardeners	L10	L20	S2030	M30	Fully cured
		Surface Dry	10 min.	15 min.	45 min.	01 hrs	7 Days
		Tack Free	20 min.	01 hrs.	2 ½ hrs	03 hrs.	
Hard Dry	03 hrs.	06 hrs.	11 hrs.	12 hrs.			
	IR Drying	Distance	Half Power	Full Power	*Guideline form short / Medium wave IR equipment		
		80 cm.	5 min.	15-20 min.			

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ADDITIONAL DATA:

Polishing: Dust and minor imperfections can be polished out after the indicated air-dry times, or after 2 hours cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations. Carefully de-nib using P1500 or finer with soap and water; blow air & dry the sanded area .Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed 1500 rpm) Compound using Fast cut compounding paste with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm. Polish using standard fine polishing paste with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss). Remove any remaining residue using Detailing Cloth.

Notes: *Recommended for better results (especially if the polishing process is being carried out after 48 hours). Polishing preferably needs to be carried out within 48 hours as longer waiting time will results in increased hardness of the paint film thereby making polishing harder as well. Polishing can be done mechanically (preferable) or manually. 2K to coat is a hard & scratch resistant 2K top coat and so to get excellent results especially for gloss restoration, polishing needs to be done as per the recommended procedure especially if it done after longer curing time after application of the 2K top coat.

MISCELLANEOUS DATA

STORAGE:

The product must be stored according to National Regulations. The product should be kept in cool and well ventilated place, protected from heat and direct sunlight at temp 5-35°C. Containers must be kept tightly closed.

SAFETY / HEALTH

Ensure good ventilation during application and drying. Avoid contact with skin and eyes. While painting it is advisable to wear eye protector. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. To remove splashes from skin; use soap and water or a recognized skin cleaner. Keep out of reach of children.

NOTE: We warranty the quality of our product and this data sheet represents test results and practical experience obtained under controlled conditions. We reserve the right to change data without prior notice.