PPG TrueFinish®
Industrial Coatings

SPECTRACRON® 310 2K INTERIOR POLYURETHANE ENAMEL

DESCRIPTION:

SPECTRACRON 310 2K Interior Polyurethane Enamel is a 2-component polyurethane designed for excellent abrasion and chemical resistance. Used as a smooth or textured finish, Spectracron 310 is suitable for application to computer cabinetry and business machines or other interior surfaces requiring superior hardness and flexibility.

HIGHLIGHTS:

- Available in wide range of colors and gloss
- Excellent chemical resistance
- Excellent mar and abrasion resistance
- Superior hardness and flexibility
- Contains no heavy metals

TECHNICAL PROPERTIES*:

PROPERTY	METHOD	RESULT
Color		Full Range
Gloss @ 60° Angle	ASTM D523	25 - 80
Pencil Hardness	ASTM D3363	H – 2H
Conical Mandrel	ASTM D522	Pass, 1/8”
Adhesion	ASTM 3359	5B Excellent
Impact Resistance	ASTM D2794	Direct 100 in lb Reverse 80 in lb
Humidity Resistance 200 Hrs	ASTM D2247	Pass
Salt Spray Resistance 200 Hrs	ASTM B117	Pass, <1/8” creep
Chemical Resistance		Excellent
Substrates		CRS, HRS, Alum, Galv, Plastic**
Primer		SPECTRACRON 521,531,571,W43181A

*Results obtained over iron phosphated CRS panel
** Plastic substrate must be properly cleaned & tested for adhesion prior to application

PHYSICAL PROPERTIES: (Blended)

PROPERTY	VALUE
Weight per gallon	10.5 ± 0.7 lbs / gallon
Solid % (Weight)	56.0 ± 5.0%
Solid % (Volume)	41.0 +/- 4.0%
Flash Point	
SPECTRACRON 310	63° F (17°C)
SPECTRACRON 3606	124° F (40°C)
VOC	4.4 - 4.8 lbs / gallon (before reduction)
Coverage	593 - 722 sq ft/gal @ 1 mil (no loss)
Shelf Life	12 months each component

Do not attempt to use this product without the current Material Safety Data Sheet.
3/2007

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SURFACE PREPARATION:

The surface must be clean and free of all contamination. Chemical treatment of the substrate and/or use of a primer will improve the performance properties of the coating system.

APPLICATION DATA:

Mixing Instructions:	Mix 6 parts of SPECTRACRON 310 Component A to 1 part SPECTRACRON 3606 Component B by volume. Mix thoroughly
Recommended Reducers:	TFS310-30 - SPECTRATHIN Reducer (Fast) TFS310-50 - SPECTRATHIN Reducer (Moderate)
Thinning:	Smooth Coat: Thin as needed 25-50% with SPECTRATHIN Reducer; Texture Coat: Reduce 0*****-25%
Base Coat:	Apply the SPECTRACRON 310 @ 4-4.5 mils wet; 1-1.5 mil DFT Let flash a minimum of 10-15 minutes before applying texture coat
Texture Coat:	Lower atomization pressures and higher viscosity will produce larger texture - Higher pressures and lower viscosity will yield small textures. Spray on a test piece before application.
Clean up:	Spectrathin Reducers, Q60 MEK, Q30 Acetone or Q120 Polypurge
Pot Life:	8 hours @ 77°F

*****Zero reduction will yield heavy texture and any reduction will yield smaller texture

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI) SMOOTH COAT	PRESSURE (PSI) TEXTURE COAT	FLUID NOZZLE	AIR NOZZLE
Conventional	DeVilbiss - MBC-510	8-10	45-55	10-20	FF	797
Conventional	Binks - 2001,95	8-10	45-55	10-20	63C	63PE
HVLP	DeVilbiss - JGHV	8-10	55-60*****	10-25	FF	#46 MP
HVLP	Binks - Mach 1*	8-10	55-60*****	10-25	94	94P

*****10-12 PSI @ Cap

CURE SCHEDULE: (Air-dry @ 77^0 F)

Dry to texture:	10 – 15 minutes
Dry to touch:	20 minutes
Dry to handle:	60 minutes
To recoat:	It is recommended to scuff sand after 48 hours before recoating
Force Dry:	30 minutes @ 140^0F - 180^0 F

ADDITIONAL INFORMATION:

- For application below 50°F, please contact your technical sales/service representative
- Excess film thickness will retard dry times
- In-Service Temperature: 180°F (maximum)
- Avoid moisture contamination of the Spectracron 3606 Component B – moisture can gel the material and affect the performance properties

CONTACT 1-866-PPG TRUE

It is recommended that the customer should trial the product for adhesion and compatibility using all substrates, surface preparation techniques and application processes in the environment the product will be intended to be used in prior to actual product application.

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