



## SPECTRACRON® 350 SERIES 2K HS URETHANE

**DESCRIPTION:**

**SPECTRACRON 350 SERIES 2K HS Urethane** is a 2-component high solids urethane with excellent exterior durability, mar and chemical resistance. It is recommended for industrial use on pretreated or primed metal surfaces. Suitable applications include metal fabrication, castings, machinery, and agriculture and construction equipment.

**HIGHLIGHTS:**

- ❖ Excellent color and gloss retention
- ❖ Excellent mar resistance
- ❖ Excellent chemical resistance
- ❖ Contains no heavy metals
- ❖ Low VOC

**TECHNICAL PROPERTIES\*:**

PROPERTY	METHOD	RESULT
Color		Wide Variety
Gloss @ 60° Angle	ASTM D523	80 - 90
Pencil Hardness	ASTM D3363	HB - H
Conical Mandrel	ASTM D522	Excellent
Adhesion	ASTM D3359	Excellent
Humidity Resistance 100Hrs	ASTM D2247	Excellent
Salt Spray Resistance 250 Hrs	ASTM B117	Excellent
Chemical Resistance		Excellent
Abrasion Resistance		Very Good
Substrates		CRS, HRS, Alum, Galv
Recommended Primers		SPECTRACRON 101, 501, 531, 521, 571, W43181 Series

\*Results obtained over iron phosphated CRS panel

**PHYSICAL PROPERTIES:**

PROPERTY	VALUE
Weight per gallon	9.5 ± 0.8 lbs / gallon
Solid % (Weight)	70.0 ± 4%
Solid % (Volume)	57.5 ± 3%
Flash Point	
SPECTRACRON 350	88°F (31°C)
SPECTRACRON 3501	355°F (179°C)
VOC	3.5 lbs / gallon maximum
Coverage	874-970 sq ft @ 1 mil (no loss)
Shelf Life	12 months each component

**SURFACE PREPARATION:**

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



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## APPLICATION DATA:

Mixing Instructions: Mix 5 parts SPECTRACRON 350 Component A to 1 part SPECTRACRON 3501 component B by volume (or 4:1 with GXH1080). Mix thoroughly. 97-722 or UA-11 accelerator can be added to Component A, add 4 oz. per / mixed gallon to the SPECTRACRON 350 before adding SPECTRACRON 3501. Do not exceed 4 oz. of accelerator.

Wet Film Thickness: 3.5 – 5.0 mils  
 Dry Film Thickness: 2.0 – 3.0 mils  
 Thinner: Fast: TFS309-30; Medium: TFS309-60; Slow: TFS309-80; Very Slow: TFS309-90  
 Clean up: MEK  
 Pot Life: 2.0 – 3.0 hours @ 77°F  
 1.5 – 2.0 hours @ 77°F with 97-722 or UA-11

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 *	NA	50	NA	66 SD
Conventional	Graco Delta Air *	¼" Fluid	50	5-10	.042
Air Assisted Airless	Graco Alpha A.A.*	NA	1000-1500	20-30	.011 to .015
HVLP	Binks 2001 HVLP *	NA	50	NA	NA

\*Or Equivalent

## CURE SCHEDULE:

<b>Air-dry @ 77°F.</b>	<u>Unaccelerated</u>	<u>Accelerated</u>
Dry to touch	6 hours	1-2 hours
Dry to handle	12 hours	4 hours
To recoat	6 hours	1-2 hours

### **Force Dry – Unaccelerated:**

Flash 10 min @ ambient: 20 minutes @ 180°F  
 Flash 10 min @ ambient: 10 minutes @ 200°F

### **Force Dry – Accelerated:**

Flash 10 min @ ambient: 20 minutes @ 150°F

## ADDITIONAL INFORMATION:

- ❖ For application below 50°F, please contact your technical sales/service representative
- ❖ Excess film thickness will retard dry times and affect the recoat window.
- ❖ After 24 hours, mechanically abrade surface before recoating
- ❖ 200° F Maximum In-Service temperature. 160° F Maximum In-Service temperature with accelerator; elevated temperatures will reduce impact resistance.
- ❖ Avoid moisture contamination of the SPECTRACRON 3501 Component B. Moisture can gel the material and effect performance properties.
- ❖ If using accelerators, avoid quantities in excess of 3 oz. per gallon. Chemical resistance, pot-life and physical properties of the urethane coating can be affected.

**SPECTRACRON® is a registered trademark of PPG Industries, Inc.**  
**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.

The technical data presented in this bulletin is based upon information believed by PPG to be currently accurate. However, no guarantees of accuracy, comprehensiveness or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in this bulletin.

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