



SPECTRACRON® 320 2K HS INTERIOR POLYURETHANE ENAMEL

DESCRIPTION:

Spectracron 320 2K HS Interior Polyurethane Enamel is a high solids, low VOC 2-component polyurethane coating. It is designed to be sprayed as a low-gloss (satin) smooth coat or can be textured to provide a unique custom finish to hide surface imperfections like grinding marks and weld seams. Spectracron 320 is intended for applications such as analytical testing equipment, dental equipment, computer cabinetry, business machines and electronic enclosures.

HIGHLIGHTS:

- ❖ Available in wide range of custom colors
- ❖ Excellent chemical resistance, hardness and flexibility
- ❖ Outstanding mar and abrasion resistance
- ❖ Contains no heavy metals
- ❖ Low VOC at ≤ 2.8 lbs. / gal. with no reportable HAPs

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Colors		Custom Colors Black (Q320BK370)
Gloss Range @ 60° Angle	ASTM D523	15 – 40
Pencil Hardness	ASTM D3363	F – H
Conical Mandrel (1/8")	ASTM D522	Pass, no cracking
Adhesion	ASTM 3359	5B, Excellent
Impact Resistance	ASTM D2794	Direct – 80 in. lbs.
Humidity Resistance (DTM, no primer)	ASTM D2247	>750 hrs., no effect
Salt Spray Resistance (DTM, no primer)	ASTM B117	168 hrs., no face blisters, 2mm creepage
Solvent Resistance	Spot Testing	Excellent**
Household Chemicals Resistance	Spot Testing	Excellent**
Resistance to Acids & Bases	Spot Testing	Excellent**
Substrates		Pretreated CRS, Aluminum and some plastics***
Recommended Primer(s)		SPECTRACRON 315 & W43181A

*These results were obtained over iron phosphated CRS panels.

**The specific solvents and chemical reagents used in these tests and their result are available upon request.

*** Plastic substrates should be properly cleaned & tested for adhesion prior to application.

PHYSICAL PROPERTIES:

PROPERTY	BLENDED VALUE
Weight per gallon	10.15 ± 0.65 lbs. / gal.
Weight Solids (%)	60.00 ± 4.00%
Volume Solids (%)	46.5 ± 1.5%
Flash Points:	
SPECTRACRON 320	17°F (-8°C)
SPECTRACRON 3606	124°F (51°C)
TFS321-50	4°F (-16°C)
VOC (blended, less exempts)	2.8 lbs. / gal.
HAPS (per gallon)	None
Coverage (@ 1 mil, no loss)	721 – 770 sq. ft. / gal.
Shelf Life - unopened container	2 yrs.

SPECTRACRON[®] 320 2K HS INTERIOR POLYURETHANE ENAMEL

SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos[®] KA Cleaner/Coater or a similar conversion coating and/or primer will improve the performance properties of the coating system. See your PPG Representative for recommendations.

APPLICATION DATA:

Mixing Instructions: 4 parts SPECTRACRON 320 (Component A)
 (by volume) 1 part SPECTRACRON 3606 (Q3606; Component B)
 Mix thoroughly

Reducer: 0.5 parts TFS321-50 (SPECTRATHIN[®] Exempt Reducer); for compliance

Viscosity (@ 77°F): 10 – 17 sec. blended (Zahn #3 EZ Cup)

Smooth/Base Coat Wet Film Thickness: 3.0 – 5.0 mils
 Thicknesses: Dry Film Thickness: 1.5 – 2.5 mils

Texture Coat*: Reduce as desired, 0 – 10%

Clean up: TFS321-50, Q60 (MEK), Q30 (Acetone) or Q120 (Polypurge)

Pot Life (@77°F): 3 – 4 hrs.

*Zero reduction yields a heavy texture; any additional reduction will generate smaller texture. Additionally, lower atomization pressure and higher viscosities will produce larger textures; while higher pressures and lower viscosity will yield smaller texture. Always trial on a test piece prior to final application.

SPRAY APPLICATION	SPRAY EQUIPMENT	FLUID PRESSURE (psi)	PRESSURE (psi) SMOOTH COAT	PRESSURE (psi) TEXTURE COAT	FLUID NOZZLE	AIR NOZZLE
Conventional	DeVilbiss MBC-510	8 - 10	45 - 55	5 - 20	FF (1.4 mm)	797
Conventional	Binks 2001 or 95	8 - 10	45 - 55	5 - 20	65SS (1.5 mm)	63 PR
HVLP*	DeVilbiss JGHV-531	8 - 10	50 inlet	5 - 20	FF (1.4 mm)	46 MP
HVLP*	Binks - Mach 1 HVLP	8 - 10	50 inlet	5 - 20	95 (1.5 mm)	95 AP

*HVLP atomization pressure should read <10 psi @ the cap

CURE SCHEDULES:

Air-dry (@ 77°F & 50% Relative Humidity)

To Texture: 10 – 15 min.
 Dust/tack Free: 15 – 20 min.
 To Touch: 30 – 60 min.
 To Handle: 1 – 2 hrs.
 To Recoat: Scuff sand after 48 hrs.

Bake / Force Cure

Flash Time: 10 – 15 min. (ambient)
 Substrate Temp: 140°F
 Bake Time: 30 – 40 min.

ADDITIONAL INFORMATION:

- ❖ Bake temperatures at or above 140°F may yield a lower gloss reading
- ❖ Air drying may yield slightly higher gloss ranges than baking
- ❖ Do not apply at temperatures below 50°F
- ❖ Excess film thickness will retard dry times
- ❖ Avoid moisture contamination in Q3606; this can gel the material and affect performance properties

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