



DULUX®

Armorspray®

2K 2:1 URETHANE

Dulux Australia
ABN 67 000 049 427

Product Name:

424-J0019 Dulux® Armorspray® 2K 2:1 Urethane clear base
424-line Dulux® Armorspray® 2K 2:1 Urethane mixed colour

Product Description:


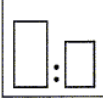
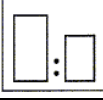

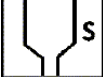
Dulux® Armorspray® 2K 2:1 Urethane is a premium quality two pack polyurethane finish. It is available as a clear base that may be tinted with the 483 line Dulux® Autobuild® range of tinters.

Dulux® Armorspray® 2K 2:1 Urethane has been developed as a high gloss 2K top coat for spot repairs and overall 2K mixed colour top coating for automotive and commercial transport vehicles.

Prior to application, surfaces must be cleaned with Dulux® AutoSpeed® Prepwash, 965-89784 and sanded. If required, a suitable Dulux® AutoSpeed® or Dulux® AutoSpeed® CV primer may be used. Please refer to the appropriate TDS for further information.

Product & Additives:

Dulux® Armorspray® 2K 2:1 Urethane base 424-J0019
Dulux® AutoSpeed® 2K Thinner-XSlow 920-89963
Dulux® AutoSpeed® 2K Thinner-Slow 920-89847
Dulux® AutoSpeed® 2K Thinner-Normal 920-89292
Dulux® AutoSpeed® RP Thinner Fast 920-89819
Dulux® AutoSpeed® 2K Hardener Slow 980-S0028
Dulux® AutoSpeed® 2K Hardener Normal 980-89290
Dulux® AutoSpeed® RP 2K Hardener 980-89790
Dulux® Autobuild® Tinters 483 line

	Tinter addition	Tint according to colour formula. If using flattening base, add this as well. Mix well immediately after tinter added to base.
	Mixing ratio	2 Parts 424-line mixed colour
	Hardener	1 Part 980-89290 or 980-S0028
	Thinner	0-5% by Vol. 920-89292
	Spray Viscosity DIN Cup B4 @ 25°C	18-20 seconds




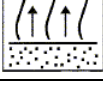





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	Gravity & Suction Feed	Fluid Tip: CONVENTIONAL: 1.2 - 1.5mm HVLP: 1.5 - 1.9mm	Spraying Pressure: 400 kPa/ 4 bar 200 kPa/ 2 bar <small>Or refer to manufacturer's recommendations</small>
	Pressure pot	Fluid Tip: 1.7 - 2.0mm Spraying Pressure: 70-100 kPa. <small>Or refer to manufacturer's recommendations</small>	
	Application	Apply even coats until opacity is achieved.	
	Air Flash	3 to 5 minutes air flash between coats at 25°C.	
	Drying	Air dry overnight	
	Baking	30 minutes @ 60°C (980-89290)	
	Infrared	Short wave: 8 mins Medium wave: 10 - 15 mins	
	Spraying	Use air fed mask at all times. Refer to applicable AS/NZS Standards	

Recommendation:

Dulux recommend the complete painting of panels to provide maximum durability when applying topcoats such as 2K mixed colours. Blend outs will not give the appropriate film builds required and may break down prematurely.



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Weight Mixing Ratios for 424-Line Armorspray 2K Urethane Mixed Colour and Flex 485-89930

A. Using an balance and adding by grams.

Volume of RFU Colour (ml)	424-Line Colour (g)	485-89930 Flex (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	25.29	4.94	17.26	2.47
100	50.58	9.88	34.53	4.93
150	75.86	14.82	51.79	7.39
200	101.15	19.76	69.05	9.86
250	126.44	24.70	86.31	12.32
300	151.72	29.64	103.57	14.79
350	177.01	34.58	120.84	17.25
400	202.30	39.52	138.10	19.72
450	227.59	44.46	155.36	22.18
500	252.87	49.39	172.62	24.65
550	278.16	54.33	189.89	27.11
600	303.45	59.27	207.15	29.57
650	328.74	64.21	224.41	32.04
700	354.02	69.15	241.67	34.50
750	379.31	74.09	258.94	36.97
800	404.60	79.03	276.20	39.43
850	429.89	83.97	293.46	41.90
900	455.17	88.91	310.72	44.36
950	480.46	93.85	327.99	46.83
1000 (1L)	505.75	98.79	345.25	49.29

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or
920-89847 Autospeed Hot Weather Thinner as required.



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Weight Mixing Ratios for 424-Line Autospeed 2K 2:1 Urethane Mixed Colour

a. Using an balance and adding by grams.

Volume of RFU Colour (ml)	424-Line Colour (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	31.75	16.05	2.14
100	63.49	32.10	4.27
150	95.24	48.14	6.41
200	126.98	64.19	8.54
250	158.73	80.24	10.68
300	190.48	96.28	12.81
350	222.22	112.33	14.95
400	253.97	128.38	17.09
450	285.71	144.43	19.22
500	317.46	160.47	21.36
550	349.21	176.52	23.49
600	380.95	192.57	25.63
650	412.70	208.62	27.76
700	444.44	224.66	29.90
750	476.19	240.71	32.04
800	507.94	256.76	34.17
850	539.68	272.81	36.31
900	571.43	288.85	38.44
950	603.17	304.90	40.58
1000 (1L)	634.92	320.95	42.71

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or 920-89847 Autospeed Hot Weather Thinner as required.



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For Safe Handling:

Please refer to the Material Safety Data Sheet No: 003046 for this product before use. This product may contain materials that are being introduced to Australia under a permit.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS), NZ 0800 734 607

For further information contact:

Dulux Australia

1956 Dandenong Rd, Clayton,
Victoria, 3168

Australia

ABN 67 000 049 427

Telephone:

1 800 810 114

Fax:

61 3 9314 0596

Dulux New Zealand

31B Hillside Road

Glenfield, Auckland
New Zealand

Telephone:

0800 800 424

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