

2K Acrylic Ready Mixed Top-coats 1510

Product description

SIPES 1510 is a 2K acrylic-urethane ready mixed topcoat for repainting of passenger cars and commercial vehicles. **SIPES 1510** delivers accurate colors, high gloss, and durable topcoats with excellent coverage. When used in conjunction with a range of MS hardeners, **SIPES 1510** topcoats can be applied for any size of repair job.

Substrates

SIPES 1510 should be applied over properly prepared SIPES 2K fillers/primers, 2K and 1K Sealers, and old finishes in solid conditions.

For final sanding, use sanding paper P400/P500 dry or P800/P1000 wet prior to applying **SIPES 1510** 2K topcoats. For cleaning and degreasing the surface prior to applying the topcoat, it is recommended to use **SIPES** Degreaser.

Application

Mixing ratio: 100:50:30 (2:1:0.6)	100% SIPES 1510 2K Ready mixed topcoat
	50 % MS Hardeners: Extra Fast, Fast, Normal, or Slow
	30% 2K thinners: Fast, Normal, Slow or Extra Slow
Use measuring stick	Use measuring stick for mixing ratio confirmation.
Application viscosity:	16-18 s (DIN4/20°C)
Spraygun tips:	1.3-1.4 mm HVLP: 1.8-2 bar/27-30 psi at the air inlet. Refer to the spraygun manufacturer's recommendation.
Number of coats:	Apply 2 normal coats (to get opacity). Recommended total dry film thickness is 40-50 microns.
Flash off time:	Between coats: 4-7 min
Drying time:	12 h/20°C 30 min/60°C
IR Drying:	Short wave 8-10 min Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets up.

General notes

Choice of hardener

SIPES offers a range of hardeners to meet every type and size of car refinish under all conditions. The recommendations below are for guidance only:

SIPES Extra Fast hardener is recommended for temperatures below 20°C and for small size of repair.

SIPES Fast hardener is used for medium sized repair and for temperatures up to 25°C. **SIPES** Normal hardener is suitable for large areas, i.e. for all repairs at temperatures up to 30°C.

SIPES Slow hardener should be used when the temperature exceeds 30°C.

Use of SIPES accelerator

SIPES accelerator is an additive for acceleration of drying time and may be added in the mixture of the clearcoat and hardener at a level of 1-5 mass % prior to addition of the thinner.

Note: The addition of **SIPES** accelerator will reduce pot life to 2-3 hours.

Recoating

SIPES 1510 is recoatable after the drying time.

Rectification and polishing

SIPES 1510 topcoat does not require polishing as it offers excellent gloss. In a case that some dirt has occurred, polish by machine using a high quality polish. Polishing is easiest up to 24 h after the drying time.

Other tips

1. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Clean the spraygun thoroughly immediately after use of 2K products.

Health and Safety

1. For full Health and Safety information please refer to Material Safety Data Sheet (MSDS).
2. Observe the precautionary notices displayed on the container.
3. Goggles and suitable protective equipment must be worn while using these products.
3. Good ventilation must be provided in the working environment.

IMPORTANT NOTE:

These products are for professional use only. The information in this Technical Data Sheet is based on our best knowledge and given for information purposes only without any obligation as we do not have control over the quality and conditions of the surface, or over many factors affecting the use and application of the product. Always read the Material Safety Data Sheet and the Technical Data Sheet for this product if available.

We have a technical-commercial team at your disposal to help you with any queries.

Due to standards and specification evolution, the company reserves the right to change the given data without prior notification.

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