

PRODUCT HIGHLIGHTS

8600-AS Series Polyurethane Topcoat

DESCRIPTION:

Transtar's Polyurethane Topcoat (Anti-Sag) is a unique high performance topcoat with superior chemical resistance and outstanding durability. Formulated with a specially modified polymer and Anti-Sag Technology, this product allows for fast, easy 1-coat application eliminating runs and sags. This is an exceptional product for fleet refinishing, OEM manufacturing, general aviation, pleasure marine and for other performance demanding markets such as industrial, general metal and specialty industrial maintenance applications. This highly productive, easy to apply coating meets the demanding requirements of today's market. 8600 Series is available in both 3.5 and 2.8 VOC for air quality regulatory compliance.

PRODUCTS:

8604 Polyurethane Topcoat Activator, Quart, 4/case
 8600 Series Variety of colors - call for details, 3/4 Gallon, 2/case
 8704 Urethane Accelerator, Quart, 4/case



SURFACE PREP:

Depending on surface, see surface preparation for sanding recommendations.



MIX RATIO:

3:1 (3 quarts of paint to 1 quart of activator)
 Pot Life: 2 hours @ 68°F (20°C) and 50% relative humidity



REDUCER:

Not required. May be reduced up to 10% by volume using 6700 Series Urethane Grade Reducer or 6700-F Series Zero VOC Urethane Grade Reducer that is appropriate for the shop temperature.



HVLP/LVLP:

1.3 - 1.8 mm
 2 - 3 medium wet coats



5 - 15 minute flash
 1.5 mils per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TIMES:

| Dry times @ 70°F (21°C) and 50% RH | | *with 8704 Urethane Accelerator |
|------------------------------------|------------|---------------------------------|
| Dust Free | 20 minutes | 20 minutes |
| Tack Free | 3 hours | 1 1/2 hours |
| Tape Time | 12 hours | 3 hours |
| Dry Time | 12 hours | 8 hours |



SANDING:

DA (Dry): #320-500 Hand (Wet): #500-800

See next page for more detailed product application. See website for this document in other languages.
 Veá la página siguiente para un uso más detallado del producto. Veá el Web site para este documento en español.
 Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

8600-AS Series Polyurethane Topcoat

SURFACE PREPARATION:

Polyurethane Topcoat can be applied over existing finishes that have been properly prepared. Recommended preparation is as follows: clean substrate with Aqua SCAT 2 1391/1394 then dry sand (DA) using 320-500 grit paper; if wet sanding, use 500-800 grit paper. The existing finish must be tightly adhered to the substrate. Best results are achieved when topcoat is sprayed over properly applied two component primer, such as Transtar's Kwik Prime 6441/6444, EZ Sand Primer 6401/6404 or any of Transtar's Star Shade Sealer Systems.



APPLICATION & MIXING:

Stir thoroughly to ensure uniform mixture. Mix 3 parts Polyurethane Topcoat with 1 part Polyurethane Topcoat Activator #8604, (3 quarts topcoat to 1 quart activator). Reduction is not necessary. However, paint may be reduced up to 10% by volume using Transtar's Urethane Grade Reducer that is appropriate for the shop temperature. For faster cure and dry times, add up to 8 oz of Transtar's Urethane Accelerator 8704 per ready to spray gallon of topcoat. For fisheyes or other related surface defects, add 1 oz of Transtar's Fisheye Remover 6737, per ready to spray gallon of topcoat.

APPLICATION FOR "SOLID COLORS": Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max (at aircap) for HVLP spray guns. Apply a light tack coat and 2-3 medium wet coats until desired coverage and flow is reached. Allow a 5-10 minute flash time between coats.

APPLICATION FOR "METALLIC/IRIDESCENT COLORS": Apply using 55-65 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max (at aircap) for HVLP spray guns. Apply a light tack coat and 2-3 medium wet coats until desired coverage and flow is reached. Allow a 5-10 minute flash time between coats.

APPLICATION FOR "CLEARCOAT" (OPTIONAL STEP): Acrylic Polyurethane Topcoat can be clearcoated with any of Transtar's 2K Acrylic Urethane Clearcoats. Allow color to flash 15 minutes. Mix clear as per label instructions. Follow clearcoat label and datasheet instructions for proper flash times and other application information.

PRESSURE POT APPLICATION: Set fluid delivery at 18-22 ounces per minute. Follow atomizing air and application instructions.

SPRAY GUN SET UP:

| GUN TYPE | FLUID TIP | AIR PRESSURE | FLUID PRESSURE |
|--------------|--------------|------------------------|----------------|
| Siphon Feed | 1.4 - 1.7 mm | 40 - 65 PSI | n/a |
| Gravity Feed | 1.4 - 1.7 mm | 40 - 65 PSI | n/a |
| HVLP Siphon | 1.4 - 1.7 mm | 10 PSI max (at aircap) | n/a |
| HVLP Gravity | 1.4 - 1.7 mm | 10 PSI max. | n/a |

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8600-AS Series Polyurethane Topcoat

REGULATORY:

| | | |
|--|----------------------|---------------------|
| Category: Single Series Coating 8600 Series | Individual Component | Ready to Use |
| VOC Actual | 3.63#/gal (435 g/l) | 2.72#/gal (326 g/l) |
| VOC Regulatory | 4.11#/gal (493 g/l) | 3.46#/gal (414 g/l) |
| Weight % of Volatiles | 60.00 | |
| Weight % of Water | 0 | |
| Weight % of Exempt Compounds | 16.00 | |
| Volume % of Exempt Compounds | 12.00 | |
| Density of Material (#/gal) | 8.25 | |

| | |
|------------------------------|----------------------|
| Category: 8604 | Individual Component |
| VOC Actual | 0.00#/gal (0g/l) |
| VOC Regulatory | 0.00#/gal (0g/l) |
| Weight % of Volatiles | 53.27 |
| Weight % of Water | 0 |
| Weight % of Exempt Compounds | 53.27 |
| Volume % of Exempt Compounds | 49.37 |
| Density of Material | 10.32 |

TECHNICAL TIPS:

FORCE DRYING: May be forced dried with infrared or convection heat at 140°F for 20 minutes. Allow a 10 minute cool down time before handling. Allow one hour cool down before sanding and polishing.

RECOATABILITY: Polyurethane Topcoat may be recoated with itself at any stage of drying. Sanding will become necessary after 24 hours.

CLEAN UP: Clean all spray equipment immediately after use. **DO NOT LEAVE MIXED MATERIAL IN EQUIPMENT.**

TECHNICAL DATA:

| | |
|-----------------------|---|
| APPEARANCE: | Black, Silver, White, Red, Green, Blue |
| % SOLIDS*: | 32% as packaged, 37.6% RTU* *(Solids by volume will vary depending on color) |
| SHELF LIFE: | One Year (unopened) |
| REDUCERS: | Optional: Up to 10% using Transtar Urethane Grade Reducer appropriate for your shop temperature. Note: Adding reducer will increase V.O.C.'s. |
| MIX RATIO: | 3:1 (3 quarts of paint to 1 quart activator) |
| POT LIFE: | 2 hours @ 68°F (20°C) and 50% RH |
| THEORETICAL COVERAGE: | 603 ft ² /gal at 1.0 mil, actual coverage may vary according to color |

ADVANTAGES:

- Anti-sag technology, easy to apply without runs and sags
- DTM (direct-to-metal) application
- Exceptional exterior weathering durability
- High gloss (all gloss ranges available)
- Superior chemical resistance
- Fast, productive dry times
- All colors are lead free and chromate free