







TECHNICAL DATA SHEET ULTIMATE DTM 2K HS Colour

Date: 18-Jul-2023

DESCRIPTION

ULTIMATE DTM 2K HS Colour is an direct to metal colour with excellent adhesion to bare metal. It eliminates the need for an Etch and Primer.

Composition: Acrylic Resins
Colour: Various colours available
Shelf life: 36 months in unopened container
Pack size: 1 Litre/5 Litre
Pre-treatment: FL8017 **ULTIMATE DTM 2K HS COLOUR** can be applied direct to metal.

	Health and safety “For professional use only” Important: When using any new product, consult the “Health and Safety” data sheet. Always read the risks and precautions stated on the product label.														
	<p>Mixing Ratio 2 : 1 10%</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: center; width: 33%;">2</td> <td style="text-align: center; width: 33%;">1</td> <td style="text-align: center; width: 33%;">10%</td> </tr> <tr> <td style="text-align: center;">FL8017</td> <td style="text-align: center;">FL2050</td> <td style="text-align: center;">FL2021/2</td> </tr> <tr> <td style="text-align: center;">ULTIMATE DTM 2K HS COLOUR</td> <td style="text-align: center;">ULTIMATE 2K HS HARDENER</td> <td style="text-align: center;">Final Systems 2K Thinners</td> </tr> </table>			2	1	10%	FL8017	FL2050	FL2021/2	ULTIMATE DTM 2K HS COLOUR	ULTIMATE 2K HS HARDENER	Final Systems 2K Thinners			
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	<p>Spraying Viscosity</p> <p>18 to 20 seconds BS 4 cup at 20°C – 14 to 16 seconds DIN4 cup 20°C Pot life – 2 ½ hours at 20°C dependent on speed</p>														
	<p>HTE/RP spray gun fluid tip 1.2 – 1.3 HVLP gravity feed fluid tip 1.2 – 1.5 Recommended Spray Pressure 2 – 2.5 bar</p>														
	<p>Number of coats 2 First coat: ½ coat closed Second coat: full coat At 20°C 3 to 5 minutes flash off between coats – 5 minutes flash off before bake or IR curing. Film thickness 40 – 50 micron.</p>														
	<p>Air Dry at 20°C dust free 10 minutes, tack free 1 hour, hard dry 3½ hours (fast)</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="background-color: #333; color: white;">Hardener</th> <th style="background-color: #333; color: white;">Bake Time (60°C)</th> <th style="background-color: #333; color: white;">IR Drying Time</th> </tr> </thead> <tbody> <tr> <td>STANDARD</td> <td style="text-align: center;">30 minutes</td> <td style="text-align: center;">16 minutes</td> </tr> <tr> <td>FAST</td> <td style="text-align: center;">20 minutes</td> <td style="text-align: center;">12 minutes</td> </tr> <tr> <td>EXTRA FAST</td> <td style="text-align: center;">15 minutes</td> <td style="text-align: center;">9 minutes</td> </tr> </tbody> </table> <p>Gloss will vary depending on speed used. For best results fast hardener will give good dry time and gloss level. Bare in mind booth temperature and the time taken to get to temperature. Times may vary based on environment. Accelerators should not be used with DTM products. ULTIMATE 2K HS Super Rapid Hardener should not be used under any circumstances with ULTIMATE 2K HS DTM Colour.</p>			Hardener	Bake Time (60°C)	IR Drying Time	STANDARD	30 minutes	16 minutes	FAST	20 minutes	12 minutes	EXTRA FAST	15 minutes	9 minutes
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