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400IF ISOFREE

400IF Isofree is a non-yellowing, fast curing, two-component coating which is isocyanate free. 400IF Isofree is U.V. stabilized and exhibits exterior durability and chemical resistance comparable to or better than most industrial grade two component polyurethane coatings.

- **Product:** Isocyanate free Acrylic based 2 Pack coating
- **Mixing Ratio** Four parts Isofree Base to one part Hardener, (400IF-0001 by volume).
- **Standard Colours:** Can be tinted to most colours.
- **Gloss** Full Gloss, Semi gloss
- **Thinning:** Universal Thinner 101UT-0001
- **Drying Time** Tack free time, 30 min
Dry times may be shortened if Isofree is cured @ 50° C for 30 – 60 min in an oven.
- **Recoat Time** 12 hours.
- **Exterior Exposure** Excellent
- **Container Size** 4Lt, 16Lt
- **Prime with** 120PE Etch Primer or 445EP Epoxy primer.
- **Coverage** Theoretical 15-20 metres squared per litre
Practical 6-8 metres squared per litre (Spray application)
- **Specific Gravity** 1.10 – 1.25 Kg/Lt
- **Weight Solids** 55 - 65 %
- **Volume Solids** 40 – 50%

Uses: Used as a substitute to isocyanate cured Polyurethane coatings. Isofree is ideal for use as a high performance coating on cars, trucks, buses, boats, farming machinery and earthmoving equipment etc.

APPLICATION

Ensure surface is free from dirt and grease or metal scale.

Round off all welds and sharp edges. Grind off any weld spatter and remove grease, oil and other contaminants in accordance with AS1627.1. Prepare metal surface by mechanical sanding or abrasive blast clean to a minimum of AS1627.4 Class 2.5 with a blast profile of 40 – 70 micron. Remove all dust or contaminants by brushing or vacuum cleaning.

System 1/

1st Coat Suitable 2k primer, allow 12 hours cure. (60-100 micron dft)

- 2k Primer: 445EP Epoxy Prime
- Primer coat may be repeated allowing for 12 hours cure time between coats to achieve higher film builds.

NB: dft- Dry Film Thickness.

2nd Sand with 320 grit paper and topcoat with 400IF Isofree and allow 12 hours cure. (40 – 60 micron dft) for

3rd Sand with 320grit paper and recoat as outlined in step 2 if necessary (40 – 60 micron dft)

System 2/

Prepare metal substrate as outlined above.

1st Coat 120PE Etch Primer, allow 2 hours cure.

2nd Coat 400IF Isofree and allow 12 hours cure.

3rd Sand with 320 grit and recoat with 400IF Isofree if required.

DRYING TIME:

2 – 4 hours touch dry

Overnight hard dry

(Drying time may be shortened if force cured in an oven at 50 deg C for 1 hr)

RECOAT:

Recoat overnight and sand between coats. May be applied over 2k Epoxies, 2k Polyurethanes and Polyesters. It is advised to test other brands for suitability prior using. May also be applied over single pack etch primer 120PE Etch Primer, as outlined above.

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