

# IKONIKOLOR PRO

## 2K DTM POLYURETHANE ENAMEL

- Two-component direct-to-metal topcoat
- Superior adhesion to properly prepared metals
- Corrosion-resistant, high-gloss protection
- Spray application only



### PREMIUM TWO-COMPONENT DTM POLYURETHANE ENAMEL

IKONIKOLOR PRO 2K DTM Polyurethane Enamel is a professional-grade, two-component coating engineered to provide direct adhesion, corrosion-resistant protection and a durable, high-gloss finish.

It may be applied directly to properly prepared steel, galvanized or phosphated steel, aluminum, cast iron and fiberglass, eliminating the need for a separate primer in approved applications.

The high-solids formula delivers excellent coverage, strong adhesion and lasting protection for demanding professional marine and industrial applications.

Proper and uniform substrate preparation is critical to achieving direct adhesion, corrosion protection and a consistent finished appearance.

### TECHNICAL INFORMATION

**VEHICLE TYPE:** Acrylic Urethane

**ACTIVATOR:** 951 Urethane Activator

**FINISH:** High gloss, 90 ± 5

**COLOR:** Snow White, Super Jet Black

**COMPONENTS:** Two

**MIX RATIO:** 4:1:25%

**SOLIDS BY WEIGHT:**

**COVERAGE:** Zero loss calculations

**VOC:** <332 grams/liter (colors may vary)

**VISCOSITY:** 42 – 44 sec Zahn #2

**GUN TIP SIZE:** 1.3 – 1.8mm

**APPLICATION METHOD:** Spray

**NUMBER OF COATS:** 2 minimum

**POT LIFE:** 4 hours @ 70 degrees

**APPLICATION TEMP:** 50°F Min / 90°F Max

**WET FILM THICKNESS:** 3-4 mils

**DRY FILM THICKNESS:** 3.5 – 3.94 mils

**REDUCER/ CLEANER:** Ikonikolor PRO Reducers

**RECOAT TIME:** @ 70° 15-20 mins

**FLASH POINT:** <74.3

**ASSOCIATED PRODUCTS:** 92 EZPrep, 7050 EZ Fair, 4700/4701 Pettit Protect Epoxy Primer, Ikonikolor Pro Prep Solvent, Ikonikolor Pro 951 Urethane Activator

### Mixing Instructions:

1. Mix Part A base material thoroughly until all solids are uniformly dispersed.
2. For conventional high-solids spray, mix 4 parts Part A base with 1 part Ikonikolor Pro 951 activator by volume.
3. Reduce 25% by volume with the appropriate approved Ikonikolor Pro reducer and mix thoroughly.
4. Apply 2 uniform coats, allowing 15–20 minutes between coats.
5. Induct mixture for at least 5 minutes prior to application



**APPLICATION INFORMATION:** Apply by conventional, airless or air-assisted airless spray. For conventional high-solids, use a 1.5–1.8 mm RP nozzle at 29–44 psi. Apply 2 coats with 15–20 minutes between coats. Do not apply in the late afternoon when working outdoors as the wet film may be adversely affected by changes in temperature and humidity.

Maintain consistent gun distance, overlap and film build.

**NOTE:** This product allowed to cure for 24 hours or longer must be sanded with 320 grit sandpaper for proper adhesion

**PREPARATION FOR PAINTING:** Use only on clean, dry, properly prepared substrates. Aluminum and light alloys must be sanded with P240–P320 abrasive. After every preparation step, remove dust and residue and degrease with the approved Ikonikolor Pro 1130 cleaner. Proper and uniform preparation is critical to direct adhesion, corrosion protection and finished appearance.

**GALVANIZED OR PHOSPHATED STEEL:** Abrade thoroughly with Scotch-Brite®. Remove residue and degrease with the approved anti-silicone cleaner. **CAST IRON:** Sand with P80–P120 abrasive. Remove residue, degrease and allow the surface to dry completely before coating.

**BARE FIBERGLASS GRP:** Sand with P240 abrasive. Remove all sanding dust and residue. Degrease with the approved Ikonikolor Pro 1130 cleaner and allow the surface to dry completely before applying the DTM coating.

**DIRECT-TO-METAL APPLICATION:** Direct adhesion depends on complete and uniform substrate preparation. Apply only to approved substrates prepared to the specified abrasive profile. Maintain consistent gun distance, overlap and film build.

**APPLICATION CONDITIONS:** Temperature, airflow, humidity, substrate temperature and equipment can affect flash and dry times.

Do not substitute activators, reducers or cleaners. Use only products approved for the Ikonikolor Pro DTM system.

Direct to metal coatings need to be planned carefully! Freshly abraded metals must be coated during the same shift. Preferably within 4 hours to prevent flash rust / oxidation from occurring.

Do not use rags to clean this surface. The sharp metal could snag fibers from the rags. These fibers could act as wicks for moisture or other contamination to occur causing premature failures.

**BARE STEEL:** Blast to ISO 8501-1 Sa 2.5 with medium surface roughness. Remove all dust and blast residue. After preparation: Degrease with the approved Ikonikolor Pro 1130 cleaner. Apply only when the surface is completely clean and dry.

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| Gun                      | Air Pressure        | Nozzle                                  |
|--------------------------|---------------------|-----------------------------------------|
| Conventional High Solids | 29-44 psi           | 1.3-1.8 mm RP                           |
| Airless / Air-Assisted   | 29-44 psi atomizing | .011-.017 tip; 1,015-2,030 psi material |

| Dry Times                  | Flash   | Dust Free    | Dry To Touch | Through Dry |
|----------------------------|---------|--------------|--------------|-------------|
| 140 Degrees<br>(Force Dry) | 10 mins | 20 - 30 mins |              | 60 mins     |
| 70 Degrees                 | 15 mins | 20 mins      | 2 - 3 hours  | 24 hours    |

| Application System              | Mix | Reducer | Pot   | Zahn #2    | Nozzle     | Air       | DFT              | Coats / Interval |
|---------------------------------|-----|---------|-------|------------|------------|-----------|------------------|------------------|
| High Solids<br>Conventional     | 4:1 | 25%     | 4 hr  | 43 ± 3 sec | 1.2-1.8 RP | 29-44 psi | 3.15-3.94<br>mil | 2 / 15-20 min    |
| High Solids Airless /<br>Airmix | 4:1 | 0-5%    | 4 hr  | 96 ± 5 sec | .011-.017  | 29-44 psi | 3.94-4.72<br>mil | 2 / 15-20 min    |
| Medium Solids<br>Conventional   | 3:1 | 15%     | >4 hr | 26 ± 2 sec | 1.3-1.5 mm | 29-44 psi | 2.36-2.76<br>mil | 2 / 15-20 min    |