



# Acrylic Urethane Topcoat UNITAN

Version 1.0

## PRODUCT DESCRIPTION

### ■ Outline

Acrylic urethane topcoat UNITAN is extremely durable and chemical/solvent resistant. UNITAN provides high gloss and can be air-dried or force dried for a urethane-tough enamel which is ideal for OEM, fleet, truck and special vehicle finishing. UNITAN offers excellent hiding with lead and chromate free formulas. It is available in many intermix formulas including fleet specified colors.

### ■ Suitable Substrates

PS-220® Acrylic Primer-Surfacer	EP-411® Epoxy Primer
PS-330® Urethane Primer-Surfacer	US-412® Primer-Sealer
PS-550® Urethane Primer-Surfacer	SPP-201® Special Plastic Primer
PP-100/PP-400® Plastic Primer	Aged Refinishes
OEM Enamels	

### ■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
Acrylic Urethane Topcoat UNITAN	4.0	4.0	12 months
Hardener SSH-302	1.0	1.0	12 months
HiQ Urethane Reducer DR-421 Series	4ℓ , 16ℓ	4ℓ , 16ℓ	24 months

\* Standard temperature of storage is 20°C.

### ■ Mixing Viscosity

15~20 sec. Viscosity(A+B+T) Ford Cup #4 at 77°F (25°C)

### ■ Pot Life

6 hours at 77°F (25°C) after mixing

### ■ Reducer

	Temperature			
	5~15°C	10~25°C	20~35°C	30°C or above
Partial	DR-421W	DR-421WS	DR-421S	DR-421S
1~3 panels	DR-421W	DR-421WS	DR-421S	DR-421S
4 panels or above	DR-421W	DR-421WS	DR-421S	DR-421R

## APPLICATION GUIDE

### ■ Use

Stirring



Stir thoroughly before use.

Surface Preparation



Wipe dry with a clean cloth. Sand and eliminate all rust and corrosion.

Mixing Ratio



Product Name	Mixing Ratio
Acrylic Urethane Topcoat UNITAN	3
Hardener SSH-302	1
HiQ Urethane Reducer DR-421 Series	0.5~1

\* Mix by volume.

Spray Condition



2.5~3.5 bar (gravity feed)  
2~3 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.2~1.5mm, D.F.T.=50~60μm



3.0~4.0 bar (siphon feed)  
2~3 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.4~1.6mm, D.F.T.=50~60μm



0.6~0.8 bar (at nozzle)  
2 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.4~1.8mm, D.F.T.=50~60μm



Set time : Apply topcoat after 10~20 minutes.  
(Reference temperature : 20°C)

Protective Equipment



Use fresh air mask or charcoal respirator to avoid inhaling or being exposed to fumes.

### ■ Drying Times

	Temp.	Time	Temp.	Time	Remark
Set time	25°C	10~20 min			
Time to handle	25°C	10 hrs	60°C	30 min	
Time to stripe	25°C	12 hrs	60°C	40 min	
Time to polish	25°C	10 hrs	60°C	30 min	

(\*) If coats are thicker, the drying schedule will be delayed.



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## ADDITIONAL INFORMATION

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### ■ Recoatability

- 1) After 24 hours, sand with P600 and recoat.

### ■ VOC Content

VOC content of 4.6lbs/gal (560g/liter)

### ■ Notice

1. Completely eliminate the moisture of spray equipment before use.  
Cleanse immediately after application not to have any leftover on spray equipment.
  
2. Put a lid on the product after apply and keep it away from direct sunlight and moisture.

### ■ Health and Safety

1. Be well-informed of MSDS before use.
2. Follow all the directions labeled on the container.
3. For safety reasons, work in the fully-ventilated place.
4. Wear safety glasses, coveralls and latex gloves when mixing and applying.

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