



1400 SERIES

FACTORY COLOR

TECHNICAL DATA SHEET

THIS IS THE PAINT | THIS IS THE SYSTEM | THIS IS i.COLOR.

1400 SERIES FACTORY COLOR

Acrylic Urethane Single Stage Coating - 2.8 VOC

PRODUCT DESCRIPTION:

iColor Single Stage 1400 Series Colors are Direct to Metal (D.T.M.), high solids, high gloss, 2.8 VOC coatings intended for use in automotive and industrial applications. Offers superior protective maintenance for surfaces exposed to humidity, chemicals and corrosive elements. Available in 12 vibrant colors.



SURFACE PREPARATION:

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively.
2. Clean area with Wax and Grease Remover or low VOC cleaner.
3. Use a tack cloth to remove any surface contaminants that may have settled on the repaired areas prior to paint application.
4. Apply 1400 series High Performance Factory Color.

****DIRECT TO METAL ADHESION: Performance is better when using 2010 DTM Primer under 1400 Series.****



POT LIFE:

Pot life will be about 3-5 hours at 77° F.



MIXING DIRECTIONS (4:1:1):

4 PARTS 1400 Series Paint

1 PART 1020 Catalyst

1 PART 1070 Zero VOC Reducer or other quality low VOC urethane reducer



APPLICATION DIRECTIONS:

Adjust air pressure to 40-50 psi at gun for gravity or siphon feed guns. HVLP use 6-10 psi at air cap.

Apply 2-3 medium coats (maximum 2 mils wet per coat) or until hiding is achieved.

Allow a 15-20 minute flash time between coats and before force drying.



DRY TIMES AT 77°F:

Flash Time 15-20 MINUTES

To Deliver 16-24 HOURS



BAKE TIMES AT 140°F

Purge Time 15 MINUTES

Bake Time 40 MINUTES



1400 SERIES

FACTORY COLOR

TECHNICAL DATA SHEET

THIS IS THE PAINT | THIS IS THE SYSTEM | **THIS IS i.COLOR.**



RECOATING:

1400 Series Acrylic Urethane Single Stage Color may be recoated after 16-24 hours at 77° F. After 16-24 hours it must be lightly sanded/scuffed before additional color or clearcoat may be applied.



ACCELERATOR & FISHEYE ELIMINATOR:

Accelerator and/or Fisheye Eliminator is not recommended for use in this product.



CLEAN-UP:

Clean spray equipment immediately after use with gun wash, or a high quality lacquer thinner, or compliant solvent depending on area regulations.



TECHNICAL DATA:

| | |
|--------------------------|-----------------------------------|
| Color: | Various |
| Catalyst: | 1020 |
| Low VOC Reducer: | 1070 |
| Mixing Ratio (2.8 VOC): | 4:1:1 |
| Weight Solids (RTS): | 52% - 70% |
| Viscosity #2 Zahn (RTS): | 18 - 28 seconds #2 Zahn |
| Pot Life: | 3-5 hours |
| Film Build per coat: | 1.0-2.0 mils per full wet coat |
| Coverage: | 850 sq.ft. per gallon @ 1 dry mil |
| Disposal/Safety: | See MSDS for this product |

FOR INDUSTRY USE ONLY

Read MSDS Before Use

1400 Series Factory Color must be blended with other components before the product can be used. Any mixture of the components will have the hazards of all the components. Before opening the packages, read all warning labels and material safety data sheets. Follow all precautions. This material is designed for application by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

NOTE: iColor products are not recommended for use in temperatures below 65°F. Using iColor products below these temperatures will effect dry times and product performance characteristics.