Total Coat Undercoating

Cleaning:

TC/UC should be applied on a clean, bare, primed or painted surface, free of oil, grease, dirt, release agents etc. A citrus based or waterborne degreaser is recommended for thorough cleaning, even on new cars. Failure to properly clean and degrease the surface to be coated will result in the loss of adhesion and the dried coating will easily peel away in large sheets.

Applying:

TC/UC has to be applied at a min of 55°F at a wet thickness of 0.5 - 1.0 mm (20 to 40 mils). When applying with the RA/88 Economy gun, use 30 – 70 psi and hold the gun 12 to 14 inches away from the substrate. These are very crucial requirements. Do not guess, consult an accurate thermometer that is measuring **in** the spraying area. Temperatures do differ a lot from floor to ceiling. Be especially careful with opening of warehouse doors etc. which can bring in colder air.
Failure to apply at this min temperature or recommended thickness will result in the dried coating being cracked or easily removable.

Drying:

TC/UC should not be exposed to temp below 55°F during the application and curing process. The drying process actually exists of three different steps: “dry to the touch”, “fully cured” and “fully cross linked”.

TC/UC will be dry to the touch after:
90 min in ambient air of 72°F and RH 40% . More drying time might be required at higher RH.
30 min in a heated booth at 130°F (Allow 15 minutes flash-off at 72° F before entering the oven)
30 min (10 min flash off at 30” and 20 min full bake at 30”) under Infra-Red lamps.

TC/UC will be fully cured after:
24 hours at ambient air of 72°F and RH 40%. More curing time might be required at higher RH.
60 min in oven at 130°F and a cool down period of 1 hr. at 72°F.
40 min (10 min flash off at 30” and 30 min full bake at 30”) under the Infra-Red Lamps and a 1 hr cool down at 72°F.

TC/UC will be fully cross linked after 7 to 12 days.

Chemicar USA
670 New York Street
Memphis, TN 38104
www.chemicar.com

Tel: 800-261-7976
Fax: 901-274-8816
Email: sales@chemicar.com

Total Coat Undercoating

Drying cont.:

Curing times can be considerably improved by adding air movement (fan) to the drying method.
Do not force dry at temps higher than 100°F.

For OEM high bake oven applications call 800 261 7976.

When the coating is “dry to the touch” the sprayed items can be moved, worked on, packaged etc. However they cannot be exposed to water and cold temperatures as this will cause thermal shock. Thermal shock will cause cracking of the coating and the TC/UC will be easily removable. Allow the coating to fully cure before exposing to water and cold weather. However during the next 7-12 days of cross linking, the coating will gain in hardness and strength. A fully cross-linked coating has a hardness of: Shore A: 92-95.

Storage:

TC/UC should be stored in a cool and dry place and has a 1-year shelf life when kept in temperatures between 45° - 85° F. Do not store in direct sunlight. Do not freeze.

Chemicar USA
670 New York Street
Memphis, TN 38104
www.chemicar.com

Tel: 800-261-7976
Fax: 901-274-8816
Email: sales@chemicar.com