

Door Armor 6000 Clear Application Instructions

PREPARATION



Qualifications: Only skilled contractors, who are trained, experienced and familiar with two part acrylic polyurethane

systems should use product. Contractor must thoroughly read tech spec, label, and MSDS prior to application. If there are any additional technical questions, call either the Distributor or the Manufacturer before commencing the job.

Substrate: Door Armor 6000 clear is intended to be used over top factory finishes or previously applied coatings on smooth metal, fiberglass, and plastic surfaces only. It is not intended to be used over any type of "raw", uncoated metal. It also is not intended to be used on any type of wood, masonry, stucco, concrete, whether previously painted or not.

Preparatory Work: Surfaces must be clean, dry, and in sound condition. Remove all oil, grease, dirt, loose rust, and other foreign contaminants to ensure proper adhesion. Insure adequate surface profile by sanding or through other methods of abrading.

Previously Painted Surfaces: Remove all surface contaminations, i.e. chalk, wax, grease, oil, polish, loose paint, dirt, rust, etc. Clean with a strong abrasive detergent, rinse well and allow to dry. Scrub mildewed/moldy surfaces with bleach and rinse well. Surface should be abraded using silicone carbide sandpaper, Scotch-Brite or other abrading medium to de-gloss and create a surface profile. Completely remove all chalk, dust, grit, etc. Do not use, turpentine, mineral spirits or other solvents that will leave oily residues. Test material prior to application to assure compatibility and adhesion. If adequate adhesion is not achieved do not continue in the application of this product. Do not apply to weathered, peeling, or damaged coatings. In some cases, previous coatings may need to be completely removed.

Equipment: The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with existing environmental and application conditions.

Airless Spray:

Pressure: 800 - 1200 psi
Hose: 1/4" ID
Tip, Fine Finish: .010" - .013"
Filter: 200 mesh
Reduction: Max 20% by volume

*Adjust pump pressure to lowest possible setting that allows proper atomization

Conventional Spray/HVLP:

Gun: Binks 95, Fluid Nozzle: 63 B
Air Nozzle: 69 PB
Atomization Pressure: 40-70 psi
Fluid Pressure: 20-25 psi.

NOTE: If specific application equipment is listed above, equivalent equipment may be substituted.

APPLICATION

Mixing: 4-1 (4 Parts resin to 1 part activator) Mix contents of Part A resin thoroughly. When using semi-gloss or satin finishes make certain no "sheen reducing" pigments remains on the bottom or sides of the can prior to mixing in Part B activator. Part B activator should always be added to Part A prior to any reducer being introduced. Power agitation is strongly recommended for a minimum of 2 minutes, or a minimum 5 minutes if mixing by hand. During agitation avoid introducing air or bubbles into the material.

To ensure that no unmixed material remains on the sides or bottom of the cans after mixing, visually observe the container by pouring the material into a separate container.

When making a 2nd batch, do so as instructed above in a separate container. Never start mixing a new batch directly into a container that still has activated material in it or add new resin and activator separately to an existing activated batch. Never add newly activated material into a batch that has been activated for more than 30 minutes.

NOTE: Mixing Ratios can vary. Always check container labels before mixing any 2 component material together.

Reducer: up to 20% as needed with Acetone or SO 660 when temperatures are below 80°F, or SO 575 for warmer conditions.

Straining: Recommended for all applications.

Respirators: Mix in well ventilated area. Wear a properly fitted air-purifying respirator with organic vapor cartridges. Confined areas, wear a positive-pressure, supplied-air respirator and utilize proper OSHA safety standards.

Application Conditions:

Temperature (air, surface, material): 50°F minimum - 90°F maximum
Relative Humidity: 85% maximum

NOTE: Temperature, humidity and direct exposure to sunlight directly affect dry time.

Application in temperatures below 50°F may result in uneven sheen. Temperatures above 90°F may cause dry spray, poor adhesion and uneven sheen. Failure to observe these parameters may result in paint failure and void the warrantee.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. Plan painting schedules to avoid these influences during the first 16 - 24 hours of curing. Failure to do so may result in paint failure and void the warrantee.

Spreading rate: (@ 2.5 mil WFT): 640 Square Feet per Gallon theoretical with no loss.

Adjust accordingly when reducing to assure minimum 1.5 mil DFT

Recommended Film Thickness: 1.75 mil dry (2.5 mils wet).

Drying Schedule, @ 2.5 mils wet -50% RH (Temp/Humidity Dependent)

	50°F	77°F	90°F
To Touch:	6 hours	3 hour	2 hours
Re-coat:	16 hours	4 hours	3 hours
Dry Hard:	48 hours	8 hours	4 hours
Full cure:	6 days	3 days	3 days

APPLICATION PRECAUTIONS

When using spray applications, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If needed, cross-coat spray at a right angle.

When spraying corrugated overhead steel doors using airless spray equipment a 3 x .012 double orifice fine finish spray tip is advised, with the spray technique of making horizontal passes over each corrugate.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. If possible, plan painting schedules to avoid these influences during the first 16 - 24 hours of curing. *Excessive reduction of material or mils thickness can affect film build, pulling, appearance, sheen level and adhesion. The coating sets up quickly, To Touch: 2 hours

*Clean equipment before use or before periods of extended downtime with reducer or acetone to avoid blockage. Do not mix previously catalyzed material with new. Do not apply the material beyond recommended pot life. Test product on substrate prior to application to insure adhesion, desired color and finish, compatibility and performance.

CLEAN UP AND PRECAUTIONS

Do not allow catalyzed material to stay in hoses, gun, and spray equipment or damage may occur. Stagnate activated material may harden in sprayer, hoses, and gun in less time than pot life if left in direct sunlight or heat. Always drain lines and pump if leaving equipment idle for more than 20 minutes.

Clean spills, splatters, and equipment immediately with acetone or solvent. Follow mfg.'s safety recommendations when using any solvent. Do not allow catalyzed material to stay in hoses beyond pot life. Immediately clean material on skin and hair with industrial soap/water. Do not allow material to dry onto skin or hair. Proper methods to protect over spraying should be implemented. Atomized particles will adhere to most surfaces and are extremely difficult to remove. Please read Material Safety Data Sheets (MSDS) carefully. Use only with adequate ventilation. Prevent breathing of spray mists. In confined areas, wear a properly fitted respirator during application until all vapor and spray mists are gone. Protect eyes and skin. Do not take internally. Do not use if you have had a prior reaction to polyurethane resins.

KEEP OUT OF REACH OF CHILDREN!!

WARRANTY

***Warranty Coverage:** This product is guaranteed not to lose more than 25% of its sheen, and/or 25% of its color and remain adhered to the surface it was applied to for the period of the warranty. This warranty does not cover previously applied coatings that this coating may have been applied over and are failing, or caused to fail by the application of this coating. This warranty covers replacement of the work, material and labor, on a prorated basis only. This warranty does not cover or include the cost of removal of any previously applied failed(ing) coating(s) for the fulfillment of this warranty. In no event will Manufacturer and Seller be liable for any loss of profits or other special consequential damages, even if Seller has been advised of the possibility of such damages. The foregoing limitation on liabilities is in lieu of all other warranties expressed or implied including, but not limited to, those concerning merchantability and fitness for a particular purpose.