



Technical Data Sheet
Automotive ECO1688 ULTRA CURE
For Professional Use Only

1. Product and Storage Information

Product Description: A UVA curable polymer clearcoat, primer surfacer and texture coating for use as a rapid repair surfacer or clearcoat top coat for metal and flexible automotive plastics and synthetic substrates. Upon exposure to UV light, the coating cures tack-free within 4 minutes. The cured coating has excellent adhesion and is compatible with most waterborne and solvent base coats. Can be applied to previously finished and fully cured automotive coating systems. The formulation is 100% solids containing zero solvents or HAPs (100% VOC free). The product exhibits no off-gassing, resulting in low to no shrink (superior wetting) and exceptional gloss retention. The product does not require a catalyst or reducer and is ready to use as is.

Storage and Shelf Life: The product shelf life is 12 months provided the container remains sealed and is not exposed to extreme hot or cold temperatures within the range of 50°F to 90°F. Any tampering, misuse or negligence in handling or use of the product renders the warranty void. Further, the warranty is void if, at any time customer stores the product in a manner inconsistent with the recommended conditions.

2. Application



Use suitable respiratory and PPE equipment
See Section 6 (Liability/Hazard Info) for more details



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Preparation Process: Use 99% isopropyl alcohol (IPA) or a compliant refinish cleaner to prep before application of the coating.

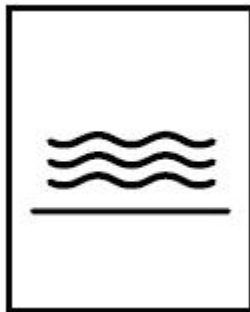
You may use a wax and grease remover or tack cloth, to prepare the surface to be coated, it is preferred to follow up with a 90-99% isopropyl alcohol (IPA) prep prior to application of the coating if local V.O.C regulations allow.

Application Process: Apply in a well-ventilated area, use appropriate PPE and a respirator (full / half mask) for spray coating (refer to SDS).

Product can be applied at temperature ranges of between 60°F and 112°F as well as humidity between 20% and 97%. Product temperature should be at minimum 72°F. Substrate temperature should be at minimum 60°F. Any spray equipment may be used. The recommended tip size is 1.2 - 1.8 mm. (1.8 for texture coat)

Follow standard shop practice when spraying. The remaining unused polymer should be stored in an opaque container and may be reused as long as the viscosity has not increased. **Unused polymer should not be returned to the original container.** The spray equipment can be cleaned with isopropyl alcohol or acetone.

WARNING: material will start curing immediately when applied in direct or indirect sunlight.



Application High Gloss Clearcoat:

1. Apply one wet followed by a work coat to achieve a minimum film build of 1.5 mils and let the product flow/level into the desired texture. ECO1688 needs the 1.5 mils of out the door material for longevity and hold out.

2. Blend Panels should be abrade with 600 grit followed by a red scotchbrite on edges and a basecoat wet bed must be used prior to ECO1688 application

3. Cure for 2-4 min with UVA curing light.

4. For additional coats no sanding is necessary during the normal spray session (20 minutes) Degloss after 20 minutes or exposure to natural UV light. Sand with 500-800 grit paper to recoat.



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*Note: applications recommended coverage of 1.5 mil after product has been through detail color sanding and polishing process if necessary

Application High Build Clear Primer Surfacer (treat bare metal prior to application)

1. Repair area should be abrade with 320 grit followed by a red scotchbrite prior to ECO1688 application as a primer surfacer.
2. Apply one wet coat to achieve a minimum film build of 1.5 mils and let product flow to desired texture.
3. Cure for 2 min with UVA curing light.
4. Repeat

Application for Clear Texture Coat

1. Repair should be abrade with 320 grit followed a red scotchbrite prior to ECO1688 application as a texture coat.
2. Apply ECO1688 at lowered air pressure to achieve desired texture. Fluid tip size and the temperature of ECO1688 will assist in achieving the correct profile.
3. Once profile of texture duplicates OEM immediately cure for 2 min with UVA curing light.
4. Texture Coat must be scuffed or sanded thoroughly prior to topcoat application.

* note (air pressure and fluid tip size will determine the actual texture profile)

Spray Gun Set-Up / Application Pressure:

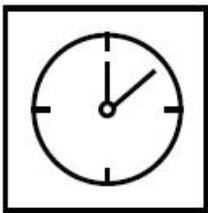
RP - Gravity Feed	1.2 - 1.8 mm	Manufacturer Recommendation
HVLP - Gravity Feed	1.2 - 1.8 mm	Manufacturer Recommendation



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3. UV Through Cure Verification

Use this procedure to verify your UVA light is adequate to thoroughly cure the product.



1. Use a test panel and apply a 3 mil coat.
2. Cure with UV light for a minimum of 2 minutes.
3. Let rest for 10 minutes.
4. Check for a tack free surface. If it's not tack free then it has insufficiently cured*.
5. Take 220 grit sandpaper and sand completely through looking for dry powder all the way through. If you encounter gummy material or clogged sandpaper then it has insufficiently cured*.

***An insufficient cure indicates that the UVA light is unable to cure the product. (This could be due to the distance or total output power of the light)**

4. Cleaning Process

Use Compliant cleaner, isopropyl alcohol or acetone to clean tools and equipment. Cure excess or unwanted material on surfacers or filters with UV light.

5. Material Details

Solid Content

100%



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Volatile Organic Content	0%
Coverage @ 1 mil	1608 sq. ft./gal

6. Liability/Hazard Info

See SDS for complete information.

Although the product is VOC free it should be used in a well-ventilated area.

If skin contact occurs immediately wash with soap and water.

Harmful if swallowed.

Causes skin and eye irritation and may cause an allergic skin reaction.

WARNING: Exposing open containers or barrels of product to direct or indirect sunlight will result in a runaway exothermic reaction. Product is unstable until properly cured.

Personal Protective Equipment: Eye/face protection: Face shield and safety glasses Use equipment for eye protection tested and approved under appropriate government standards such as NIOSH (US) or EN 166(EU).

Skin protection: Handle with gloves. Gloves must be inspected prior to use. Use proper glove removal technique (without touching gloves outer surface) to avoid skin contact with this product. Dispose of contaminated gloves after use in accordance with applicable laws and good laboratory practices. Wash and dry hands.

Body Protection: Use full paint suit with hood, The type of protective equipment must be selected according to the concentration and amount of the dangerous substance at the specific workplace.

Respiratory protection: Where risk assessment shows air-purifying respirators are appropriate use a full-face respirator with multi-purpose combination (US) or type ABEK (EN 14387) respirator cartridges as a backup to engineering controls. If the respirator is the sole means of protection, use a full-face supplied air respirator. Use respirators and components tested and approved under appropriate government standards such as NIOSH (US) or CEN (EU).

Control of environmental exposure: Do not let product enter drains.



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