



## TECHNICAL DATA SHEET

### NO MIX™ 2K SYSTEM

#### PRODUCT DESCRIPTION

A high performance Clear Over Base (C.O.B) tinting system that requires **NO MIXING**. No Mix product has the following characteristics:

- Superior pigment distribution
- Improved colour depth
- Consistency in Tinter/Toner strength
- Greater flow characteristics
- Better gloss retention
- Incorporating an extensive range of colour formulations

#### PRODUCT AND ADDITIVES

- Concept HS 2K Primer (High Build)
- Concept Primer Hardener Range
- Concept No Mix Colour
- Concept NM Reducer
- Concept Universal Hardener Range
- Concept MS-22 2K Clear
- Concept MS-22 Hardener Range
- Concept 2K Thinner




#### SUITABLE SUBSTRATES

- Aluminium surfaces primed with Concept 1K Etch Primer.
- Steel surfaces primed with Concept 1K Etch Primer.
- Polyester spray filler.
- Glass reinforced polyester.
- Concept Universal 4000 Primer
- Sound existing surfaces, except for weak surfaces such as nitrocellulose or enamels.

## MIXING RATIO

- ✓ Concept HS 2K Primer
  - 4 parts Concept HS 2K Primer by volume.
  - 1 part Concept Primer Hardener by volume.
  - 10 - 20% Concept 2K Thinner by volume.
  
- ✓ Concept No Mix
  - 1 part Concept No Mix colour by volume.
  - 50 – 70% Concept NM Reducer by volume.
  - If required, 5% by volume of Concept Universal Hardener can be added to the No Mix colour, before thinning, to activate it.
  
- ✓ Concept MS-22 2K Clear
  - 2 parts Concept MS-22 2K Clear by volume.
  - 1 part Concept MS-22 Hardener by volume.
  - If needed, a 5% reduction can be made with Concept 2K Thinner.




## SPRAY GUN AND PRESSURE

SPRAY GUN & PRESSURE:	<ul style="list-style-type: none"><li>• 1.2 – 1.4 mm through gravity feed.</li><li>• Pressure is 350 – 450 kPa.</li></ul>	
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## APPLICATION

- Before priming, ensure all surfaces are thoroughly sanded and cleaned with Concept Wax & Grease Remover.
- Mix the Concept HS 2K Primer, with both the hardener and thinner stated above. Apply two to three even coats.
- Allow the primer to dry (see below), sand the surface thoroughly with 800 Wet & Dry sandpaper.
- Ensure the surface of the primer is cleaned with Concept Wax & Grease Remover.
- Thin the No Mix to the stated level. Apply two to three even coats of No Mix colour. Ensure that the correct coverage has been achieved.
- Allow the No Mix Colour to dry (30 – 40 minutes) before the applying the clearcoat.

- Mix the Concept MS-22 2K Clear, with both the hardener and thinner stated above. Apply three even coats
- Allow the clear to dry for at least 24 hours before polishing and buffing. If possible, allow a longer drying period during colder conditions.

<p><b>SPRAYING VISCOSITY:</b></p>	<ul style="list-style-type: none"> <li>• Concept HS 2K Primer 25 – 27 seconds B4 cup at 25°C.</li> <li>• Concept No Mix colour 17 – 18 seconds B4 cup at 25°C.</li> <li>• Concept MS-22 2K Clear 18 – 19 seconds B4 cup at 25°C.</li> </ul>	
<p><b>FLASH-OFF TIME:</b></p>	<ul style="list-style-type: none"> <li>• 5 – 10 minutes between coats at 25°C for all products.</li> </ul>	
<p><b>DRYING:</b></p>	<ul style="list-style-type: none"> <li>• Concept HS 2K Primer 16 – 24 hours at 25°C for a Dry Film Thickness of 50 – 80 Microns.</li> <li>• Concept No Mix colour 30 – 40 minutes at 25°C for Dry Film Thickness of 20 – 25 microns.</li> <li>• Concept MS-22 2K Clear 16 – 24 hours at 25°C for a Dry Film Thickness of 50 – 60 Microns.</li> </ul>	

## TECHNICAL INFORMATION

<b>COLOUR:</b>	Primer: Beige, Grey No Mix: Large Range of Colour Formulations Available
<b>COVERAGE:</b>	Primer: 5 m <sup>2</sup> /L @ 80 Micron Dry Film Thickness. No Mix: 8 m <sup>2</sup> /L @ 25 Micron Dry Film Thickness. Clear: 7 m <sup>2</sup> /L @ 60 Micron Dry Film Thickness.
<b>POT LIFE:</b>	Primer: 2 – 3 hours at 25°C. Clear: 6 – 8 Hours at 25°C
<b>PACKAGING:</b>	Primer: 1LT, 4LT, 5LT Kit (Hardeners: 250ML, 1LT) No Mix: 1LT (Xirallic Tinters: 250ML) Clear: 1LT, 5LT (Hardeners: 500ML, 2.5LT)
<b>ITEM CODE:</b>	Primer: A03C/2KPRIM (Hardeners: A04C/PRIMH) No Mix: A12/NM Clear: A07C/MS22 (Hardener: A04C/MS22)
<b>SHELF LIFE:</b>	12 months (Hardeners: 6 months)

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The above information is reliable and accurate to the best of our knowledge at the time of preparation. Any recommendations or suggestions made are without warranty or guarantee. Users assume all responsibility since the conditions of use are beyond our control.

**REVISED: 20 December 2006**

**REPLACES ISSUE:**