

# Application of **KrystalKote™ Gloss**, clear or custom tint Graffiti- & Corrosion-Resistant Polyurethane Coating to **Commercial Vehicles**

## SURFACE PREPARATION

Refer to the **KrystalKote™ Data Sheet** for product preparation prior to application.

- 1.) The surface to be coated must be completely clean of all contaminants prior to application: including factory release agent, oil, grease, fingerprints, dust, powder, water, rust, scale, etc. Usually, a light solvent wipe-down is sufficient to remove minor oils and dust. Sandblasting areas of rust or scale may be required.
- 2.) Primed surfaces usually require only light solvent wipe-down to remove fingerprints, etc.
- 3.) Previously painted surfaces may require light sanding to remove gloss, and present a proper "grip" surface for **KrystalKote™**, followed by light solvent wipe-down to completely remove dust, fingerprints, etc.

**APPLICATION:** CLEAR COAT over factory paint, or CUSTOM TINT direct-to-metal (d-t-m) or over primer.

*QUALIFIED, PROFESSIONAL APPLICATION RECOMMENDED*

Equipment & materials required:

- ▶ Wet Film Thickness (WFT) gauge;
- ▶ Conventional or HVLP airgun spray equipment;
- ▶ Proper air delivery system (compressor, reservoir, moisture/oil trap, pressure regulators, etc.);
- ▶ Acetone or Methyl Ethyl Ketone (M.E.K.) as thinning solvent, if needed;
- ▶ Acetone, Lacquer Thinner, M.E.K., or Toluene as spray equipment cleaning solvent;
- ▶ Isopropyl Alcohol (IPA), Acetone, Lacquer Thinner, M.E.K., or Toluene as surface wipe-down solvent;
- ▶ Proper OSHA protective clothing and activated-charcoal filtered breathing mask apparatus.

Spray Equipment Selection Guide: Suitable equipment from other manufacturers may be used. Changes in pressure and tip sizes may be needed for proper spray characteristics.

Industrial airgun equipment such as *Binks Model 2001* (Conventional) or *Mach 1* (HVLP), or equal. Separate air & fluid pressure regulators, and moisture & oil trap in main air supply line, recommended. A mechanical pot agitator can be used. Adequate air pressure/volume will ensure proper atomization. Recommended fluid nozzle: .046" to .070" orifice (.055" & .064" most commonly used).

- 1.) Using a drill-mounted impeller, thoroughly mix clear **KrystalKote™ Curing Agent** into **KrystalKote™ Base Compound** until uniform, as outlined on *Base* label and **KrystalKote™ Data Sheet**. Do not mix by shaking. Up to 5% by weight (nearly 10% by volume) of Acetone or M.E.K. may be added as a thinning agent, if needed, to facilitate flow of **KrystalKote™** for spraying.
- 2.) Mix no more **KrystalKote™** than can be easily applied within @ 3-hours. Normal pot life is 3½- to 4-hours at 75°F. A cold weather "accelerator" is available to shorten cure time, but will also shorten pot life. A hot weather "retarder" is also available to lengthen pot life, but will also lengthen cure time. Additives and instructions are available from **TradeWinds International, Inc.**
- 3.) Clean equipment and airgun orifices with solvent before use.
- 4.) Apply **KrystalKote™** to @ 5-mil WFT in even parallel passes, overlapping @ 50% each pass, and cross spray at right angles, to avoid pinholes and thin areas (aka "holidays").

## **KrystalKote™ Gloss, clear or custom tint**

### Application to Commercial Vehicles

(continued)

- 5.) Check wet coating thickness with WFT Gauge until feel for proper WFT is achieved: 6-mil WFT will dry to @ 5-mil DFT; 5-mil WFT will dry to @ 4-mil DFT; and 4-mil WFT will dry to @ 3.5-mil DFT.
- 6.) Use caution when applying **KrystalKote™ clear** to avoid excessive WFT, which may cause clouding of clarity, due to trapped micro-bubbles. Two thin coats may be easier to apply than one heavy coat. A second coat should be applied when first coat is only "tack dry" (tacky, but not wet). If the first coat of **KrystalKote™** becomes "dry-to-touch", @ 24-hours must elapse before applying second coat of **KrystalKote™** to allow proper solvent release time from first coat. Color coat or primer coat adhesion may be adversely affected by applying second coat of **KrystalKote™** over dry-to-touch first coat of **KrystalKote™** within 24-hours. See CURE TABLE.
- 7.) **KrystalKote™ Gloss clear** can be spray-applied directly over rubber window mounts, rubber hoses, clear & tinted plastic lenses, decals, lettering, striping, reflective tapes & sheeting, etc.
- 8.) **KrystalKote™ Custom tint** applied over a primer coat can be applied in a single 5- to 6-mil WFT, or in multiple coats. **KrystalKote™ Custom tint** applied d-t-m should be applied in two coats. The first as an @ 3-mil WFT "fog" or "tack" coat, followed 30- to 45-minutes later by a normal 5- to 6-mil WFT top coat. Allow **KrystalKote™** to only "tack dry" before applying consecutive coats. If the first coat of **KrystalKote™** becomes "dry-to-touch", @ 24-hours must elapse before applying second coat of **KrystalKote™** to allow proper solvent release time from first coat. Color coat or primer coat adhesion may be adversely affected by applying second coat of **KrystalKote™** over dry-to-touch first coat of **KrystalKote™** within 24-hours.
- 9.) Immediately clean all spray equipment with Acetone, Lacquer Thinner, M.E.K., or similar solvent.
- 10.) Allow @ 8-hours dry time at 77°F before removing tape or handling **KrystalKote™**-ed surfaces.
- 11.) Standard, heated vehicle drying ovens can be used with normal settings for polyurethane.
- 12.) Allow at least 72-hours cure time at 77°F before attempting to apply adhesive-backed reflective tape or sheeting over **KrystalKote™**. To determine most efficient "tape delay" time, trial applications are recommended on **KrystalKote™** d-t-m or over primed test panels. Heat-cured **KrystalKote™** will result in shorter delay time before applying adhesive tapes, etc.

**KrystalKote™** is a registered trademark (pending) of:

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