

SERIES20TM **METAL PAINT**

S103

ZZ20-CL

Clear

Series 20 is an automotive quality, one-component acrylic lacquer developed specifically for industrial needs.



Features

- A durable, high gloss finish in a one-component acrylic laquer.

Advantages / Benefits

- Easy to apply
- High gloss
- Fast drying

Compatible Surfaces

- Any Series 20 topcoat

Associated Products / Required Products

- Xylene

Clear

Directions For Use

Surface Preparation:

Surfaces must be clean, free of moisture, mill scale, rust and loose paint. Scuff painted surface lightly before application.

Mix Ratios:

20% reduction with Xylene to final viscosity of 20 seconds #2 Zahn cup.

Reducers:

Xylene

Additives:

- 20/30-91 Gloss Modifier: Enables you to adjust the gloss level
- 5 parts of Series 20 paint to 1 part flattening paste: gloss = 15-20
- 15 parts of Series 20 paint to 1 part flattening paste: gloss = 30-35
- 20 parts of Series 20 paint to 1 part flattening paste: gloss = 40-45

Spray Setup:

Air Pressure

Conventional..... 55-60 psi at the gun

HVLP..... 10 psi at cap

Pot Pressure 15-18 psi

Gun Setup

Siphon Feed 1.3 mm 0.050 fluid tip

HVLP..... 1.3 mm 0.050 fluid tip

Pot Pressure 1.2 mm 0.046 fluid tip

Application:

- Stir before use.
- Apply when air, product and surface temperature air above 50° F and at least 5° above dew point.

Drying Times:

Air Dry

Tack free 10 minutes

Dry to handle..... 20 minutes

Force Dry 30 minutes at 140° to 170° F

Total Film Build:

1 mil dry film thickness

Directions For Use

Equipment:

- Conventional siphon cup
- Pressure tank
- HVLP

Equipment Cleaning:

Xylene or Lacquer Thinner

Technical Data:

VOC.....5.66 lbs. /gal
Solids.....25.4 ± 2 % by wt
Viscosity.....20 ± 3 seconds # 2 Zahn Cup
Density.....7.60 ± 0.2 lbs. /gal

Theoretical Coverage:

319 sq. ft./gal with 100% recovery @1 mil DFT

Typical Performance Characteristics:

Gloss @ 60°80+
Gloss retention.....Excellent after 18 months in Florida
Flexibility¼ mandrel bend
Impact resistance.....40 in. lbs. Direct / 10 in. lbs. Reverse
Water resistance.....Passes 48 hour full immersion with no adhesion loss

Important:

To prevent the possibility of condensation during the coating application the surface temperature should be a minimum 5° above the dew point. If the surface temperature is too high the solvents will volatilize within the film, causing tiny vapor blisters or pinholes that usually leads to an early coating failure. When the ambient temperature is too high, the coating may cure on the surface and inhibit full cure of the underlying material and this will also leads to the formation of blisters and pinholes. To prevent above problems the temperature range has been established. The additives should be used when their properties are required.

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Emergency Medical or Spill Control Information:

US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein. If you require technical assistance, please call us toll-free 800/323-6593.



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