



# Single Stage Polyurethane Color

## Product Numbers:

4200 Series (gallon)

A premium single stage paint that is easy to spray and will wet sand and buff very well the next day after spraying (only if necessary).

This single stage has very good chemical resistance and stone chip resistance.

## Mixing: 4:1

Mix 4 parts single stage to 1 part of the following activators.

2102-4 Medium (quart)

2103-4 Slow (quart)

2104-4 Very Slow (quart)

## Prepping:

Sand the surface with 320-800 grit wet or dry paper. Clean the vehicle with SPI 700-1 Waterborne Wax and Grease Remover or SPI 710-1 Solvent based Wax and Grease Remover then let the vehicle sit for 45 minutes before applying the single stage paint.

**Spraying:** Gun tip recommendation 1.3 – 1.5

With properly adjusted gun spray one wet coat. When finished check time and wait exactly 30 minutes before spraying second coat. Do the same for the third coat if needed.

The last coat of color can be integrated with any SPI pre-activated clear mixed with pre-activated single stage at any ratio, although the most common is 1:1.

This single stage can also be clear coated after sitting overnight with any SPI clear. If done within 24 hours simply tack it and shoot it.

## Dry Times:

With the slow activator the first coat will flash in 10-30 minutes depending on air and substrate temperature.

## Baking: Low Temperature Baking Single Stage

No Purge! Bake for 10-15 minutes at 110-120 degrees. This obviously depends on air temperature and activator used.

**Never bake this Single Stage over 120 degrees!**



## **Repairing:**

After 4 hours at 70 degrees or better you should be able to make repairs without any problems. If the Single Stage was baked, repairs should be made 60 minutes after the vehicle has cooled to room temperature.

## **Buffing:**

Next day wet sand, if possible, pull the vehicle out in the sun for about 4 hours, pull it inside and when the vehicle cools buff as usual. This will make buffing a little easier.

## **Spraying in Non-Baking Paint Booths:**

The booth fan **MUST** be shut off within one minute after the overspray is gone!

## **DO NOT spray this clear until all precautions have been read!**

1. Never add any fisheye eliminators to this Single Stage
2. We do not recommend ceramic coatings over any SPI product due to the extensive range of available products and lack of long-term testing.
3. Bake at temperature and cycles **not higher** than 120 degrees for 10 minutes or 110 degrees for 15 minutes. **No purge time is needed** before bake cycles.
4. If allowing to air dry the **fan must be shut** off within one minute after the overspray has been evacuated from the last coat of Single Stage.
5. The mixed **pot life** will be about 2-3 hours depending on the temperature in the shop.
6. Use only a pure carnauba wax or a fresh paint safe hand glaze. Only after 90 days of sunlight can a traditional wax be used.
7. If more than 2 coats are to be applied, **wait 30 minutes** between every coat of Single Stage.