

UNO HD Color National Rule

Application on Flexible Parts



Products	UNO HD Color	
	DF21 Flex Agent DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener 868 1K Plastic Primer	870 High Solids Adhesion Promoter for Plastics UR Series Reducer SM09 Flattener - Special MAT09 SC01 Base Booster SC10 Mixing Clear
Cleaning	See Flexible Parts section "Cleaning & Preparing Vehicle Surface for Undercoating".	
Pretreatments	See Flexible Parts section "868 1K Plastic Primer" or "870 High Solids Adhesion Promoter for Plastics".	
Mixing Ratio	Step 1 - 10:1 or 4:1	Step 2 - 4:1:1
	* For high gloss, flexible parts 10 parts UNO HD Color 1 part DF21 * For high gloss, soft flexible parts 4 parts UNO HD Color 1 part DF21 For lower gloss applications, see Notes below for the amount of SM09 to use. Mix color with SC01 and SC10 as per mixing formula.	4 parts UNO HD/DF21 mixture 1 part DH42, DH44, DH46 or DH47 1 part UR Reducer
Application	Apply 1 medium wet coat 5 to 10 minutes flash between coats Apply a 2nd medium wet coat	
Drying	20°C/68°F 2 to 3 hours 60°C/140°F 30 minutes 70°C/160°F 25 minutes	
Sanding/ Polishing	Wet Sand - N/A Dry Sand - N/A	
Notes	Step 1:	
	Hard Flexible Parts	
	Full Gloss	
	Semi	
	Satin	
	Flat	
	Soft Flexible Parts	
	Full Gloss	
	Semi	
	Satin	
	Flat	
	Step 2: See Above (4:1:1)	

UNO HD Color	DF21	SM09
10	1	-
8	1	2
7	1	3
6	1	4
20	5	-
16	5	4
12	5	8
10	5	10



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on Flexible Parts Technical Data

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Characteristics

R-M UNO HD is a high solids Single Stage, two component, topcoat system. This formulation is based on a unique acrylic/polyurethane technology that offers high solids and high performance. DF21 Flex Agent is designed to give partial or full flexibility to UNO HD Colors without changing durability, gloss or overall quality.

Technical Data

Viscosity	20-23 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.5-1.6 mm
Fluid Tip (HVLP gravity)	1.5-1.6 mm
Air Pressure (HVLP/HE)	8-10 psi at air cap
Number of Coats	2 wet coats
Thickness	2.5-3.0 mils
Pot Life	3 hours @ 22°C/72°F
Coverage	Varies based on color
VOC as Applied	500-535 gms/ltr (4.1-4.5 lbs/gal) (varies based on color and gloss)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do use R-M 812 Fisheye Eliminator if necessary, add 1/4 to 1/2 cap full per quart or gun cup.
- Do use UNO HD color mixture within 3 hours for best results.
- Do measure amount of hardener and reducer - DO NOT ESTIMATE.
- Do use JET95 0.5 to 1% with DH46 or DH47 if **necessary**.
- Do shake new tinting bases for 15 minutes on a mechanical paint shaker before placing on a mixing machine.
- Do agitate tinting bases on a mixing machine at the start of the work day for 15 minutes and every 4 hours throughout the day to ensure good color matching.

Things NOT to DO:

- Do not attempt to recoat, sand or compound until the final coat has dried a minimum of 24 hours.
- Do not use if the shop temperature is below 15°C/60°F.
- Do not use any hardeners other than DH42, DH44, DH46 or DH47 or reducers other than UR Series.
- Do not use Jet95 when using DH42.
- Do not use HD17 or HD18 in this presentation.
- Do not use UNO HD wet-on-wet over EP569, EP669, EP769 or EP869.