PolyCLAD 2500

Aliphatic Acrylic Polyurethane

Designed for trailer, fleet and refinish markets when high clarity and a fine finish is required. PolyClad has similar features to international automotive grade finishes. It dries to an extremely durable yet flexible rust preventative super-high gloss finish and provides optimum resistance to chemical exposure and harsh environments.

**Recommended For**
- Refinish Market
- Trailer and Fleet Equipment Manufacturers

**Features**
- Long Pot Life/Short Dry Time
- Excellent Color and Gloss Retention
- Outstanding Flow and Leveling
- Two Component Package
- VOC Compliant
- Anti-Graffiti Properties

**Application:**
- Air-assisted airless, HVLP, or conventional spray.

**Average Dry Time:**
- Dust Free: 1 ½ hours (at 77°F / 25°C).

**Resistance To:**
- **Dry Heat - to 150°F** - Excellent color permanence for green, bright red, maroon, yellow and white.
- Weather - Excellent
- Oil Spills - Excellent
- Moisture - Excellent
- Abrasion - Excellent
- Solvent - Excellent
- Petroleum - Excellent
- Chemical Fumes - Very good in sulfide resistant colors.

**Theoretical Coverage at 1 mil:**
- 855 sq. ft. per gallon, depending on color. The actual coverage will be less, depending on application technique, job conditions, and type of surface to be coated.

**Thinning:**
- No thinning required for most spray applications. If thinning is necessary, consult Technical Bulletin.

**Finish:**
- Super High Gloss

**% Solids by Volume:**
- Average of 53%, depending on color

**% Solids by Weight:**
- Average of 64%, depending on color

**Pigment Type:**
- Chemical Resistant

**Solvent Type:**
- Ketones and Acetates

**Vehicle Type:**
- Acrylic Polyurethane

**Viscosity at 77°F (25°C):**
- 58-62 seconds in Zahn 2

**Physical Properties:**
- **VOC Actual:** 316 g/l • **VOC Regulatory:** 339 g/l • **Weight of Volatiles:** 31.2% • **Weight of Exempt:** 4.5% • **Volume of Exempt:** 6.7% • **Density:** 1,185 g/l

**Caution:**
- Recommended application up to 2.0 mils dry film thickness per coat. Heavy applications exceeding this thickness may result in slow dry.
Type
Aliphatic Acrylic Polyurethane

Intended Use
A premium topcoat for any adequately prepared substrate such as steel, aluminum, galvanized, fiberglass, and concrete.

FOR INDUSTRIAL USE ONLY

Chemical Resistance
Resistance to dry heat up to 150°F. Excellent resistance to weather, moisture, oil spills, abrasion, and petroleum. Very good resistance to solvents. Good chemical fumes resistance.

Surface Preparation
Dependent on coating use. Refer to SURFACE PREPARATION Section.

Application
Apply by air assisted airless, HVLP, or conventional spray.

Colors
Standard shop colors. Custom matches available upon request.

Recommended Film Thickness
Up to 2.0 mils DFT per coat.

FILM THICKNESS PER COAT

Spray
Recommended 2-3 mils DFT per coat

Brush or Roller
Recommended 3 to 4 mils DFT per coat

Theoretical Coverage at 1 mil
855 sq. ft. per gallon, depending on color. The actual coverage will be less, depending on application technique, job conditions, and type of surface to be coated.

Tack Free Time at 77°F (25°C)
¾ to 1 ½ hours

Drying Time
(foot traffic acceptable)
12 hours at 77°F

Curing Time at 77°F (25°C)
7 days. Dry time may be shortened with the addition of accelerators.

OVERCOATING TIME

Minimum
8 hours at 77°F

Maximum
De-gloss and recoat.

PHYSICAL SPECIFICATIONS

Pigments
Chemical resistant

Shipping Weight
(approximate due to color, fill level, pigment)
2500 PolyClad:
Gallon - 9.2 lbs

2500 PolyClad Catalyst:
(approximate)
1 pint - 1.4 lbs
Gallon - 6.8 lbs

Solids
Average 53% by volume, depending on color
Average 64% by weight, depending on color

Thermal Shock
N/A

Pot Life (at 77°F)
Mixed: 8-12 hours
Consult manufacturer when using in high humidity (above 85%).
Mixing Ratio
7 parts color base : 1 part catalyst

Shelf Life
12 months at 77°F without catalyst

Gloss
Super High Gloss

AREA OF USAGE
As a super high gloss premium topcoat; recommended for refinsh market, trailer and fleet, and OEM equipment.

CHEMICAL RESISTANCE
• Water • Salt • Acids • Alkali • Solvents •

NOTE: Although 2500 SERIES exhibits resistance to the above environments, this list is not meant to imply an express guarantee in actual service. It is recommended that the user contact Ponderosa Paint Company for specific recommendations when severe exposure is expected.

THINNING
No thinning is required for most spray applications. If necessary, thin 10 to 15% by volume with Envirosol. Envirosol is a zero VOC reducer. Envirosol T-601 slow, T-602 medium, T-603 fast. (Note: always thin after adding hardener or retarder.)

Density
Envirosol T-601 slow 9.5 lb/gal
T-602 medium 8.3 lb/gal
T-603 fast 7.3 lb/gal

Spray Application
No thinning required for most spray applications. If necessary, thin 10% with Envirosol.

Brush or Roller Application
Not applicable

SURFACE PREPARATION

Steel
Clean the surface thoroughly to remove oil, grease, wax, dirt, etc. Use a solvent cleaner. All rust must be removed prior to chemical wash. A commercial metal conditioner is necessary. Treat aluminum with a commercial etching solution to remove all traces of dirt, grease, foreign matter and for best results, treat aluminum with a chromate conversion coating.

Concrete
Must be primed, depending on surface use and condition. Contact Ponderosa Paint Company for specific recommendations.

EQUIPMENT

Spray Application
1. All spray equipment should be thoroughly cleaned and the hose, in particular, should be free of old paint film and other contaminants, including water.

2. Air Pressure:
   - HVLP 5-10 psi at the air cap
   - Conventional 45-55 psi at the gun
   - Air-Assisted HVLP 80 psi at the gun

   Gun Setup: 1.1-1.4 mm or equivalent

3. When air-assisted airless spray equipment is used, the recommended liquid pressure is 1800 to 3300 psi with a tip size from .09” to .015”.

   Roller Application
   Not applicable.

   Brush Application
   Natural bristle brush (for field repair).

READ THIS NOTICE
SAFETY AND MISCELLANEOUS EQUIPMENT

1. It is recommended that the operator provide himself with clean coveralls and rubber soled shoes and observes good personal hygiene. Certain personnel may be sensitive to various types of resins, which may cause dermatitis or severe allergic reactions.
2. WHEN ADDED, THE THINNER USED FOR THIS COATING IS FLAMMABLE. CARE, AS DEMANDED BY GOOD PRACTICE, OSHA, STATE AND LOCAL SAFETY CODES, ETC., MUST BE TAKEN. Keep away from heat, sparks and open flame, and use necessary safety equipment (such as air mask, explosion-proof electrical equipment, non-sparking tools and ladders, etc.) Avoid contact with skin and avoid breathing of vapor or spray mist. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of the reach of children.

3. CAUTION: Read and follow all caution statements on this product technical bulletin, material safety data sheet and container label for this product.

4. Read Material Data Safety Sheet (MSDS) before use.

MIXING

2500 Series Urethane Enamel comes in a two component package. The coating and the curing agent, 2500 Catalyst, are mixed at a 7:1 ratio (7/8 gallon: 1 pint). If thinning use seven parts (by volume) of 2500 Color Base, one part (by volume) of 2500 Catalyst, and mix with one part Envirosol (by volume). Thoroughly mix.

NOTE: Always thin after adding hardener or additives. *The addition of solvent may result in a non-compliant ready to spray VOC. Verify with local regulations prior to use.

APPLICATION PROCEDURE

1. Surface should be dry and clean, free of dirt, grease, old loose scaling paint and anything that might interfere with adhesion. Prime bare metal. For surfaces that are pitted or scratched, a primer is recommended in order to achieve a smooth more uniform appearance.

2. HVLP air atomizing spray equipment is recommended for application. A fluid pressure of 3-15 psi and atomizing gauge pressure of 45-65 psi are recommended.

3. When the part is completely coated and no more parts are to be finished, clean up all equipment. This material has a 8-12 hour pot life after mixing. Any unused paint and all mixing and application equipment must be flushed and cleaned within 15 minutes after mixing or use.

4. Refer to appropriate Material Safety Data Sheets and applicable local, state and federal laws for handling and disposal questions.

INSPECTION

Degree of surface preparation and film thickness shall conform to appropriate specifications outlined in SURFACE PREPARATION and RECOMMENDED FILM THICKNESS sections.

Ponderosa Paint Company warrants its products to be free of defects in materials and workmanship. Since Ponderosa Paint Company has no control over surface preparation or application methods, no guarantee concerning results is offered, expressed, or implied. If this product is found to be defective, liability shall be limited to the refund of purchase price or replacement of product.

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