



# BUMPER PAINT

Technical Data Sheet No 605

Fast drying 1K paint

Excellent coverage

Great durability

VOC compliant with the regulations

## General Technical Description



Mix 4 parts BUMPER PAINT with 1 part 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



10 min / 60°C (140°F)  
1h / 23°C (73°F)



3-5 min

## Surface

Plastic parts of the car

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried.



Make sure you always use appropriate face protection and good ventilation

**Product Application:** Fast drying 1K paint for restoring OEM look of plastic bumpers and plastic parts 2 coats . Apply in thin layers. One coat and after 5-10 min flash off time apply the second coat.



20-25 % 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



Flash off time  
5 - 10 min / 23°C (73°F)

**Flash Point:**  
26°C / 79°F

**Specific Gravity:**  
0.9 - 1.1 g/cm<sup>3</sup>

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended thinners / reducers
- It can also be used by countries that do not adopt the VOC legislation
- Do not use at temperatures below 15°C (50°F)
- Do not apply the primer as 'wet on wet' on TPA surfaces.



Ready to spray:  
20-25 s  
DIN 4 @ 20°C (68°F)



1h / 23°C (73°F)  
10 min / 60°C (140°F)  
panel temperature

**Solid Content (No thinner):**  
22% Weight

### VOC (2004/42/EC)

This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 780 g/L.  
2004/42/IIB(e)(840)780

### Storage shelf life:

- Store in a cool place +5°C - +25°C (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.



Compliant Spray gun  
1.5 - 1.8 mm  
2-3 bar (29 - 44 psi)  
inlet pressure  
2 coats = 35-40µm  
(1.4 - 1.6 mil)



Short wave 3-5 min



Always wear protective equipment

### Theoretical Coverage:

8 - 10 m<sup>2</sup> / l at 15 micron (0.6 mil) dry film thickness

### Cleaning of equipment:

Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER



HVLP 1.5 mm  
2 bar (29 psi)  
inlet pressure  
2 coats = 35-40µm  
(1.4 - 1.6 mil)



Follow the application instructions mentioned in this TDS

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