

ULTRA-LOCK

Metallic Control Additive / Basecoat Converter

TECHNICAL DATA SHEET

ULTRA-LOCK is a combination Effect Additive / Basecoat Converter designed for use with Kirker's ULTRA-GLO urethane color system. UA-2400 significantly improves sprayability and ease-of-use while converting Kirker's single-stage urethanes into a fast-drying, low-gloss basecoat-like finish. Anti-Mottle Technology stabilizes metallics and pearls, locking them in place for an even, streak-free finish. When used together, ULTRA-GLO and ULTRA-LOCK combine the same ease-of-use benefits of traditional basecoats with the superior adhesion, durability and other performance properties of today's most advanced urethane topcoats.

This additive may also be used with Kirker's Diamond Pearl series colors, Urethane Candy Base series colors and the SPECTRA Series Urethane Candy Color system.

COATING TYPE:

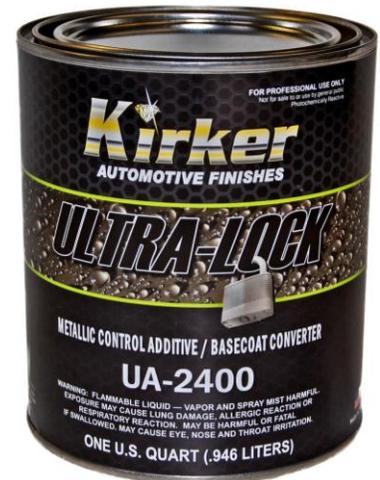
Urethane Additive

PRODUCT CODE:

UA-2400

PHYSICALS:

| | |
|--------------------|---|
| Appearance: | Colorless (cloudy) liquid |
| Weight per gallon: | 7.95 lbs |
| Package measure: | 1 U.S. quart (32 fl. oz.) |
| Packaged VOC: | 3.6 lbs/gallon / 431 grams/liter National Rule Compliant |

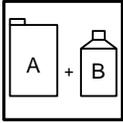


SURFACE PREP:

Whether using ULTRA-GLO urethane colors with the ULTRA-LOCK additive or not, a clean and well-prepped surface is critical before starting. Remove all traces of wax, grease, silicone, oil and other contaminants with a detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover).

Abrade substrate with 600-800 grit to ensure sufficient adhesion. Re-clean with a final wash cleaner (such as Kirker's 600 Surface Wash).

Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Be sure to thoroughly shake and/or stir contents of ULTRA-LOCK before opening, as the contents in the can may settle over time due to the high density of these materials.

ULTRA-LOCK is designed to be mixed into Kirker's ULTRA-GLO urethane colors at a 3:1:1 ratio by volume. For every three (3) parts of SSU color, mix one (1) part of the appropriate Activator (UA-1600M, UA-1600S), depending on air flow and temperature, and one (1) part UA-2400 ULTRA-LOCK.

| Temperature range | Less than 80° F | More than 80° F |
|-------------------|-------------------|-----------------|
| Activator | UA-1600M (Medium) | UA-1600S (Slow) |

No additional reduction is required. If necessary, use one of Kirker's urethane-grade reducers (chosed from the list below depending on the anticipated shop temperature at the time of application), or Universal Zero-V.O.C. Reducer (UE-8000). **WARNING:** With further reduction beyond the recommended 3:1:1 mix ratio, ULTRA-GLO may no longer be VOC compliant for your area.

| Temperature range | Less than 70° F | 70° F - 80° F | 80° F – 90°F | Above 90°F |
|-------------------|-----------------|---------------|---------------|---------------|
| Reducer (Gallon) | UR-9065 (Gal) | UR-9075 (Gal) | UR-9085 (Gal) | UR-9095 (Gal) |
| Reducer (Quart) | UR-8065 (Qt) | UR-8075 (Qt) | UR-8085 (Qt) | UR-8095 (Qt) |
| Speed | FAST | MEDIUM | SLOW | SUPER SLOW |

If necessary, Kirker's UFE8 Universal Fish Eye Eliminator may be added to the mix (1/2 ounce per ready-to-spray quart of ULTRA-GLO SSU).

Caution: Mix only as much material as you will need to complete the immediate job.

3:1:1

| | | | | |
|----------------------|--------------|--------------|--------------|--------------|
| UA SSU Color | 6 oz | 12 oz. | 15 oz. | 18 oz. |
| UA-1600 Activator | 2 oz. | 4 oz. | 5 oz. | 6 oz. |
| UA-2400 Additive | 2 oz | 4 oz | 5 oz | 6 oz |
| TOTAL MIXTURE | 10 oz | 20 oz | 25 oz | 30 oz |

SPECTRA Series Urethane Candy Colors

When mixing ULTRA-LOCK into SPECTRA Series Urethane Candy Color system, the mix ratio will be 4:1:1 by volume, or for every four (4) parts SPECTRA Series candy, mix one (1) part 0175 Activator * and one (1) part UA-2400 ULTRA-LOCK. No additional reduction is required.

**Clear activators 0065, 0075 and 0085 may be used in place of the 0175 in the SPECTRA Series Urethane Candy colors, depending on air flow and temperature at the time of application.*



POT LIFE:

Approximately 2 hours at 70°F.

CAUTION: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GENERAL GUN SETTINGS:

| GUN TYPE | TIP SIZE | AIR PRESSURE |
|----------------------------|-----------------|----------------------|
| Conventional Siphon Feed: | 1.2 mm – 1.6mm | 40-50 psi at the gun |
| Conventional Gravity Feed: | 1.2 mm – 1.5 mm | 40-50 psi at the gun |
| HVLP | 1.2 mm – 1.4 mm | 8-10 psi at the cap |

These are general gun setting recommendations. Always refer to gun manufacturer's recommendations for more specific and additional details on suggested tip size, air pressure and other adjustments.



APPLICATION:

After integrating the ULTRA-LOCK Metallic Control Additive / Basecoat Converter, ULTRA-GLO urethane colors and SPECTRA Series urethane candies will no longer be suitable for use in single-stage applications. That is, the color must be applied as a basecoat and requires the use of a urethane clear coat for durability.

Apply the converted paint in medium wet coats as necessary to achieve the desired coverage, allowing five (5) to ten (10) minutes flash time between coats (+/- depending on air flow and temperature). Typically, most colors will cover in two (2) to three (3) medium wet coats; however an additional coat may be required when using UA-2400, which dilutes the pigment concentration in the mix to some extent.

ULTRA-LOCK's Anti-Mottle Technology stabilizes metallic and pearl effect pigments, locking them in place for an even, streak-free finish. If urethane colors still don't lay out in a uniform pattern, a final drop coat may be applied immediately after the previous wet coat for further improved uniformity. A dry film thickness of 2 mils is recommended.

For more specific information about shooting Kirker's ULTRA-GLO colors (metallic, pearl or solid), Diamond Pearl Colors (DP Series), Urethane Candy Base Colors (UCB Series) or SPECTRA Series Urethane Candy Colors, please refer to the appropriate Technical Data Sheet.



DRY TIMES: AIR DRY

| | |
|-------------|---------------|
| Dust free: | 10-15 minutes |
| Tack free: | 20-40 minutes |
| Clear coat: | 30-40 minutes |
| Tape: | 4-6 hours |
| Full cure: | 18 hours |

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F.



CLEANUP:

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of UA-1600M and UA-1600S Activator is limited once cans have been opened. These products are extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly after each use, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of potentially damaging condensation inside of the can.



RECOAT / CLEARCOAT:

Converted ULTRA-GLO basecoat or SPECTRA Series Urethane Candy Colors may be recoated for up to 18 hours (at 70° - 75°F). After 18 hours, surface must first be abraded with 600-800 grit to promote sufficient adhesion before recoating.

Keep in mind, once ULTRA-LOCK is integrated into the system, the urethane topcoat may no longer be suitable for use in a single-stage application and requires a separate urethane clear coat for exterior durability.

Use any of Kirker's urethane clears, including **ULTRA** (EC300) 4:1:1 High-Solids Clear; **EUROTHANE** (EC200) 2:1 Euro-style High-Solids Clear; **CUSTOM** (UCC500) 4:1 High-solids Clear, **PRO-FLO** (EC100) 4:1 Medium-Solids Clear or **ZOOM** (V2010) 4:1 High Speed Clear.



HEALTH / SAFETY PRECAUTIONS:

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. **READ ALL WARNINGS ON ALL LABELS BEFORE USING.**

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. It is the responsibility of the purchaser to determine the suitability of this product for its intended use. Since the methods of use, conditions of application, and the application itself are beyond manufacturer's and sellers' control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

FOR ADDITIONAL INFORMATION:



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