



TDS Sheets

Duraflint I Single Stage

Duraflint I Single Stage Series is a 3:1 Polyurethane

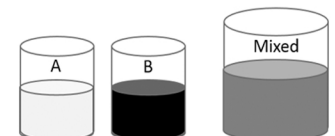
Duraflint I Singlestage is sold as a Kit. You will also get 1 Quart of hardener with your purchase rendering a gallon worth of product. AKA a short filled gallon



Component

Volume

Duraflint I	Single Stage	3
HH-7603/7605/7607	Activator	1
HR-1360/1370/1380/1390	Reducer	As needed up to 5%



USE ONLY TAMCO REDUCERS. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears. 45% solid content RTS

H-7603-Fast
60-75°F / Large areas 65-70°F

HH-7605- Standard
75-80°F / Large areas 70-80°F

HH-7607- Slow
85-100°F / Large areas 80-90°F

HH7607 will be 87-100°F you may need to add 5% HR900 retarder in hot humid conditions

Gun Setups

See manufacturers suggestions

Common User Suggestions

Iwata Supernova: 1.3 or 1.4, fluid open, trigger pull full, 1 turn in on fan, 26 psi

Iwata WS400 evo: 1.3hd fluid open, trigger pull full, 1 turn in on fan, 30 psi

Iwata LPH 400: 1.3 or 1.4 fluid open, trigger pull full, 1 turn in on fan, 20 psi (this is an hvlp gun recommended by the manufacturer to be no higher than 19 psi but the extra pressure helps atomize the clear for a smoother finish)

Sata RP 4000/5000: 1.3 or 1.4 fluid open, trigger pull full, fan open, 28-30 psi

Sata 4000/5000 hvlp: 1.3 or 1.4 fluid open, trigger pull full, fan open, 29-32 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE10 fluid open, trigger pull full 28 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE20 24-26 psi





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Application

See manufacturers suggestions

Common User Suggestions

After basecoat has dried for 30 minutes apply 1 medium/wet coat and allow to flash for 15-20 minutes before applying next coat. We recommend no longer than 1 hour application time between base and clear for maximum adhesion. Apply only 3 coats of clear for each session. Shop conditions temperature and air flow will determine flash times. The “string” test method can be used to determine proper flash time for your conditions. Monitor an area by lightly touching. If the clear is still wet or stringing do not apply additional coats. Wait until finish becomes sticky but doesn’t string. Do not apply .more clear after 1 hour of dry time



Dry Times

Air Dry at 70° 12 hours

Force Dry at 140°= Allow to flash for 20-30 min then bake 30 minutes and allow a 30 minute cooldown

Finish Sanding

After the clear has cured for at least 12 hours dry or wet sanding is acceptable. Adding a small amount of dish soap to the water and soaking the paper will provide best results. If sanding with a DA sander we recommend denibbing first and taking it slow as “pigtailed” can .be introduced and become difficult to remove in the polishing process



Recoat

If you choose to apply additional coats of clear after sanding you can add 5% reducer and apply 1 medium coat followed by 2 more medium wet coats with 20-30 minute flash .between. As above shop conditions will vary flash times so “string” test is recommended

Polishing

Allow clear to dry for at least 12 hours before polishing

We recommend going all the way up to 3000 grit for best results and ease of polishing. Follow recommended procedures from the manufacturer of the products you are using. For show car polishing we recommend allowing the car to sit for a few days to outgas before finishsanding and polishing. After finish sanding allow the car to sit in the sun for a day before buffing. This allows more solvents to evaporate and the surface to be easier to polish and won’t show sand scratches