

22-Line

Urethane Acrylic - 340 g/L (2.8 lbs/gal) VOC - Flexible with 522-333 (2:1 Pre-Mix)



A brand of BASF –
We create chemistry


Application:




22-Line color is an acrylic urethane enamel to be applied as a single stage finish over well cured old paintwork and primers. 22-Line colors, when mixed with the appropriate hardener, reducer and Low VOC mixing clear, meet the 340 gms/liter (2.8 lbs/gal) VOC system requirement. This document outlines the use of 22-Line for flexible applications.

Remarks:

- Choose hardener and reducer according to temperature and size of object to be painted.
- New tinting bases must be shaken for 15 minutes on a mechanical paint shaker before placing on a mixing machine. To ensure good color match, agitate tinting bases on a mixing machine for 15 minutes at the beginning of the day, and every 4 hours during the work day.
- Tinting bases should not be used straight, they must be mixed with 522-M0 (**4:1 by volume**) before use.
- To polish or remove dust particles: after 24 hrs. air dry, or when cool after force drying, wet sand with 1200 grit or finer sandpaper, then polish with fine polishing compound and/or liquid polish. Two mils (dry film) of color must remain after polishing. If extensive color sanding is anticipated, apply an additional coat of color.

VOC ready for use	340 g/l	2.8 lb/gal
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	Mixing Ratio Pre-Mix	100 parts by volume 22-Line
		50 parts by volume 522-333

		2:1+10 %	
	Mixing Ratio	100 parts by volume	Pre-Mix
	Hardener	50 parts by volume	929-100, -105, -115, -120, -130
	Reducer	10 parts by volume	352-25, -45
	Potlife at 68°F / 20°C	1.5 h	

Safety advice:



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Nozzle pressure		10 psi
Nozzle size		1.3 mm
Number of spraycoats	2	
Flash-off at 68°F / 20°C	5 min between coats	
Film thickness	2.2-3 mil	

	Drying at 68°F / 20°C	8 h tack free
	Drying at 140°F / 60°C	30 min
	Infrared (short wave)	7 min
	Infrared (medium wave)	10 min

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document

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