



## Technical Data Sheet

Date of issue	Revision Date	Version
11/04/14	24/06/19	1.2
Product Code	Product Name	
<b>G1_ _-</b>	<b>2K Gloss</b>	

**2K Gloss** is an easy to use high solid 2K top coat that is available in both white and black. It provides excellent coverage with a high gloss finish.

*Always check that you have the latest TDS*



### SURFACE PREP

Surface must be chemically clean & dry.



### MIXING RATIO

2: Parts 2K Gloss  
1: Part FX Hardener  
10~20% FX Reducer



### NUMBER OF COATS

2-3 medium wet coats



### CONVENTIONAL - GUN SET UP

1.2~1.4 Fluid tip  
15~25 cm Spray distance  
20~45 psi Air pressure  
15~25 cm Fan size



### HVLP - GUN SET UP

1.2~1.4 Fluid tip  
10~15 cm Spray distance  
10~15psi at the cap  
15~25 cm Fan size



### FLASH TIME @ 25°C

10~15 min between coats  
15 min before baking



### CURE TIMES @ 25°C

Dust Free: 30 min\*  
Baking: 40~50min\* @ 60°C  
\*Medium Hardener



### THEORETICAL COVERAGE

6~9 m<sup>2</sup> per litre



### POT LIFE

1.5 Hour  
\*Medium Hardener



### SPRAYING VISCOSITY

Ford 4 Cup: 20~25 sec



### SAFETY

Always wear appropriate safety clothing, gloves, & breathing apparatus



### MSDS

Observe all safety precautions in relation to this products Material Safety Data Sheet



### CLEAN UP

Clean equipment with Gun Wash, Reducer or Thinners

### STORAGE

1 Year in cool, dry conditions

### QUICK APPLICATION GUIDE:

1. Prepare your surface.
2. 2-3 medium wet coats or until desired coverage has been achieved.
3. Allow to flash off properly between coats.
4. Bake 40~50min\* @ 60°C.
5. Lightly polish if required.

### MIXING



Mix Ratio: 2:1 + 10 to 20% reducer  
2: Parts 2K Gloss  
1: Part FX Hardener\*  
10~20% FX Reducer  
*\*Hardener should be added first and mixed thoroughly before adding the Reducer.*

### DETAILED APPLICATION GUIDE:

#### CLEANING



Thoroughly clean the surface using DNA® Wax & Grease Remover followed by DNA® Prep Clean X and dry thoroughly.

#### SUBSTRATE



Suitably prepared surface that is clean, chemically dry & correctly prepared.

#### PREPARATION



If applying over an existing 2K clear coat, sand using P500-800 wet or dry. Clean with DNA® Prep Clean 'X' & wipe dry.

#### SPRAYING



Strain mixed 2K Gloss into paint gun. Allowing for flash time between each coat apply 2-3 medium wet coats or until desired coverage has been achieved.

Spray with a 50% spray overlap.

*Flash time varies with temperature, FX Hardener and FX Reducer being used.*

#### FLASH OFF@ 25°C



Time between coats  
10~15 min (Fast Reducer)  
10~15 min (Medium Reducer)  
15~20 min (Slow Reducer)  
20~30 min (High Flow Reducer)

**CURING TIMES****Dust Free @ 25°C**

25 min (Fast Hardener)  
 30 min (Medium Hardener)  
 60 min (Slow Hardener)

**Baking @ 60°C**

20~30 min (Fast Hardener)  
 40~50 min (Medium Hardener)  
 60 min (Slow Hardener)

**Air Dry Touch @ 25°C**

2 hr (Fast Hardener)

**POT LIFE @ 25°C**

1 hr (Fast Hardener)  
 1.5 hr (Medium Hardener)  
 2 hr (Slow Hardener)

**REDUCERS & HARDENERS GUIDE**

These all have special properties that allow the most versatility in the hands of the professional painter in order to achieve the best results under varying conditions. For further details, refer to the DNA® Reducer and DNA® Hardener TDSs, Technical Data Sheets.

**'FX' Reducer™ Fast, RFXF****'FX' Hardener™ Fast, HFXF**

Application temperature range (10 to 15°C)

Used where you wish to speed up the drying time. Ideal for spot repairs or spraying in cooler temperatures.

**'FX' Reducer™ Medium, RFXM****'FX' Hardener™ Medium, HFXM**

Application temperature range (15 to 30°C)

Used where a normal drying time is required. Ideal for general repairs, clear coating and spraying in normal temperatures.

**'FX' Reducer™ Slow, RFXS,****'FX' Hardener™ Slow, HFXS**

Application temperature range (25 to >30°C)

Used where you wish to slow down the drying time. Ideal for resprays or spraying in hotter temperatures.

**'FX' Reducer™ High Flow, RFXHF**

Application temperature range (25 to >35°C)

Used where the slowest drying times are required or when spraying in the hottest temperatures.

High Flow promotes premium leveling that is often required when flow coating\*\* to get a glass like finish off the gun.

**Important Information:**

- Always check you have the latest Technical Data Sheet
- Always buy enough product to complete the entire job
- Products are for Professional Use Only

**Warranty:****DNA will replace any faulty or defective goods.**

You must always spray out a test panel and fully test prior to commencing any job to determine suitability, final finish and overall appearance. Goods are guaranteed for 12 months if stored in cool dry conditions. All information and data provided is given in good faith and intended as a general guide only for use by qualified professional painters and DNA will not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of preparation, use of incompatible materials, equipment failure, use of incorrect equipment or any other reason beyond the control of DNA and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. DNA paints reserves the right to make changes to formulations and on rare occasions batches may have slight variations such as colour or tone, these are not covered by warranty.

If any goods are defective, you must not proceed to the job. Stop work immediately and contact your distributor or DNA Paints and point out the defect.

Any faulty goods must be returned at the customers expense to the distributor or DNA paints with a copy of the original invoice or other proof of purchase to obtain a replacement of the faulty product or a refund for the cost of the goods. The benefits provided to the consumer by the warranty are in addition to other rights and remedies available to the consumer under the law.

DNA paints

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