InnoColor

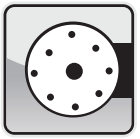
TECHNICAL DATA SHEET

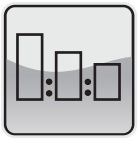
Automotive Refinish Expert

InnoColor

PICTOGRAPH

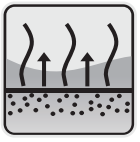

Cleaning

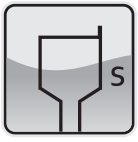

Dry Sanding by Machine


Mixing Ratio


Use Dipstick


NO.of Coats


Flash-Off Time

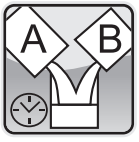


Application Viscosity


Gravity Feed Spray Gun


Suction Feed Spray Gun

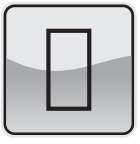

Re-Coat



Pot Life


Wet Sanding by Hand


Drying Time


Ready for Use

Topcoat

Single - Stage Solid Topcoat

Product Description

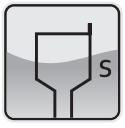
Double component solid colors for repairing automotive finishes.

Technical Characteristics

Color: mixing system Shelf life: 48 months at 25°C/77°F Theoretical spreading rate: 260 m²/l (avg) at 1 µm

Pre-treatment

Wet flat with P600 - 800 grade paper or dry flat with P400 - 500 grade paper.
Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re-clean with IC - 800 The use of a tack rag is recommended.

 **Mixing Ratio**	Stir well before use. Twice per day for 15 min on the mixing machine. **IC - 2K Solid Colors** 100 (vol) depending on color **IC - 9788 Hardener** 50 (vol) **IC - 950 Thinner** 20 - 30 (vol) Mix well and strain before application. Note: IC - 9688/IC - 940 is for temperatures beneath 15°C IC - 9788/IC - 950 is for temperatures between 15°C - 25°C/77°F IC - 9888/IC - 960 is for temperatures above 25°C/77°F IC - 970 Thinner is for temperatures above 35°C or when refinishing large surfaces.
 **Spray Viscosity Potlife**	14 to 19 seconds DIN 4 cup at 25°C/77°F 3 - 4 hours at 25°C/77°F
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.8 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	**Apply topcoat over original stoved finishes or over IC - 981/IC - 972 grey primers.** Number of spraycoats: 1 half wet + 1 wet coat Flash - off: 10 mins Film thickness: 40 - 50 µm
 **Drying**	Drying 25°C/77°F 60°C/140°F Dust free after 20 mins 5 mins Ready for assembly after 6 hours 30 mins Ready for polish after 24 hours 75 - 110 mins
 **IR Drying**	IR drying after flash - off time: Step 1 - short wave: 5 mins at a 80 cm distance Step 2 - medium wave: 20 mins at a 80 cm distance
Further Treatment	Polish after specified drying times and cooling.

Basecoat 2c

2 - Stage Solid Colors

Product Description

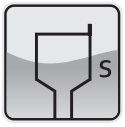
Single component solid colors for repairing automotive 2 - stage finishes.

Technical Characteristics

Color: mixing system Shelf life: 48 months at 25°C/77°F Theoretical spreading rate: 120m² /l (avg) at 1 µm

Pre-treatment

Wet flat with P800 - 1000 grade paper or dry flat with P600 - 800 grade paper.
Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800 The use of a tack rag is recommended.

 **Mixing Ratio**	Stir well before use. Twice per day for 15 mins on the mixing machine. **IC - 1K Solid Colors** 100 (vol) depending on color **IC - 940 (5°C - 15°C)** **IC - 950 (15°C - 25°C/77°F)** **IC - 960 (25°C/77°F - 35°C)** **IC - 970 (>35°C)** 110 - 120(vol) Mix well and strain before application.
 **Spray Viscosity Potlife**	14 to 19 seconds DIN 4 cup at 25°C/77°F 24 hours at 25°C/77°F
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.8 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	**Apply basecoat over original stoved finishes or over IC - 981/IC - 972 grey primers.** Number of spraycoats: 1 thin + 1 wet coat Flash - off: 5 - 10 mins Film thickness: 15 - 25 µm
 **Drying**	Drying at 25°C/77°F: 5 mins Drying at 60°C/140°F: -
Further Treatment	After the flash - off, apply InnoColor clear coat wet on wet.

Basecoat 2c

2 - Stage Metallic Colors (Aluminum/Pearl/Xirallic)

Product Description

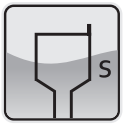
Single component metallic colors for repairing automotive 2 - stage finishes.

Technical Characteristics

Color: mixing system Shelf life: 48 months at 25°C Theoretical spreading rate: 120m² /l (avg) at 1 µm

Pre-treatment

Wet flat with P800 - 1000 grade paper or dry flat with P600 - 800 grade paper.
Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800 The use of a tack rag is recommended.

 **Mixing Ratio**	Stir well before use. Twice per day for 15 mins on the mixing machine. **IC 1KS/1KP/1KX/BH - Metallic Colors** 100 (vol) 100 g **IC - 940 (5°C - 15°C)** **IC - 950 (15°C - 25°C)** 110 - 120 (vol) 100 - 110 g **IC - 960 (25°C - 35°C)** **IC - 970 (>35°C)** Mix well and strain before application.
 **Spray Viscosity** **Potlife**	14 to 19 seconds DIN 4 cup at 25°C 24 hours at 25°C
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.8 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	**Apply basecoat over original stoved finishes or over IC - 981/IC - 972 grey primers.** Number of spraycoats: 1 thin + 1 wet coat + 1 mist coat to match effect Flash-off: 3 mins with spraygun - cooling; Note: Before mist coat, enlarge the spray fan and adjust spraying pressure & distance to be: 2.0 bar (HVLP) 10 - 15 cm 3.5 bar (Conventional) 20 - 25 cm Film thickness: 15 - 25 µm
 **Drying**	Drying at 25°C: 5 mins Drying at 60°C: -
Further Treatment	After the flash - off, apply InnoColor clear coat wet on wet.

Basecoat 2c

2 - Stage Red Pearl

Product Description

Single component basecoat for repairing automotive 2 - stage finishes.

Technical Characteristics

Color: mixing system Shelf life: 48 months at 25°C Theoretical spreading rate: 120m² /l (avg) at 1 µm

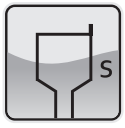
Pre-treatment

Phase 1

Wet flat with P800 - 1000 grade paper or dry flat with P600 - 800 grade paper.
Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800 The use of a tack rag is recommended.

Phase 2 (Optional)

Apply one thin layer of IC - 1K12 / solid colors that are close to red pearl; after one min's flash - off, apply one more wet layer of the same color.
Flash off for 5 mins.

 **Mixing Ratio**	Stir well before use. Twice per day for 15 mins on the mixing machine. **IC - 1KP Red Pearl** 100 (vol) 100 g **IC - 940 (5°C - 15°C)** **IC - 950 (15°C - 25°C)** **IC - 960 (25°C - 35°C)** **IC - 970 (>35°C)** 110 - 120 (vol) 100 - 110 g Mix well and strain before application.
 **Spray Viscosity** **Potlife**	14 to 19 seconds DIN 4 cup at 25°C 24 hours at 25°C
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.8 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	**Apply basecoat over original stoved finishes or over IC - 981/IC - 972 grey primers.** Number of spraycoats: 1 thin + 1 wet coat + 1 mist coat to match effect Flash-off: 3 mins with spraygun - cooling; Note: Before mist coat, enlarge the spray fan and adjust spraying pressure & distance to be: 2.0 bar (HVLP) 10 - 15 cm 3.5 bar (Conventional) 20 - 25 cm Film thickness: 15 - 20 µm
 **Drying**	Drying at 25°C: 5 mins Drying at 60°C: -
Further Treatment	After the flash - off, apply InnoColor clear coat wet on wet.

Xirallic/Pearlescent Basecoat 3c

3 - Stage Single Component Xirallic/Pearl Colors

Product Description

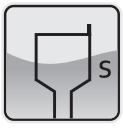
Single component basecoat with xirallic/pearl effect for repairing automotive 3 - stage finishes.

Technical Characteristics

Color: mixing system Shelf life: 48 months at 25°C Theoretical spreading rate: 120m² /l (avg) at 1 µm

Pre-treatment

Wet flat with P800 - 1000 grade paper or dry flat with P600 - 800 grade paper.
Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800 The use of a tack rag is recommended.

 **Mixing Ratio**	Stir well before use. Twice per day for 15 mins on the mixing machine. **Step 1: IC - 1K Solid Colors** 100 (vol) depending on color **IC - 940 (5°C - 15°C)** **IC - 950 (15°C - 25°C)** **IC - 960 (25°C - 35°C)** **IC - 970 (>35°C)** 110 - 120 (vol) Mix well and strain before application. **Step 2: 1KX/BH - /1KP Xirallic/Pearl Colors** 100 (vol) 100g **IC - 940 (5°C - 15°C)** **IC - 950 (15°C - 25°C)** **IC - 960 (25°C - 35°C)** **IC - 970 (>35°C)** 110 - 120 (vol) 100 - 110 g Mix well and strain before application.
 **Spray Viscosity Potlife**	14 to 19 seconds DIN 4 cup at 25°C Step 1: 24 hours at 25°C Step 2: 24 hours at 25°C
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.8 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	**Apply basecoat over original stoved finishes or over IC - 981/IC - 972 grey primers.** **Step 1** **Step 2** Number of spraycoats: 1 thin + 1 wet coat 1 wet + 1 mist coat to match effect Film thickness: 15 µm 15 - 25 µm Flash - off: 3 mins with spraygun - cooling; 5 mins. Note: Before Step 2 mist coat, enlarge the spray fan and adjust spraying pressure & distance to be: 2.0 bar (HVLP) 10 - 15 cm 3.5 bar (Conventional) 20 - 25 cm
 **Drying**	Drying at 25°C: 5 mins Drying at 60°C: -
Further Treatment	After the flash - off, apply InnoColor clear coat wet on wet.

Binders

IC - 1K100 Binder for Basecoat Color Preparation

Product Description

Binder for InnoColor basecoats. Improves leveling and enhances orientation of aluminum and pearl particles.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C

Pre-treatment

See process described in **TDS of InnoColor Basecoat** - Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent Basecoat 3c.

Mixing Ratio

Stir well before use.

		IC - 1K100	IC - 1K190
IC - 1K Solid Basecoat	100 g:	10 g	/
IC - 1KS Coarse Alu.	100 g:	15 g	0 - 10 g
IC - 1KS Fine Alu.	100 g:	20 g	0 - 10 g
IC - 1KP/IC-1KX/BH - 3 - stage Pearl	100 g:	50 - 70 g	-
IC - 1KP 2 - stage Pearl	100 g:	10 g	-

* IC - 1K190 Flip Controller may be added to ensure better results for aluminum and pearl colors as well as for colors with an aluminum mixing base content of at least 75%.
Note: IC - 1K100 should NOT be mixed into poor - covering 1K paint.
Strain before application.

Spray Viscosity Potlife

14 to 19 seconds DIN 4 cup at 25°C

Application

See process described in **TDS of InnoColor Basecoat**

Drying

See process described in **TDS of InnoColor Basecoat**

Further Treatment

See process described in **TDS of InnoColor Basecoat**

Binders

IC - 1K160 Balance Binder for Basecoat Color Preparation

Product Description

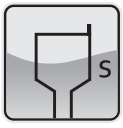
Binder for InnoColor basecoats. Improves leveling and enhances orientation of aluminum and pearl particles. When 1K160 used in grey metallic colors, it can enhance the sprayed effect.

Technical Characteristics

Color: Milky Shelf life: 24 months at 20°C

Pre-treatment

See process described in TDS of InnoColor Basecoat - Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent Basecoat 3c.

 **Mixing Ratio**	Stir well before use. **IC - 1K160** **IC - 1K Solid Basecoat** 100 g: 5-8 g **IC - 1KS Coarse Alu.** 100 g: 5-8 g **IC - 1KS Fine Alu.** 100 g: 5-8 g **IC - 1KX/1KP Pearl** 100 g: 5-8 g Note: IC - 1K160 can prevent the metallic color with cloudy phenomenon and get a perfect flake control in metallics.
 **Spray Viscosity Potlife**	14 to 19 seconds DIN 4 cup
 **Application**	See process described in **TDS of InnoColor Basecoat**
 **Drying**	See process described in **TDS of InnoColor Basecoat**
Further Treatment	See process described in **TDS of InnoColor Basecoat**

Basecoat

IC - 1K190 Flip Controller - Aluminum/Pearl Effect - Adjusting Agent

Product Description

IC - 1K190 is developed for InnoColor aluminum colors to give silver toners a flash - like effect.
Used to lighten up the side face and darken the front face of aluminum flakes.

Technical Characteristics

Color: Milky Shelf life: 24 months at 25°C

Pre-treatment

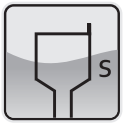
See process described in **TDS of InnoColor Basecoat** - Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent Basecoat 3c.

Mixing Ratio

Stir well before use.

		IC - 1K100	IC - 1K190
IC - 1KS Coarse Alu.	100 g:	15 g	0 - 10 g
IC - 1KS Fine Alu.	100 g:	20 g	0 - 10 g
IC - 1KP 3 - stage Pearl	100 g:	50 - 70 g	-
IC - 1KP 2 - stage Pearl	100 g:	10 g	-

*IC-1K190 Flip Controller may be added to ensure better results for aluminum and pearl colors as well as for colors with an aluminum mixing base content of at least 75%.
Strain before application.



Spray Viscosity Potlife

14 to 19 seconds DIN 4 cup at 25°C

Application

See process described in **TDS of InnoColor Basecoat**

Drying

See process described in **TDS of InnoColor Basecoat**

Further Treatment

See process described in **TDS of InnoColor Basecoat**

Binders

IC - 2K200 Binder for Topcoat Color Preparation

Product Description

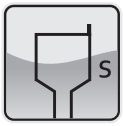
Binder added into IC - 2K solid colors to improve the gloss of the paint film.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C

Pre-treatment

See process described in **TDS of InnoColor Solid Topcoats**

 **Mixing Ratio**	Stir well before use. **IC - 2K Solids** 100 g **IC - 2K200** 15 g Note: IC - 2K200 should NOT be mixed into 1K paint or transparent 2K paint. Strain before application.
 **Spray Viscosity**	14 to 19 seconds DIN 4 cup at 25°C
 **Application**	See process described in **TDS of InnoColor Solid Topcoats.**
 **Drying**	See process described in **TDS of InnoColor Solid Topcoats.**
Further Treatment	See process described in **TDS of InnoColor Solid Topcoats.**

Topcoat

IC - 2K290 Matting Agent

Product Description

Matting agent which allows reducing the gloss level of InnoColor IC - 2K solid colors and clears.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C

Pre-treatment

As specified in the TDS of the product in which IC - 2K290 is being used - Solid Topcoat, 2K Clears.

Mixing Ratio

Stir well before use.

Option 1:
When IC - 2K290 is contained in the mixing formula:
Mix the components respecting the amounts specified in the mixing formula.
Prepare the paint for application by adding hardener and thinner as indicated in the TDS of the topcoat/clearcoat being adjusted.

Option 2:
When matting an original glossy topcoat/clearcoat:
Add IC - 2K290 to produce the desired degree of matting.

Semi Gloss:			
IC - 2K Topcoat	100 (vol)	**IC - 2K Clears**	100 (vol)
IC - 2K 290	30 (vol)	**IC - 2K 290**	30 (vol)
Satin Gloss:			
IC - 2K Topcoat	100 (vol)	**IC - 2K Clears**	100 (vol)
IC - 2K 290	50 (vol)	**IC - 2K 290**	50 (vol)
Silky Matte:			
IC - 2K Topcoat	100 (vol)	**IC - 2K Clears**	100 (vol)
IC - 2K 290	100 (vol)	**IC - 2K 290**	100 (vol)

Stir well.
Prepare the paint for application by adding hardener and thinner as indicated in the TDS of the topcoat/clearcoat being adjusted.

Sprayguns

HVLP gravity - feed spraygun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
Conventional gravity - feed spraygun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm

Application

Number of spraycoats: 1 half wet + 1 wet coat
Film thickness: 40 - 60 µm
Dust - free until mat between spraycoats and before stoving.

Further Treatment

As specified in the TDS of the product, in which IC - 2K290 is being used.

2K Clears

IC - 9901NR Mirror Effect Clear (H.S.)

Product Description

A two-component clear coat with a mirror effect and deep, rich gloss.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Pre-treatment

IC - 9901 - NR Mirror Effect Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat. See TDS of basecoat for other preparation of substrate.

Mixing Ratio

IC - 9901NR **Clear**	100 (vol)	100 g
IC - 9788 **Hardener**	50 (vol)	50.2 g

Mix well and strain before application.
Note: IC - 9688 is for temperatures between 5°C - 15°C
IC - 9788 is for temperatures between 15°C - 25°C
IC - 9888 is for temperatures above 25°C

Spray Viscosity
Potlife

16 to 18 seconds DIN 4 cup at 25°C
3 - 4 hours at 25°C

Sprayguns

HVLP gravity - feed spraygun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm
Conventional gravity - feed spraygun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm

Application

Number of spraycoats: 2 coat
Flash - off: 8 - 15 mins
Film thickness: 50 - 60 µm

Drying

Drying	25°C	60°C
Dust free after	30-40 mins	-
Ready for assembly after	Overnight	30-40 mins
Ready for polish after	Overnight	30-40 mins

IR Drying

IR drying after dust free
Step 1 - short wave: 5 mins at a 80 cm distance
Step 2 - medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.

2K Clears

IC - 9903 High Solid Clear (H.S.)

Product Description

High Solid clears for application ranging from spot repair, panel repair to overall refinish.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 350 - 400 m² /l (avg) at 1 µm

Pre-treatment

IC - 9903 High Solid Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat.
See TDS of basecoat for other preparation of substrate.

Mixing Ratio	**IC - 9903 Clear** 100 (vol) 100 g **IC - 9703 Hardener** 50 (vol) 50.2 g **IC - 950 Thinner** 10 - 15 (vol) 9 - 13 g Mix well and strain before application. Note: IC - 9603/IC - 940 is for temperatures between 5°C - 15°C IC - 9703/IC - 950 is for temperatures between 15°C - 25°C/77°F IC - 9803/IC - 960 is for temperatures above 25°C/77°F IC - 970 Thinner is for temperatures above 35°C or when refinishing large surfaces.
Spray Viscosity Potlife	15 to 17 seconds DIN 4 cup at 25°C/77°F 4 - 5 hours at 25°C/77°F
Sprayguns	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.5 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
Application	Number of spraycoats: 1 half wet + 1 wet coat Flash - off: 8 - 10 mins Film thickness: 60 - 70 µm
Drying	Drying 25°C/77°F 60°C/140°F Dust free after 20 mins - Ready for assembly after 6 hours 30 mins Ready for polish after 7.5 - 9 hours 70 mins
IR Drying	IR drying after dust free Step 1 - short wave: 5 mins at a 80 cm distance Step 2 - medium wave: 20 mins at a 80 cm distance
Further Treatment	Polish after specified drying times and cooling.

2K Clears

IC - 9905 Speed Clear (H.S.)

Product Description

Speed clears for application ranging from spot repair, panel repair to overall refinish. Dry to polish time is 2.5 hours.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Pre-treatment

IC - 9905 Speed Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat.
See TDS of basecoat for other preparation of substrate.

Mixing Ratio

IC - 9905	**Clear**	100 (vol)	100 g
IC - 9788	**Hardener**	50 (vol)	49 g
IC - 950	**Thinner**	0 - 5 (vol)	0 - 5 g

Mix well and strain before application. Normally, thinner is not needed. Only when temperature is very low or viscosity is high, thinner can be used.

Note: IC - 9688/IC - 940 is for temperatures between 15°C
IC - 9788/IC - 950 is for temperatures between 15°C - 25°C/77°F
IC - 9888/IC - 960 is for temperatures above 25°C/77°F
IC - 970 is for temperatures above 35°C or when refinishing large surfaces.

Spray Viscosity Potlife

14 to 17 seconds DIN 4 cup at 25°C/77°F
2 - 3 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
Conventional gravity - feed spraygun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm

Application

Number of spraycoats: 1 half wet + 1 wet coat
Flash - off: 5 - 8 mins
Film thickness: 50 - 60 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	17 - 20 mins	-
Ready for assembly after	100 - 120 mins	-
Ready for polish after	3 - 3.5 hours	75 mins

IR Drying

IR drying after dust free
short ware: 5 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.

2K Clears

IC - 9906 4:1 Hyper Fast Clear (H.S.)

Product Description

Hyper Fast Clear is for application of spot repair and panel repair.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Pre-treatment

IC - 9906 Hyper Fast Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat.
See TDS of basecoat for other preparation of substrate.

Mixing Ratio	**IC - 9906 Clear** 100 (vol) 100 g **IC - 9709 Hardener** 25 (vol) 27 g Mix well and strain before application. Note: IC - 9609 is for temperatures between 5°C - 15°C IC - 9709 is for temperatures between 15°C - 25°C/77°F IC - 9809 is for temperatures above 25°C/77°F
Spray Viscosity Potlife	15 to 18 seconds DIN 4 cup at 25°C/77°F 1 - 2 hours at 25°C/77°F
Sprayguns	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.5 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
Application	Polish after specified drying times and cooling. Number of spraycoats: 1 half wet + 1 wet coat Flash - off: 3 - 5 mins Film thickness: 40 - 50 µm
Drying	Drying 25°C/77°F 60°C/140°F Dust free after 9 - 12 mins - Ready for assembly after 60 mins - Ready for polish after 60 - 90 mins 45 mins
IR Drying	IR drying after dust free Step 1 - short wave: 5 mins at a 80 cm distance Step 2 - medium wave: 10 mins at a 80 cm distance
Further Treatment	Polish after specified drying times and cooling.

2K Clears

IC - 9906 - 30 2:1 Hyper Fast Clear (H.S.)

Product Description

Hyper Fast Clear is for application of spot repair and panel repair.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Pre-treatment

IC - 9906 - 30 Hyper Fast Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat.
See TDS of basecoat for other preparation of substrate.

Mixing Ratio	**IC - 9906 - 30 Clear**	100 (vol)	100 g
	IC - 9788 Hardener	50 (vol)	49 g

Mix well and strain before application.

Note: IC - 9688 is for temperatures between 5°C - 15°C
IC - 9788 is for temperatures between 15°C - 25°C/77°F
IC - 9888 is for temperatures above 25°C/77°F

Spray Viscosity Potlife

14 to 16 seconds DIN 4 cup at 25°C/77°F
1 - 2 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
Conventional gravity - feed spraygun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm

Application

Polish after specified drying times and cooling.
Number of spraycoats: 1 half wet + 1 wet coat
Flash - off: -
Film thickness: 40 - 50 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	9 - 11 mins	-
Ready for assembly after	80 mins	-
Ready for polish after	90 - 120 mins	30 mins

IR Drying

IR drying after dust free
Step 1 - short wave: 5 mins at a 80 cm distance
Step 2 - medium wave: 10 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.

Clear Coat

IC - 608 - NR - 411 High Solids Express Clear Coat

Product Description

IC - 608NR - 411 H.S. Express Clear is a U.S. National Rule Compliant acrylic urethane clear which works well in air dry environment and provide excellent gloss, DOI, leveling, blending, and buffing characteristics. It is an easy to apply two coat clear that offers a range of reducers to meet your different temperature needs.

Technical Characteristics

Color: Transparent
Shelf life: 24 months
Recommended Storage Temperature: 5°C - 25°C/41°F - 77 °F
Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

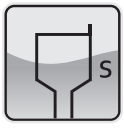
Pre-treatment

IC - 608NR - 411 H.S. Express Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat. See TDS of basecoat for other preparation of substrate.

Mixing Ratio

IC - 608 - NR - 411 Clear coat	100
IC - 678 Hardener	25
IC - 950 - 21V Reducer	25

Mix well and strain before application.
Note:
IC - 668/IC - 940 - 21V is for temperatures between 5°C - 15°C/41°F - 59°F
IC - 678/ IC - 950 - 21V is for temperatures between 15°C - 25°C/59°F - 77°F
IC - 688/IC - 960 - 21V is for temperatures between 25°C - 35°C/77°F - 95°F



Spray Viscosity and Potlife

Spray Viscosity (20°C /68°F)	17-19 S
Pot - Life (20°C /68°F)	3 - 4 h

Spray Guns

HVLP gravity - feed spray gun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm
Conventional gravity - feed spray gun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm

Application

Number of spray coats	2
Film thickness	60 um

Drying

-	20°C/68°F	60°C/160°F
Flash off	5 - 10mins	-
Dust free after	30 - 40mins	-
Ready for assembly after	Overnight	30 - 40mins
Ready for polish after	Overnight	30 - 40mins

IR Drying

IR drying after dust free
Step 1 - short wave: 6 - 10mins at a 80 cm distance
Step 2 - medium wave:6 - 10mins at a 80 cm distance

VOC(Ready to spray)

Actual VOC (Maximum)	435g/l
Regulatory VOC (Maximum)	501g/l

Note:
Use reducer according to shop conditions. Using reducers other than Zero VOC Reducers will increase VOC.
Further Treatment: Polish after specified drying times and cooling. PHYSICAL DATA
Actual VOC (RTS): less than 4.2lbs/gal
Regulatory VOC (RTS): less than 4.2lbs/gal
(less water and exempt solvents)

2K Clears

IC - 2020 Matt Clearcoat

Product Description

Mette finish clears for application ranging from spot repair, panel repair to overall refinish.

Technical Characteristics

Color: transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

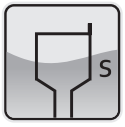
Pre-treatment

IC - 2020 Matt Clearcoat is suitable to be applied on top of a clean and dust - free InnoColor basecoat.
See TDS of basecoat for other preparation of substrate.

Mixing Ratio

IC - 2020	**Clear**	100 (vol)	100 g
IC - 2010	**Hardener**	25 (vol)	24.5 g
IC - 950	**Thinner**	40 - 50 (vol)	35 - 44 g

Need to shake before use
Mix well and strain before application.
Note: IC - 2010F/IC - 940 is for temperatures between 5°C - 15°C
IC - 2010ST/IC - 950 is for temperatures between 15°C - 25°C/77°F
IC - 2010SL/IC - 960 is for temperatures above 25°C/77°F
IC - 970 is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity Potlife

14 to 17 seconds DIN 4 cup at 25°C/77°F
2 - 3 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
Conventional gravity - feed spraygun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm

Application

Number of spraycoats: 1 half wet + 1 wet coat
Flash - off: 8 - 10 mins
Film thickness: 40 - 50 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	10 - 15 mins	-
Ready for assembly after	6 hours	30 mins
Ready for polish after	12 hours	60 mins

IR Drying

IR drying after dust free
Step 1 - short wave: 5 mins at a 80 cm distance
Step 2 - medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.

InnoColor

Wonder-Tech

Primers

IC - 981 2K Multi - Use DTM Primer Surfacer

Product Description

IC - 981, a three - in - one and two - component acrylic primer filler for bodywork repair, has been meticulously developed to enhance two key characteristics: its quality and workshop applicability. It exhibits a high isolating quality and excellent adhesion to putties, fillers, and properly sanded hardened paints.

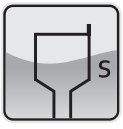
Technical Characteristics

Color: Grey
Shelf life: 24 months
Recommended Storage Temperature: 5°C - 25°C/41°F - 77°F
Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Mixing Ratio

	High Build	Primer	Sealer
IC - 981 Primer	100	100	100
IC - 9788 Hardener	25	25	25
IC - 950 Thinner	10	25	-
IC - 950 - 21V Reducer (Zero VOC)	-	-	50
IC - 2k200 Binder	-	-	10%

Mix well and strain before application.
Note:
IC - 9688/IC - 940 (or IC - 940 - 21V) is for temperatures between 5°C - 15°C/41°F - 59°F
IC - 9788/IC - 950 (or IC - 950 - 21V) is for temperatures between 15°C - 25°C/59°F - 77°F
IC - 9888/IC - 960 (or IC - 960 - 21V) is for temperatures between 25°C - 35°C/77°F - 95°F
IC - 970 is for temperatures above 35°C/95°F



Spray Viscosity and Potlife

	High Build	Primer	Sealer
Spray Viscosity (20°C /68°F)	28 - 32 S	18 - 22 S	17 - 21 S
Pot-Life (20°C /68°F)	20 - 40 mins	20 - 40 mins	20 - 40 mins

Spray Guns

	High Build	Primer	Sealer
HVLP gravity - feed spray gun	2.0 - 2.5 mm 1.8 - 2.0 bar 15 - 20 cm	1.6 - 1.8 mm 1.8 - 2.0 bar 15 - 20 cm	1.5 - 1.6 mm 1.8 - 2.0 bar 15 - 20 cm
HVLP gravity - feed spray gun	1.7 - 2.0 mm 3.0 - 4.0 bar 20 - 25 cm	1.5 - 1.7 mm 3.0 - 4.0 bar 20 - 25 cm	1.3 - 1.4 mm 3.0 - 4.0 bar 20 - 25 cm

Application

	High Build	Primer	Sealer
Number of spray coats	2 - 3	2 - 3	1 - 2
Film thickness	70 um	55 um	35 um

Drying

	High Build	Primer	Sealer
Dry sanding after @20°C/68°F	1.5 - 2 h	1.5 - 2 h	20mins (Non sanding)
Dry sanding after @60°C/160°F	30 S	30 S	-
Flash off	5 - 10 mins	5 - 10 mins	5 - 10 mins

VOC(Ready to spray)

	High Build	Primer	Sealer
Actual VOC (Maximum)	475g/l	516g/l	350g/l
Regulatory VOC (Maximum)	475g/l	516g/l	350g/l

Note:
Use reducer according to shop conditions. As a sealer, using reducers other than Zero VOC Reducers will increase VOC.
Further Treatment: After sanding , apply InnoColor basecoat or topcoat.

Primers

IC - 981D 2K Primer Surfacer (Black)

Product Description

Multi - purpose primer surfacer for covering putty/existing finishes, easy sanding, high efficiency with strong filling power and adhesion. Fine hardness is featured.

Technical Characteristics

Color: Black Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

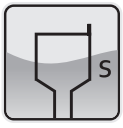
Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

Mixing Ratio

IC - 981D	**Primer**	100 (vol)	100 g
IC - 961	**Hardener**	25 (vol)	19 g
IC - 950	**Thinner**	25 - 30 (vol)	30 - 35 g

Mix well and strain before application.
Note:
IC - 940 is for temperatures between 5°C - 15°C
IC - 950 is for temperatures between 15°C - 25°C/77°F
IC - 960 is for temperatures between 25°C/77°F - 35°C
IC - 970 is for temperatures above 35°C.



Spray Viscosity
Potlife

18 to 22 seconds DIN 4 cup 25°C/77°F
1.5 - 2 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.5 - 1.7 mm	1.8 - 2.0 bar	15 - 20 cm
Conventional gravity - feed spraygun	1.6 - 1.8 mm	3.0 - 4.0 bar	20 - 25 cm

Application

Number of spraycoats: 1 thin + 1 wet coat
Flash - off: 5 - 8 mins
Film thickness: 80 - 120 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	10 - 15 mins	-
Fully cured after	1.5 - 2 hours	30 mins

Further Treatment

After the dust-free, apply InnoColor basecoat or topcoat.

Primers

IC - 981W 2K Primer Surfacer (White)

Product Description

Multi - purpose primer surfacer for covering putty/existing finishes, easy sanding, high efficiency with strong filling power and adhesion. Fine hardness is featured.

Technical Characteristics

Color: White Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

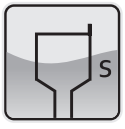
Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

Mixing Ratio

IC - 981W Primer		100 (vol)	100 g
IC - 961	**Hardener**	25 (vol)	20 g
IC - 950	**Thinner**	25 - 30 (vol)	30 - 35 g

Mix well and strain before application.
Note: IC - 940 is for temperatures between 5°C - 15°C
IC - 950 is for temperatures between 15°C - 25°C/77°F
IC - 960 is for temperatures between 25°C/77°F - 35°C
IC - 970 is for temperatures above 35°C



Spray Viscosity
Potlife

18 to 22 seconds DIN 4 cup at 25°C/77°F
1.5 - 2 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.5 - 1.7 mm	1.8 - 2.0 bar	15 - 20 cm
Conventional gravity - feed spraygun	1.6 - 1.8 mm	3.0 - 4.0 bar	20 - 25 cm

Application

Number of spraycoats: 1 thin + 1 wet coat
Flash - off: 5 - 8 mins
Film thickness: 80 - 120 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	10 - 15 mins	-
Fully cured after	1.5 - 2 hours	30 mins

Further Treatment

After the dust - free, apply InnoColor basecoat or topcoat.

Primers

IC - 991 2K Fast - Drying Primer (Grey)

Product Description

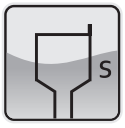
Multi - Purpose fast - drying primer for covering putty/existing finishes.
Fast - Drying and suitable for spot and panel repair.

Technical Characteristics

Color: Grey Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 µm

Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

 **Mixing Ratio**	**IC - 991 Primer** 100 (vol) 100 g **IC - 961 Hardener** 25 (vol) 20 g **IC - 950 Thinner** 35 - 40 (vol) 20 - 25 g Mix well and strain before application. Note: IC - 940 is for temperatures between 5°C - 15°C IC - 950 is for temperatures between 15°C - 25°C/77°F IC - 960 is for temperatures between 25°C/77°F - 35°C IC - 970 is for temperatures above 35°C.
 **Spray Viscosity Potlife**	16 to 20 seconds DIN 4 cup at 25°C/77°F 10 - 15 mins at 25°C/77°F
 **Sprayguns**	HVLP gravity - feed spraygun 1.5 - 1.7 mm 1.8 - 2.0 bar 15 - 20 cm Conventional gravity - feed spraygun 1.6 - 1.8 mm 3.0 - 4.0 bar 20 - 25 cm
 **Application**	Number of spraycoats: 1 thin + 1 wet coat Flash - off: 2 - 3 mins Film thickness: 80 - 120 µm
 **Drying**	Drying 25°C/77°F 60°C/140°F Dust free after 3 - 5 mins - Fully cured after 30 - 35 mins 10 mins
Further Treatment	After the dust - free, apply InnoColor basecoat or topcoat.

2K Primer

IC - 981 - 60 2K Primer Surfacer(Grey)

Product Description

Multi-purpose primer surfacer for covering putty/existing finishes,easy sanding,high efficiency with strong filling power and adhesion. Fine hardness is featured.

Technical Characteristics

Color: Grey Shelf life:24 months at 25°C/77°F Theoretical spreading rate: 250-300 m2/l (avg) at 1 µm

Pre-treatment

Degrease with IC-800.
Wash off residues and dry thoroughly.
Re-clean with IC-800. The use of a tack rag is recommended.
Wet flat with P600-800 grade paper or dry flat with P240-360 grade paper.

Mixing Ratio

IC-981-60	Primer	100 (VOL)	100 g
IC-961	Hardener	25 (VOL)	20 g
IC-950	Thinner	20-25 (VOL)	15-20 g

Mix well and strain before application.
Note:
IC-940 is for temperatures between 5°C – 15°C
IC-950 is for temperatures between 15°C – 25°C/77°F
IC-960 is for temperatures between 25°C/77°F – 35°C
IC-970 is for temperatures above 35°C.

Spray Viscosity
Potlife

16 to 20seconds DIN 4 cup 25°C/77°F
1-1.5 hours at 25°C/77°F

Sprayguns

HVLP gravity-feed spraygun	1.5 – 1.7 mm	1.8 – 2.0 bar	15 – 20 cm
Compliant gravity-feed spraygun	1.6 – 1.8 mm	3.0 – 4.0 bar	20 – 25 cm

Application

Number of spraycoats: 2 thin + 2wet coat
Flash-off: 8 – 10 mins
Film thickness: 180 – 220 µm

Drying

Drying	25°C/77°F	60°C/140°F
Dust free after	15 –20 mins	
Fully cured after	3 – 4 hours	50 mins

Further Treatment

After the dust-free, apply InnoColor basecoat or topcoat.

Primers

IC - 972 - 20 1K Primer Surfacer (Grey)

Product Description

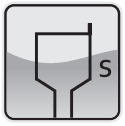
Fast - drying primer surfacer for covering minor defects on putty/existing finishes.

Technical Characteristics

Color: Grey Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 240 - 280 m² /l (avg) at 1 µm

Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re-clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

 **Mixing Ratio**	**IC - 972 - 20 Primer** 100 (vol) 100 g **IC - 944 Super Fast Thinner** 140 - 150 (vol) 100 - 110 g Mix well and strain before application.
 **Spray Viscosity Potlife**	16 to 20 seconds DIN 4 cup at 25°C/77°F 24 hours at 25°C/77°F
 **Sprayguns**	HVLP gravity - feed spraygun 1.5 - 1.7 mm 1.8 - 2.0 bar 15 - 20 cm Conventional gravity - feed spraygun 1.6 - 1.8 mm 3.0 - 4.0 bar 20 - 25 cm
 **Application**	Number of spraycoats: 1 thin + 1 wet coat Flash - off: 5 - 8 mins Film thickness: 60 - 80 µm
 **Drying**	Drying 25°C/77°F 60°C/140°F Dust free after 10 mins - Fully cured after 30 - 45 mins 10 - 15 mins
Further Treatment	After the dust-free, apply InnoColor basecoat or topcoat.

Primers

IC - 972 1K Primer Surfacer (Grey)

Product Description

Fast - drying primer surfacer for covering minor defects on putty/existing finishes.

Technical Characteristics

Color: Grey Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 240 - 280 m² /l (avg) at 1 µm

Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re-clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

Mixing Ratio

IC-972 Primer	100 (vol)	100 g
IC-940 (5°C-15°C) **IC-950 (15°C-25°C)** **IC-960 (25°C -35°C)**		
IC-970 (>35°C)	140-150 (vol)	100-110 g

Mix well and strain before application.

Spray Viscosity
Potlife

16 to 20 seconds DIN 4 cup at 25°C/77°F
24 hours at 25°C/77°F

Sprayguns

HVLP gravity - feed spraygun	1.5 - 1.7 mm	1.8 - 2.0 bar	15 - 20 cm
Conventional gravity - feed spraygun	1.6 - 1.8 mm	3.0 - 4.0 bar	20 - 25 cm

Application

Number of spraycoats: 1 thin + 1 wet coat
Flash - off: 5 - 8 mins
Film thickness: 60 - 80 µm

Drying

	25°C/77°F	60°C/140°F
Drying		
Dust free after	10 mins	-
Fully cured after	30 - 45 mins	10 - 15 mins

Further Treatment

After the dust-free, apply InnoColor basecoat or topcoat.

Primers

IC - 900 Plastic Primer

Product Description

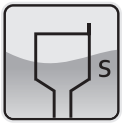
Single - component primer to promote adhesion of paint to plastic parts.
Suitable for PP, ABS, PA or PVC plastic substrates.

Technical Characteristics

Color: Transparent Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 30 - 60 m² /l (avg) at 1 um

Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800. The use of a tack rag is recommended.
Plastic substrates except PE should be wet flat with P600 - 800 grade paper or dry flat with P320 - 400 grade paper.

 **Mixing Ratio**	This product is ready for use.
 **Spray Viscostiy Potlife**	16 to 18 seconds DIN 4 cup at 25°C/77°F 72 hours at 25°C/77°F
 **Sprayguns**	HVLP gravity - feed spraygun 1.2 - 1.3 mm 1.5 - 2.0 bar 10 - 15 cm Conventional gravity - feed spraygun 1.3 - 1.6 mm 3.0 - 4.0 bar 15 - 20 cm
 **Application**	Number of spraycoats: 2 thin coats Flash - off: 5 - 10 mins Film thickness: 5 - 10 µm
 **Drying**	Dust free at 25°C/77°F: 15 - 20 mins
Further Treatment	After the dust - free, apply InnoColor IC - 1K/2K Primer.

Sealer

IC - 981 - 70 Sealer (Grey)

Product Description

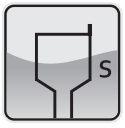
Sealer has been specifically formulated as a premium quality sealer to be used over a variety of substrates.
981 - 70 offers excellent adhesion to variety of substrates , old paint finishes and all InnoColor primers.
Sealer has excellent leveling and gloss hold out properties and is compatible with most basecoat/clearcoat and single stage systems.

Technical Characteristics

Color: Grey Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 300 - 360 m² /l (avg) at 1 µm

Pre-treatment

Degrease with IC - 800.
Wash off residues and dry thoroughly.
Re - clean with IC - 800. The use of a tack rag is recommended.
Wet flat with P600 - 800 grade paper or dry flat with P240 - 360 grade paper.

 **Mixing Ratio**	**IC - 981 - 70 Sealer** 100 (vol) **IC - 650 Hardener** 25 (vol) **IC - 950 - 2V Reducer** 0 - 25 (vol) Mix well and strain before application. Note: 850 Slow Hardener / 960 Slow Reducer / 970 Extra Slow Reducer 750 Standard Hardener / 950 Standard Reducer 650 Fast Hardener / 940 Fast Reducer Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.
 **Spray Viscosity**	13 to 20 seconds DIN 4 cup at 25°C/77°F
Potlife	2.5 hours at 25°C/77°F
 **Sprayguns**	HVLP： 1.2 - 1.6 mm
 **Application**	Number of spraycoats: 1 - 2 coats Flash - off: 5 - 10 mins
 **Drying**	Dry to basecoat or topcoat: 20 mins
Further Treatment	After drying time, apply InnoColor basecoat or topcoat.

Primers

IC - 974 - 20 Epoxy Primer

Product Description

Anti - corrosion epoxy primer for bare metal.
Adhesive to steel, aluminum and galvanized steel.

Technical Characteristics

Color: Grey Shelf life: 24 months at 25°C/77°F Theoretical spreading rate: 300 - 360 m² /l (avg) at 1 µm

Pre-treatment

Degrease with IC - 800 and washed with a tack rag.
Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper.
Clean with IC - 800.

Mixing Ratio	Stir well before use. **IC - 974 - 20 Primer** 100 (vol) 100 g **IC - 964 - 20 Hardener** 25 (vol) 20 g **IC - 954 Thinner** 25-30 (vol) 20 g Mix well and strain before application.
Spray Viscosity Potlife	18 to 22 seconds DIN 4 cup 25°C/77°F 24 hours at 25°C/77°F
Sprayguns	HVLP gravity - feed spraygun 1.5 - 1.7 mm 1.5 - 2.0 bar 15 - 20 cm Conventional gravity - feed spraygun 1.6 - 1.8 mm 3.0 - 4.0 bar 20 - 25 cm
Application	Number of spraycoats: 2 coats Flash - off: 8 - 10 mins Film thickness: 50 - 60 µm Note: This primer can also be applied with a brush.
Drying	Dust free after: 20 - 30 mins Drying at 25°C/77°F 2 hours Drying at 60°C/140°F 30 mins
Further Treatment	After the dust - free, apply InnoColor IC - 1K/2K primer or IC - 212 putty if large sand holes exist (optional).

Body Filler

IC - 199 Mutifunctional Body Filler

Product Description

Very fine particles, good filling power, fast drying, excellent adhesion power, easy to apply and to sand. Suitable for bare metal,primers and existing finishes.

Technical Characteristics

Color: Yellow
Shelf life of Multifunctional Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re - clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	7 - 8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 20 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.

Potlife

2 - 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - 201 2K Body Filler(BPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Soft Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

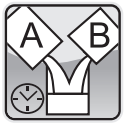
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	5 - 7 minutes	3 - 5 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	5 - 10 minutes	5 - 10 minutes
Dry Sandable After:	20 - 30 minutes	10 - 20 minutes	10 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.



Potlife

3 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 15 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 10 mins
Dry sanding 15 mins

Body Filler

IC - 211 2K Body Filler(BPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Soft Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

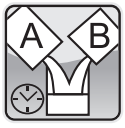
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	5 - 7 minutes	3 - 5 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	5 - 10 minutes
Dry Sandable After:	20 - 30 minutes	15 - 25 minutes	10 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.



Potlife

3 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 10 mins
Dry sanding 15 mins

Body Filler

IC - 213 2K BPO Multifunctional Body Filler

Product Description

Very fine particles, good filling power, fast drying, excellent adhesion power, easy to apply and to sand.
Suitable for bare metal,primers and existing finishes.

Technical Characteristics

Color: Yellow
Shelf life of Multifunctional Body Filler : 24 months ; Best quality :12 months at 25°C
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

Pre-treatment

Degrease with IC-800.
Dry sand with P100-P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC-800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	7 - 8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 20 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.

Pot Life

2 - 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - 219 2K Soft Body Filler(BPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Soft Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

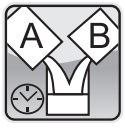
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	5 - 7 minutes	3 - 5 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	25 - 35 minutes	20 - 30 minutes	15 - 25 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.



Potlife

2 - 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 25 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 15 mins
Dry sanding 25 mins

Body Filler

IC - FG10 2KBPO Fiberglass Body Filler

Product Description

IC - FG10 Fiberglass Body Filler gives a glass fiber reinforced plastics surface with superior flexibility, high adhesion and pinhole-free. It is ideal for repairing polyester parts and rust metallic areas.

Technical Characteristics

Color: Green
Shelf life of Fiberglass Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

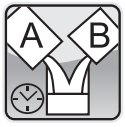
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	7 - 8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 20 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.



Potlife

2 - 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - FG20 2KBPO Fiberglass Body Filler

Product Description

IC - FG20 Fiberglass Body Filler gives a glass fiber reinforced plastics surface with superior flexibility, high adhesion and pinhole-free. It is ideal for repairing polyester parts and rust metallic areas.

Technical Characteristics

Color: Green
Shelf life of Fiberglass Body Filler : 24 months ; Best quality :12 months at 25°C
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C

Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	7 - 8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 20 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.

Potlife

2 - 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - FG700 2KBPO Fiberglass Body Filler

Product Description

IC-FG700 Fiberglass Body Filler gives a glass fiber reinforced plastics surface with superior flexibility, high adhesion and pinhole-free. It is ideal for repairing polyester parts and rust metallic areas.

Technical Characteristics

Color: Yellow

Shelf life of Fiberglass Body Filler : 24 months ; Best quality :12 months at 25°C/77℉

Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77℉

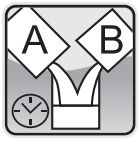
Pre-treatment

Degrease with IC-800.
Dry sand with P100-P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC-800.

Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1.5%
Gel Time:	7-8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	10 - 15 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 20 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

2 – 4 mins at 25°C/77℉

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77℉: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW200 2K Lightweight Body Filler(BPO)

Product Description

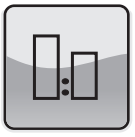
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	7-9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes

Potlife

Mix well before application.

2 – 4 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW210 2K Lightweight Body Filler(BPO)

Product Description

It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

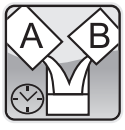
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.



Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW220 2K Lightweight Body Filler(BPO)

Product Description

It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

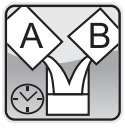
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.



Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW230 2K Lightweight Body Filler(BPO)

Product Description

It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

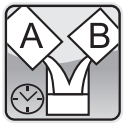
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.



Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW240 2K Lightweight Body Filler(BPO)

Product Description

It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: Yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

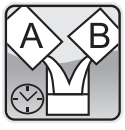
Pre-treatment

Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.



Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW300 2K Lightweight Body Filler(BPO)

Product Description

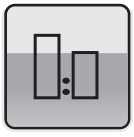
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: white
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77°F
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77°F

Pre-treatment

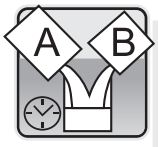
Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

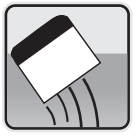
Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

2 – 4 mins at 25°C/77°F



Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW310 2K Lightweight Body Filler(BPO)

Product Description

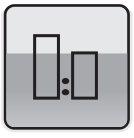
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: yellow
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77℉
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77℉

Pre-treatment

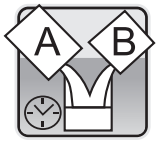
Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

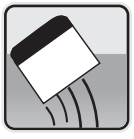
Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

4 – 6 mins at 25°C/77℉



Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77℉: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW320 2K Lightweight Body Filler(BPO)

Product Description

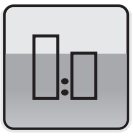
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: grey
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77℉
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77℉

Pre-treatment

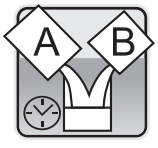
Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

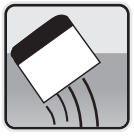
Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

4 – 6 mins at 25°C/77℉



Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77℉: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - LW330 2K Lightweight Body Filler(BPO)

Product Description

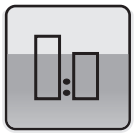
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: green
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77℉
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77℉

Pre-treatment

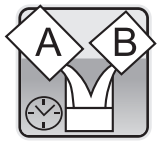
Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	7 - 9 minutes	5 - 7 minutes	3 - 5 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	20 - 30 minutes	15 - 20 minutes

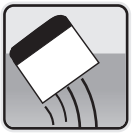
Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

4 – 6 mins at 25°C/77℉



Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77℉: 20 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - GZ100 Light Weight Ultra Fine Finishing Glaze

Product Description

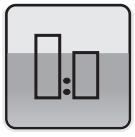
It features flowable texture with grey color, fine and smooth body, very light, easy spreading, excellent filling, super easy sanding without clogging abrasive paper, meanwhile, it can be effective to decrease the car body weight by using this filler to repair. It is especially suitable for renovation and repair of the car engine cover, doors and trunk door.

Technical Characteristics

Color: green
Shelf life of Lightweght Body Filler : 24 months ; Best quality :12 months at 25°C/77℉
Shelf life of BPO Hardener: 12 months ; Best quality : 6 months at 25°C/77℉

Pre-treatment

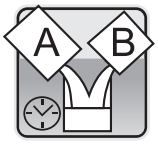
Degrease with IC - 800.
Dry sand with P80 - P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with IC - 800.



Mixing Rate

	10°C	20°C	30°C
Mixing Ratio (BPO Hardener):	3%	2%	1%
Gel Time:	6 - 8 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	20 - 30 minutes	15 - 25 minutes	10 - 20 minutes

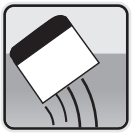
Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80 °C, 5 minutes



Potlife

Mix well before application.

3 – 5 mins at 25°C/77℉



Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77℉: 15 mins

Sanding

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper; then with P240-P320 grade paper to feather edge.
Water sanding 15 mins
Dry sanding 20 mins

Body Filler

IC - 1000 2K CHPO Universal Body Filler

Product Description

2 - component polyester putty featuring good sanding, adhesion and filling properties;
universally Suitable for bare metal, Primers and existing finishes.

Technical Characteristics

Color: Grey
Shelf life of Universal Body Filler: 10 months; Best quality: 6 months at 25°C/77°F
Shelf life of CHPO Hardener: 6 months; Best quality: 3 months at 25°C/77°F

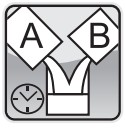
Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	8 - 10 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	40 - 60 minutes	30 - 40 minutes	20 - 30 minutes
Dry Sandable After:	3 - 4 hours	2 - 2.5 hours	1 - 1.5 hours

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.



Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper;
then with P240 - P320 grade paper to feather edge.

Body Filler

IC - 2000 2K CHPO Body Filler

Product Description

2 - component Universal body filler featuring good sanding, adhesion and filling properties; universally Suitable for bare metal, Primers and existing finishes.

Technical Characteristics

Color: Grey
Shelf life of Universal Body Filler: 10 months; Best quality: 6 months at 25°C/77°F
Shelf life of CHPO Hardener: 6 months; Best quality: 3 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1%
Gel Time:	8 - 10 minutes	4 - 6 minutes	2 - 4 minutes
Wet Sandable After:	40 - 60 minutes	30 - 40 minutes	20 - 30 minutes
Dry Sandable After:	3 - 4 hours	2 - 2.5 hours	1 - 1.5 hours

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 10 - 15 minutes
Mix well before application.

Potlife

4 - 6 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 20 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 20 mins
Dry sanding 30 mins

Body Filler

IC - 5000 2K Body Filler(CHPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy wet sanding without clogging abrasive paper, meanwhile.

Technical Characteristics

Color: yellow
Shelf life of Universal Body Filler: 12 months; Best quality: 6 months at 25°C/77°F
Shelf life of CHPO Hardener: 12 months; Best quality: 3 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	4 - 6 minutes	2 - 4 minutes	1 - 3 minutes
Wet Sandable After:	15 - 20 minutes	15 - 20 minutes	10 - 15 minutes
Dry Sandable After:	40 - 50 minutes	35 - 45 minutes	30 - 40 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.

Potlife

1 - 3 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 40 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 15 mins
Dry sanding 40 mins

Body Filler

IC - 6000 2K Body Filler(CHPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy wet sanding without clogging abrasive paper, meanwhile.

Technical Characteristics

Color: grey
Shelf life of Universal Body Filler: 12 months; Best quality: 6 months at 25°C/77°F
Shelf life of CHPO Hardener: 12 months; Best quality: 3 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	17 - 20 minutes	14 - 17 minutes	11 - 14 minutes
Wet Sandable After:	45 - 55 minutes	35 - 45 minutes	30 - 40 minutes
Dry Sandable After:	70 - 80 minutes	55 - 65 minutes	40 - 50 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.

Potlife

12 - 15 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 60 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 45 mins
Dry sanding 60 mins

Body Filler

IC - 7000 2K Body Filler(CHPO)

Product Description

It features flowable texture with yellow color, fine and smooth body, easy spreading, excellent filling, super easy wet sanding without clogging abrasive paper, meanwhile.

Technical Characteristics

Color: red
Shelf life of Universal Body Filler: 12 months; Best quality: 6 months at 25°C/77°F
Shelf life of CHPO Hardener: 12 months; Best quality: 3 months at 25°C/77°F

Pre-treatment

Degrease with IC - 800.
Dry sand with P100 - P120 grade paper or wet sand with P150 - P180 grade paper.
Re-clean with IC - 800.

Mixing Ratio

	10°C	20°C	30°C
Mixing Ratio (CHPO Hardener):	3%	2%	1.5%
Gel Time:	17 - 20 minutes	14 - 17 minutes	11 - 14 minutes
Wet Sandable After:	45 - 55 minutes	35 - 45 minutes	30 - 40 minutes
Dry Sandable After:	70 - 80 minutes	55 - 65 minutes	40 - 50 minutes

Maximum Fill Depth 4 - 7 mm **Infrared Bake:** 50 - 80 cm, 80°C, 5 minutes
Mix well before application.

Potlife

12 - 15 mins at 25°C/77°F

Application

Apply with plastic/steel blade.

Drying

Drying at 25°C/77°F: 60 mins

Sanding

Wet flat with P180 - 240 grade paper or dry flat with P80 - 120 grade paper; then with P240 - P320 grade paper to feather edge.
Water sanding 45 mins
Dry sanding 60 mins

Thinners

InnoColor Thinners

Product Description

Used to reduce application viscosity and to increase the smoothness of the paint film. Thinner with high dissolving ability, compatible with InnoColor primers, basecoats, topcoats and clears.

IC - 940 Thinner 5°C - 15°C (Fast) **IC - 950 Thinner 15°C - 25°C /77°F (Standard)**
IC - 960 Thinner 25°C/77°F - 35°C (Slow) **IC - 970 Thinner >35°C (Extra Slow)**

Technical Characteristics

Color: Transparent Shelf life: 48 months at 25°C/77°F

Pre-treatment

As specified in the TDS of the products in which IC Thinner is being used.

Mixing Ratio

Stir well before use.

IC - 981 Primer	100 (vol)	100 g
IC - 961 Hardener	25 (vol)	20 g
IC - 940/950/960/970 Thinner	25 - 30 (vol)	30 - 35 g
2K Solids/Clears	100 (vol)	100 g
IC - 940/950/960/970 Thinner	depending on 2K Solids/Clears	

Mixing Ratio

1K Basecoats	100 (vol)	depending on colors
IC - 940/950/960/970 Thinner	100 - 120 (vol)	

Mix well and strain before application.
Note: If the temperature and humidity are too high, IC - 70 retarder solvent can be added.

Application

As specified in the TDS of the products in which IC Hardeners are being used.
Important: Due to different dissolving ability, it is recommended InnoColor products should be used with IC Thinner to ensure the best performance.

Tips:

1) Be cautious of over dissolution of the paint when using high - dissolving thinner. Avoid orange peel.
2) Be cautious of under dissolution of the paint when using poor - dissolving thinner. Avoid poor leveling and poor color effect (e.g. orientation of aluminum/pearl particles, poor solid color brightness).

Auxiliaries

IC - 70 Retarder Solvent

Product Description

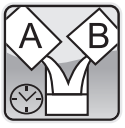
Additive for use in 1K basecoats, 2K topcoats and clears at high temperature (>30°C), at high humidity level (>70%) and/or at high air speed level (>0.5m/s) in booths, to prolong volatilization of solvent and to help produce a good leveling and blushing - free refinishing job in above - mentioned circumstance.

Technical Characteristics

Color: Transparent Shelf life: 24 months at 25°C/77°F

Pre-treatment

As specified in the TDS of the product in which IC - 70 is being used - Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent Basecoat 3c, Solid Topcoat, 2K Clears.

 **Mixing Ratio**	Stir well before use. Add IC - 70 (30% max) to the first basecoat layer. Example for a humidity level is above 70%: **IC - 1K Basecoat** 100 (vol) **IC - 970** 70 - 90 (vol) **IC - 70** 10 - 30 (vol) - to proportionately replace same amount of IC - Thinner
 **Mixing Ratio**	Add IC - 70 (10% max) to the first topcoat/clearcoat layer. Example for a humidity level is above 70%: **IC - 2K Solids/Clears** 100 (vol) **IC - Slow Hardener** 50 (vol) **IC - 970** depending on clears **IC - 70** 5 - 10 (vol) - to proportionately replace same amount of IC - Thinner
 **Pot Life**	The addition of IC - 70 does not change the potlife of the topcoats.
 **Sprayguns**	As specified in the TDS of the product in which IC - 70 is being used.
 **Application**	Intermediate flash - off times will be 5+ mins longer compared with the times specified in the TDS of the product in which IC - 70 is being used. Reasonable extension of flash - off time can help reduce the blush of paint. As specified in the TDS of the product in which IC - 70 is being used. **Important:** Topcoats and clears mixed with IC - 70 will be as hard and resistant as surfaces refinished without IC - 70, however, the addition of IC - 70 can have a negative effect on initial hardness after stoving.
 **Drying**	**Option 1:** Prolong the drying time. **Option 2:** Increase the amount of the hardener used in the IC - 2K topcoat/clear to no more than 10%.
Further Treatment	As specified in the TDS of the product in which IC - 70 is being used.

Auxiliaries

IC - 350 Thinner SRA

Product Description

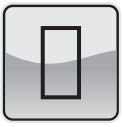
Blending thinner designed to smooth transition areas from blend - in zones to old paintwork, by dissolving rough overspray area of new and existing finishes. Suitable for panel/spot repair.

Technical Characteristics

Color: Transparent Shelf life: 36 months at 25°C/77°F

Pre-treatment

See process described in **other InnoColor TDS.**

 **Mixing Ratio**	The product is ready for use.
 **Application**	1 thin coat right after the finish, second coat in 20 seconds.
 **Drying**	As recommended for the InnoColor clear used.
Further Treatment	If necessary, minor defects can be sanded out with P2000 paper then polish with any standard fine polishing compound once the clear coat has fully cured.

Auxiliaries

IC - 360 Anti - Silicon

Product Description

Traces of grease, oils and particularly silicone oils on the surface to be painted, in paint products or in the spraying air can cause surface defects such as “craters” or “fish eyes” in the paint film. In the medium and long term the root cause of cratering has to be identified and eliminated.
IC - 360 is a short - term remedy to prevent cratering in individual repairs.

Technical Characteristics

Color: Transparent Shelf life: 36 months at 25°C/77°F

Pre-treatment

Clean with IC - 800.
Sand (well - cured old paintwork and IC fillers with P400).
Clean with IC - 800.

Mixing Ratio

Mix the IC - 2K topcoat/clears with hardener and thinner as specified in the TDS. Use the amount of ready - for - use product to determine the amount of IC - 360 to be added.

Add 2 - 5 capfuls (10 - 20g) of IC - 360 per liter of ready - for - use product (toner + hardener + thinner)

Note:

1) Use IC - 360 only when necessary.
2) Never use more than recommended amounts. Excess addition may cause defect of small bubbles or affect the transparency of paint.
3) In serious problems, fisheyes affected paint film must be sanded out and filled. When it is hard dried, refinish with paint mixed with IC - 360.
4) In small problems, sip 1 - 2 drop(s) of IC - 360 with a straw and directly drop to the fisheye affected areas.

Application

1) If defects are detected after one thin spraycoat of IC - 2K topcoat/clears, use IC - 360 as specified.
2) Wait until the paint coat in which craters or fisheyes were detected is dry.
3) Apply one wet coat of paint containing IC - 360 to the affected areas and allow the solvents to evaporate between coats.
4) Continue to apply the clear or topcoat as indicated in the TDS of the product concerned.

Auxiliaries

IC - 800 Degreaser

Product Description

IC - 800 are particularly well suited for removing grease, oils, wax and silicone prior to the application of InnoColor primer and for the pre - treatment of plastic surfaces.

Technical Characteristics

Color: Transparent Shelf life: 48 months at 25°C/77°F

Pre-treatment

Do not use the cleaners on solvent - sensitive or thermoplastic substrates.

 **Mixing Ratio**	This product is ready for use Soak a clean and dry lint - free cloth with IC - 800 Degrease small areas of approximately 0.5m² of the surface to be painted and wipe these areas immediately afterwards with a dry cloth of the same quality. IC - 800 should not dry on the surface being treated.
 **Cleaning**	**Attention:** Some 1K primers/basecoats may suffer surface etching from the use of IC - 800. In this case, ensure a good flash - off of the substrate before going on with the repair so that no solvents will be trapped in the new paint system. In extreme cases, remove the 1K primer/basecoat before applying the new paint system, or flat with P800 - 1000 grade sandpaper for refining refinish.
Further Treatment	As specified in the InnoColor refinishing processes.

Auxiliaries

IC - 820 Quick Drier

Product Description

Drying accelerator for use in IC - 2K topcoats/clears. The addition of IC - 820 will accelerate the chemical reaction between the hardener and the acrylic resin of the products.

Technical Characteristics

Color: Transparent Shelf life: 36 months at 25°C/77°F

Pre-treatment

As specified in the TDS of the product in which IC - 820 is being used - Solid Topcoat, 2K Clears.

Mixing Ratio

Mix the IC - 2K products with hardener and thinner as specified in the TDS. Use the amount of ready - for - use product to determine the amount of IC - 820 to be added.

Important:

The addition of IC - 820 will reduce the potlife of the product.
IC - 820 can NOT be used as hardener.

Use a fast thinner when working in low temperatures (5 - 15°C).
1% of IC - 820 = 2.5 capfuls of IC - 820 per liter of ready - for - use product
(base + hardener + thinner)

1) Drying in low temperatures

The normal application temperature for paint products is 25°C/77°F . If the application temperature is lower, the following percentages apply:

Temperature	10°C - 15°C	0°C - 10°C	< 0°C
IC - 820 (2K Solids)	0.5 - 1 %	1 - 1.5 %	2 %
IC - 820 (2K Clears)	1 - 1.5 %	1.5 - 2 %	3 %
IC - 820 (2K Primer)	1 - 1.5 %	1.5 - 2 %	3 %

2) Accelerating drying

The stoving time for IC - 2K products at 60°C/140°F is 60 minutes. When refinishing individual panels, it is possible to reduce the stoving time to 30 minutes at 60°C/140°F if the following percentages are respected:

	IC - 2K Solids	IC - 2K Clears	IC - 2K Primer
IC - 820	0.5 %	1 %	1 - 2 %

IC - 820 should always be used in small amounts (3% max). If you add too much IC - 820, you will risk loss of gloss or paint film embrittlement.