

Technical Data Sheet

Euro Colour MS 2K Clear 4:1 E 333

Description: Euro Colour E 333 is an exceptionally fast, 2-component urethane clear for use in spot and panel repair of OEM base/clear finishes. High gloss retention and weathering resistance which can retain high gloss level for 3 years. Easy to spray with flow aided formula. Fast dry, good polishability, minimal overspray deliver a new level of productivity.

Relevant Products

E 333	MS 2K Clear 4:1
E 444	MS Universal Activator
E 500	2K Thinner (for spot or panel repair)
E 500s	2K Thinner (for overall repair)
Extra 100	Rubbing compound
Car cream	Finishing compound
Microfinishing Glaze	Finishing agent



Recommended Substrates







- OEM finishes
- Cured repaired finishes
- Euro Colour Master Colour

Physical Properties

Appearance	Vicious Liquid
Colour	Transparent
Odour	Characteristic
Viscosity	11.50 ± 0.30 sec (IWATA #2)
Density (g/lit)	890-915
% non- volatile	32 ± 1 %
ph	n/a
% soluble in water	< 1.00 %

Product Preparation

	Mixing Ratio	Euro Colour E 333 Euro Colour E 444	4 Parts 1 Part
	Apply VOC	650-666 g/l	
	Pot life @ 20° C	1 hours	

Product Preparation (cont'd)			
	Spray viscosity @ 20° C	IWATA # 2	11 ± 0.10 sec
	Spray equipment	Gravity feed Suction feed	Nozzle size
			Distance
			1.2 – 1.4 mm 1.4 – 1.8 mm
	Spray pressure	Gravity feed Suction feed	35-40 pounds 35-40 pounds
	Number of coats	1.5-2	
	Flash time	5 -7 minutes	
	Time to polish	Air dry	up to 24 hours
		Forced dry	2-3 hours after cool down
	Theoretical coverage	7-9 m ² /lit at recommended DFT 45-55 µ -ready-to-spray	

Substrate Preparation

1. Mask the whole vehicle to protect from overspray for spot or panel repair.
2. Allow basecoat to dry 15-30 minutes.
3. Tack with appropriate basecoat tack cloth prior to applying clear.

Recoatability

At any time after drying cure time

Polishing

Optimum times: - Air dry: up to 24 hours
 - Forced dry: 2-3 hours after cool down

Sanding: Sanded with wet sandpaper 1500 grit

Polishing: - Apply a thin ribbon of Extra 100 to the area to be polished. Use double sided wool polishing pad or a sponge pad. Maintain air polisher or variable speed polisher at 1200 to 1800 rpm. Polish until all the 1500S are removed. Wash with water and soap. Wipe dry with clean cloth.

- Apply thin ribbon of Euro Colour Car Cream or Euro Colour Microfinishing Glaze with soft wool or sponge pad throughout the polishing area. Keep the polisher moving all the area until complete removing all the scratch and achieve high gloss. Hand polish with a soft, clean with Microfinishing Glaze is recommended to prevent scratch

Film Property	
Drying Time (@ 20°C)	
- Dust-free	5 – 7 minutes
- Dry to handle	4 – 6 hours
- Hard Dry	24 hours
IR drying (@ 80°C)	
- Flash time	5-7 minutes
- Distance	80 cm
- Time to dry	30 minutes
Film Thickness	45-55 μ
Gloss (60°)	90 ± 2
Hardness	H
Adhesion (Master Colour)	25/25
Resistance NaOH (5%)	Excellent
Resistance to general thinner	Excellent

Repair Systems

Overall repair

Pay attention to the application method. Spray procedure has to ensure proper overspray meltin which is achieved within 2 min. of the clear application. In case of working in high temperature condition, to avoid overspray, Euro Colour E500S is recommended to add by 2.5-5% by weight. Lower spray pressure and slower spray stoke are required to achieve DFT recommended.

Spot repair: Euro Colour E500 Blending Thinner method

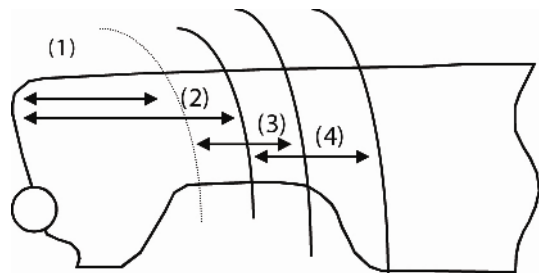
When spot repairing with Master Colour, the clearcoat method as described below can be used when blending out the clear in original areas is unavoidable, the melt-in of the clear can be achieved as described below:

- (1) Apply 1 coat of E333 over the basecoat, extending into the area surrounding the spot.
- (2) Apply a 2nd coat of E333, extending further into the area surrounding the spot.
- (3) OPTIONAL: reduce 1 part of activated ready for use E333 with 1 part E500 and apply 1 coat of reduced E333 over the blend-out area.
- (4) Blend in the fade-out area immediately with pure E500.

*** Surface should be carefully and correctly prepared before the basecoat application. See recommended use, paragraph surface preparation.

*** Stay with the application of AK350 within the prepared area.

If necessary, balance out the gloss level by buffing with Extra 100 and Euro Colour Car Cream or Microfinishing Glaze after the repair is completely hard dry. See the buffing in Polishing section below.



Products	Packages (lit)	Storability at 20° C (month)	Density @ 20° C (g/lit)
Euro Colour E 333	1.000-3.785	24	935-965
Euro Colour E 444	0.500	20	980-999
Euro Colour 2K thinner	3.785-13.000	24	Variously depended on each

Safety Information



- Consult the chemical safety data sheet prior to use.
- Read the precautionary notice displayed on the container.
- Suggested protection suit and accessories must be used while working
- MSDS is available at distributors or the manufacture
- INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Disclaimer: To the best of our knowledge, the information contained herein is accurate. However, neither the above named supplier nor any of its subsidiaries assumes any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of suitability of any material is the sole responsibility of the user.

