

BEARCAT INDUSTRIES, L.P.

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SL-600 Aliphatic Urethane Reference Guide

Sanding

All surfaces must be sanded to achieve a rough surface profile. Preferred sanding methods are:

- Nylon Cup Brush
- #80 Grit sandpaper with DA
- #80 Grit sandpaper by hand

Wipedown

All surfaces must be free of dust, grease, wax and all other contaminants. Wipe down surface area with MEK, methyl ethyl ketone, (acetones are acceptable). **DO NOT USE lacquer thinner**. It is important to use clean cloth rags to reduce contamination.

Important: Chemical gloves and cartridge filtered respirator or supplied fresh air is recommended when using MEK or acetone.

Masking

To prevent any overspray, masking tape may be used with paper, plastic, or tarps. Unmasking can be done one of two ways, wire tape or razor blade.

Follow these steps when using wire trim tape:

1. Always leave at least 3-5 inches of loose tape at the end. Making sure that you will be able to steadily pull the wire.
2. When unmasking, pull slowly in one long stroke making sure not to stop in mid pull.
3. When pulling the line, pull as close to the material as possible. Experiment with this, different thickness will produce different edges.

Follow these steps when using a razor blade:

1. Carefully cut trim line with razor blade.
2. Remove excess material.

Caution: Razor blades can cause damage to painted surfaces. Please use caution when trimming edges.

Spraying

There are two ways from which to spray SL-400 or SL-600. You can spray from 2 – 7.5 gallon hoppers that come equipped on the E-10 spray rig. You can also bypass the hoppers, in favor of connecting directly to 2 – 55 gallon drums.

Important: You must mix B-side thoroughly before spraying, whether you are using the hoppers or drum sets.

Important: Moisture contamination will cause adhesion problems and will blister the material. It is important to have an air filter connected to your air compressor for dry air. Desacant filters must also be used on 55 gallon drums of A and B side to prevent moisture contamination in material.

Cure Time

SL-600 will set in approximately 2 minutes, depending on temperature. Full cure is 24 hours.

Tech data

Storage

For best results, store pails, drums or totes in hot room at 80F. Drum or tote heater blankets may be used, if hot room is not available. It is important to keep desacant filters on either drums or totes, A-side and B-side, to prevent moisture contamination, if using drum or tote sets. Fittings and filters can be purchased from Industrial Polymers. It is important to monitor filters and change when beads turn from blue to pink. This will prevent moisture contamination in material.

Safety

This product contains I.P.D.I. (isophrone diisocyanates) CAS # 4098-71-9 and may cause severe allergic respiratory reaction. Proper personal protection must be used at all times to prevent health problems. This includes supplied air respirators, protective clothing and chemical resistant gloves.

Physical Properties

Typical properties of SL-600 at ambient temperatures are shown below:

Tensile Strength	2,033 psi
Tear Strength	523 psi
Elongation	208%
Hardness	45 Shore D

Clean Up

OVERSPRAY CANNOT BE REMOVED. It is important to mask off all areas that are not being sprayed.

Use acetone or isopropyl alcohol to clean SL-600. (*Do not use bleach or other chemicals*).