User Guideline

Ultracur3D®

Coat F+

Version 2.1

Application: Automotive interior, Footwear, Consumer goo ds, Medical O&P

Key Features:

- Outstanding elasticity and flexibility
- Excellent adhesion
- Low emission
- Extensive range of colors
- Easy to use

Handling:

The coating must be stirred sufficiently before the hardener is added. The mixture must be stirred sufficiently before use. The coating with hardener should not be poured back to the original packaging.

Surface pretreatment:

Cleaning: Isoproponal

Blasting: 30min at 3bar with glass beads

Remark: Blasting is **mandatory** for chemically smoothed surfaces.

Substrates:

●● = Very well suited
● = well suited
❍ = suited in some cases

Ultrasint TPU01	Ultrasint TPU88A	Ultrasint PA11	Ultracur3D FL300	Ultracur3D EL60	Ultracur3D EL4000	Ultracur3D RG35	Ultracur3D ST45	Ultrafuse TPU85A	Formlabs TPU 90A
●●	●●	●●	●●	●●	●●	●	●	●●	●●

Safety advice:

The product is suitable for professional use only.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. The safety data given in this publication is for information purposes only and does not constitute a legally binding MSDS. The relevant MSDS can be obtained upon request from your supplier or you may contact Mass Additive Manufacturing GmbH directly at sales@forward-am.com.

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forward am

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Mixing ratio:	100 : 4 by weight
Hardener:	Ultracur3D® Hardener F+
Reducer:	DI-Water (max 10% by weight)
Potlife bei 20°C:	2 h
Shelf life (5 – 35°C)	12 months

Application:	**HVLP spray gun**	**Dipping**
Air pressure:	2 – 2.5 bar	-
Nozzle size:	1.3 mm	-
Nozzle pressure:	1.5 bar flat brush 0.5 – 0.6 bar round brush	-
Room conditions:	Room temperature (23°C) Relative air humidity (63%)	
Layer thickness:	25 ± 5 µm	N / A
Number of layers	1.5 - 2	N / A
Flash off at 23°C:	5 -10 min	
Application remark:	We recommend applying our Pure White as a primer to achieve a good color appearance on darker substrates for lighter colors such as our Canola Yellow and Signal Orange.	

Final drying:	30 minutes at 80 °C

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