

“Waterbourne” IES STONEGUARD #1680



IES Stoneguard is a liquid plastic coating, water based, specially formulated for the automotive industry, as an exceptional rustproofing and abrasion protection (gravelguard) material. It also provides outstanding corrosion protection and sound deadening qualities.

IES Stoneguard substitutes the traditional asphalt/rubber based product with a solvent-free plastic product, non toxic. Dries at ambient temperature.

Benefits

- A uniformed textured coating can be obtained by use of 1685 Euro Economy Spray Gun or 1690 Euro Multi-Spray Gun
- IES Stoneguard dries to a beautiful black matte finish.
- IES Stoneguard passes the salt spray mist corrosion test (GM4298P) - 336 hours.
- IES Stoneguard has outstanding Anti-chipping Performance (Gravelometer test GM9508P).
- IES Stoneguard has excellent sound deadening qualities.
- 100% paintable.
- Very strong adhesion on metals, fiberglass, wood and painted surfaces.
- Environmentally friendly. It does not contain any PVC, VOC's or toxic components.
- No solvent emissions. No over spray. No spray booth needed.
- Single-component product. no additives or mixing required.
- One year shelf life. **Keep from freezing.**
- Not Flammable and odorless when cured.
- One quart covers 10-15 square feet.

IES Stoneguard is a waterborne, elastic material designed to be applied on clean, primed, painted or top coated surfaces. It's an advanced mix of synthetic polymers, free of PVC's, VOC's, isocyanates, asbestos, with outstanding adhesion and elastic properties on metals and painted surfaces.

A cross-linked polymer coating of 0.5mm to 1.5mm thick (20-60 mils), maintains it's original elasticity for many years without cracking or peeling. This coating reduces solar heat transfer by 20-25°F.

Application Guns:

1685 Euro Economy Spray Gun	1/pkg
1690 Euro Multi-Spray Gun	1/pkg

Product # 1680
32 fl. oz. bottle
12 bottles per case

1680 IES STONEGUARD BLACK

APPLICATION AND CURING INSTRUCTIONS

DESCRIPTION

A tough, durable, high-tech coating that provides protection from chipping, corrosion & road noise.

CLEANING

1680 should be applied on a clean, primed or painted surface, free of oil, undercoat, grease, dirt, release agents etc. Clean surface with IES Super Cleaning Solvent. Failure to properly clean and degrease the surface to be coated will result in the loss of adhesion and the dried coating will easily peel away in large sheets.

APPLYING

1680 has to be applied at a minimum temperature of 50°F at a thickness of 0.5-1.0mm (20 to 40 mils). When using the 1685 Euro Economy Spray Gun, spray at 30-40 psi and hold the nozzle of the gun at 10 -14 inch from the substrate. When using the 1690 Euro Multi-Spray Gun, refer to the operating instructions that are provided with the gun.

These are very crucial requirements. Do not guess, make sure the temperature is above 50°F in the spraying area. Temperatures do differ a lot from floor to ceiling. Be especially careful with opening of warehouse doors etc. which can bring in colder air.

Failure to apply at this min temperature or recommended thickness will result in the dried coating being cracked and easily removable (like black dust).

DRYING:

1680 should not be exposed to temp below 50°F during the application process. The drying process actually exists of three different steps: "dry to the touch" , "fully cured" and "fully cross linked".

1680 will be dry to the touch after:

90 min in ambient air of 72°F and Relative Humidity (RH) 40% . More drying time might be required at higher RH.

30 min in a heated booth at 130°F

30 min (10 min flash off at 30" and 20 min full bake at 30") under Infra Red lamps.

1680 will be fully cured after:

24 hours at ambient air of 72°F and RH 40%. More curing time might be required at higher RH.

12 hours @ temperatures of 80-90°F.

60 min in a heated booth at 130°F and a cool down period of 1 hr at 72°F

40 min (10 min flash off at 30" and 30 min full bake at 30") under the Infra Red Lamps and a

1 hr cool down at 72°F.

1680 can be painted after fully cured.

1680 will be fully cross linked after 7 to 12 days.

Curing times can be considerably improved by adding air movement (fan) to the drying method.

Do not force dry at temps higher than 160F.

When the coating is "dry to the touch" the sprayed items can be moved, worked on, packaged etc. However they cannot be exposed to water and cold temperatures as this will cause thermal shock. Allow the coating to fully cure before exposing to water and cold weather. After the coating is fully cured, it can be painted. However during the next 7-12 days of cross- linking, the coating will gain in hardness and strength. A fully cross- linked coating has a hardness of: Shore A: 93-95.

STORAGE

1680 should be stored in a cool and dry place. **KEEP FROM FREEZING.**