



Tufcote™ CE 602

High-Gloss DTM Polyurethane

(Formerly CenturyExtreme™ 602)



GENERAL

DESCRIPTION

The Tufcote™ CE 602 is a High Gloss direct-to-metal (DTM), high gloss polyurethane coating designed to provide corrosion protection and a tough, glossy, light-stable finish direct to properly prepared steel substrates. The Tufcote™ CE 602 Series is has excellent adhesion, hardness, impact resistance, chemical resistance and exterior UV stability and is formulated for VOC Compliance (<2.8 lb./gal).

SUGGESTED USES

The Tufcote™ CE 602 is intended for use over properly prepared steel substrates and is designed to provide a durable, high gloss, chemical resistant exterior finish.

- Steel Storage tanks
- Railcar
- Heavy Equipment
- Trailer Chassis and Frame
- Marine/OEM/Industrial Maintenance

NOT RECOMMENDED FOR

- Immersion service

PERFORMANCE PROPERTIES

Chemical	Excellent
Humidity	Excellent
Weather	Excellent
Impact	Excellent

COLORS AVAILABLE

Black
White
Gray
Custom Colors Available



MIXING

MIXING RATIO

4:1 BY VOLUME
4 PART BASE / 1 PART ACTIVATOR

COMPONENTS

Base:
Black, 602-B-100B
Hopper Gray, 602-D300-105
White, 602-W300-101

Activator:
652-V-100



REDUCTION

No reduction necessary for airless spray under most conditions. If thinning is desired, reduce with xylene or MEK, adding no more than 3% by volume.

POT LIFE

Temperature	
104° (40°C)	45 Min.
77°F (25°C)	2 Hr.
60°F (15°C)	2.5 Hr.



APPLICATION

SURFACE PREPARATION

This product can be applied over a properly cured compatible epoxy primer or a surface prepared to SSPC-SP 6, 7 or 10 with a 1.5 - 3.0 mil (38-76 micron) abrasive blast profile. Poor surface preparation will reduce the overall performance and service life of the coating. For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants. If applying over an unknown, previously installed coating, test an inconspicuous area for lifting or softening of existing coating prior to full application.

APPLICATION CONDITIONS

Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising. Water condensation on the new film may cause surface imperfections and poor cure. Do not apply when Relative Humidity exceeds 85%. Avoid placing freshly painted components outdoors under wet, rainy conditions. Lower temperatures (< 60°F) will increase dry times. Do not use this product when temperatures fall below 50°F. Substrate temperatures above 120°F may cause the product to sag, curtain, or run.

APPLICATION DATA

Coating Thickness:	4-8 Mil DFT
Coverage:	160 Sq. Ft/Gal @ 6 Mil DFT
Full Cure:	10 Days @ 77°F
Re-coat:	2 Hr. @ 77°F

SPRAY APPLICATION

Airless Spray

Pressure:	1,800 – 2,500 psi
Tips:	0.015" – 0.019"

Conventional Spray

	<u>DeVilbiss</u>
Spray Gun:	MBC-510
Fluid Nozzle:	E
Atomizing Pressure	60-65 psi
Air Cap:	704

BRUSH & ROLL APPLICATION

These products may be applied by brush or roller for touch-up. Use nylon or other brushes designed for solvent based paints. Use ¼' rosin core roller covers designed for solvent-based paints. See application Guidelines for detailed instructions.

CLEAN UP THINNERS

Flush all paint supply lines immediately after application. Clean equipment Axalta thinners 10-T-101 or 10-T-120. Use soap and water to remove any material from hands or skin.



DRY SCHEDULE

Cure time at 6 mil DFT

Temperature	Dry Touch	Dry-Handle	Dry-Decal
104° (40°C)	45 Min.	1 Hr.	2 Hr.
77°F (25°C)	1.5 Hr.	3 Hr.	5 Hr.
60°F (15°C)	6 Hr.	7 Hr.	8 Hr.
50°F (10°C)	12 Hr.	14 Hr.	16 Hr.



PHYSICAL PROPERTIES

Finish	High-Gloss
Mixed VOC	2.41 lbs./gal
Volume Solids	60% +/- 1%
Weight Solids	71% +/- 1%
Theoretical Coverage Per Gallon	962 ft ² @ 1 mil DFT 160 ft ² @ 6 mils DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Package Size:
Base:1-gallon Pail, 4-gallon pail
Base:1-quart Pail, 1-gallon pail

RECOMMENDED STORAGE CONDITIONS

Store components between 55°F and 100°F. Store in dry shaded/covered conditions away from sources of heat and ignition.

Shelf-Life, Part A, 24 Months-Unopened, 77°F
Part B, 24 Months-Unopened, 77°F

SAFETY AND HANDLING

Please contact your Axalta representative for acceptable alternatives to the thinners listed above. Use soap and water to remove any material from hands or skin. Cleanup solvents or thinners are recommended to be used in accordance with each facilities Environmental, Health and Safety standards, regulations and procedures. Please and understand the Safety Data Sheet before using this product.