


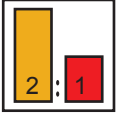
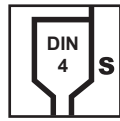


Technical Data Sheet

Acryline 2K High Performance Clearcoat

Product Description	<ul style="list-style-type: none"> • 2K Clearcoat with excellent gloss. • High Mechanical and chemical resistance. • Resistant to weathering.
Technical Description	<ul style="list-style-type: none"> • Mix 2:1 with Acryline 2K MS Hardeners (APU 202/3/4). • Pot Life 4 hours @ 23°C. • Force drying possible. • Air drying @ 25°C.
Single Panel / Spot Repairs	<ul style="list-style-type: none"> • For extra fast air drying add 5 - 10% Acryline Air Dry Promoter (ATH 313 refer to appropriate part of datasheet).
Working Process	<ul style="list-style-type: none"> • 2:1 Clear MS System.
Substrate	<ul style="list-style-type: none"> • Basecoat metallics. • Unibase basecoats. • Pearlescent basecoats.
Pretreatment / Cleaning	 <ul style="list-style-type: none"> • Ensure that the basecoat is touch dry before clearcoat application.
Application	 <ul style="list-style-type: none"> • Use air fed respirator. • Refer to relevant Health and Safety Data sheets.
Special Notes	<ul style="list-style-type: none"> • Do not use Fast Hardener in combination with Slow Thinner. • Do not use Slow Hardener with Fast Thinner. • Medium Hardener may be used with either Fast or Slow Thinner.   <ul style="list-style-type: none"> • Mix 2:1 with Acryline 2K MS Hardeners (APU 202/3/4). • Pot life 4 hours @ 23°C.



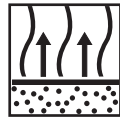
- Thin with Acryline 2K Thinners (ATH 301/2).
- Thin 5 - 10%.
- 18 - 20 sec DIN 4 @ 23°C.



- 1.3 - 1.4 mm.
- HVLP: 1.8 - 2 bar.
- Conventional: 3 - 4 bar.
- 2 coats = 50 - 60 microns (approx.).



- 1.5 - 1.7 mm.
- Conventional: 4 - 5 bar.
- 2 coats = 50 - 60 microns (approx.).










- 5 min @ 23°C.
- Flash off between coats.

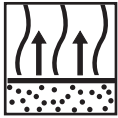



- 10 min @ 23°C.
- Final flash off.



- Air dry over night @ 23°C.
- Or
- 30 min @ 60°C panel temperature.

Working Process	<ul style="list-style-type: none"> • 2:1 MS Accelerated System For Single Panel Spot Repair Using Air Dry Promoter ATH 313.
Substrate	<ul style="list-style-type: none"> • Basecoat metallics. • Unibase basecoats. • Pearlescent basecoats.
Pretreatment / Cleaning	 <ul style="list-style-type: none"> • Ensure that the basecoat is touch dry before clearcoat application.
Application	<ul style="list-style-type: none"> • Extra fast drying for single panel / spot repairs add controlled additions of Acryline Air Dry Promoter ATH 313.  <ul style="list-style-type: none"> • Use air fed respirator. • Refer to relevant Health and Safety Data sheets.
Special Notes	<ul style="list-style-type: none"> • Do not use Fast Hardener in combination with Slow Thinner. • Do not use Slow Hardener with Fast Thinner. • Medium Hardener may be used with either Fast or Slow Thinner.   <ul style="list-style-type: none"> • Mix 2:1 MS Acryline 2K Hardeners.  <ul style="list-style-type: none"> • Thin 5 - 10 % Acryline Air Dry Promoter (ATH 313). • Add sufficient Acryline 2K Thinner to give 18 - 20 sec Din 4 @ 23°C.  <ul style="list-style-type: none"> • 1.3 - 1.4 mm. • HVLP: 1.8 - 2 bar. • Conventional: 3 - 4 bar. • 2 coats = 50 - 60 microns (approx.).  <ul style="list-style-type: none"> • 1.5 - 1.7 mm. • Conventional: 3 - 4 bar. • 2 coats = 50 - 60 microns (approx.).

	 <ul style="list-style-type: none"> • 5 min @ 23°C. • Flash off between coats and final flash off.
	 <ul style="list-style-type: none"> • Air Dry 20 - 30 mins @ 23°C.
Flashpoint	<ul style="list-style-type: none"> • 23°C.
Specific Gravity	<ul style="list-style-type: none"> • 0.950 - 0.980 g/cm³. • Dependant on colour.
Solid Content	<ul style="list-style-type: none"> • +/- 40% (by weight).
Average DFT	<ul style="list-style-type: none"> • Minimum 55 microns.
Raw Material	<ul style="list-style-type: none"> • 2-pack acrylic resins.
Cleaning of Equipment	<ul style="list-style-type: none"> • Clean after use with Lacquer Thinners.
Shelf Life	<ul style="list-style-type: none"> • 12 months @ 20 - 25°C in original sealed packaging.
Important Remarks	<ul style="list-style-type: none"> • For professional use only. • Acryline 2K Clearcoat cannot be used over Acrylic lacquers and synthetic enamels.



- Protect from sunlight.



- Working areas should be well ventilated.
- Booth must have good extraction.
- Refer to Safety Data Sheet (SDS), for download from www.plascon-automotive.co.za.



- Protect from severe cold.



- This Product contains flammable materials.
- Keep away from sparks & open flames.
- No smoking permitted in the area.

Warning:

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitisation if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Contact with skin and eyes should be avoided. Contact with eyes should be referred to a Doctor after washing with water. Gloves and goggles should be worn when handling these products, as well as suitable respiratory equipment. Ensure work area is well ventilated. Inhalation of spray mists must be avoided. Splashes of paint in eyes should be flushed out with water. Contact lenses, if in use, must be removed. Paint in contact with skin must be removed promptly and then washed with soap and water.

Note:

The information contained here represents the current state of our knowledge and is intended as a guide to our products and their uses. It is not intended as an insurance of certain product properties or of their specific applications. The warnings displayed on the product labels should be followed. Any industrial property rights should be observed. We guarantee perfect product quality under the terms of our general conditions of sale.

All other Acryline Technical Data Sheets (TDS's) can be downloaded from www.plascon-automotive.co.za.

Disclaimer:

The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control. Should a recommendation be of a GENERAL NATURE and not refer to any particular project, and should the reader wish to use the general specification for a PARTICULAR project, then he should first confirm with the Technical Service Department that the specification can be used. Not all products referred to in this Data Sheet are stock items. Many are manufactured only on receipt of official customer orders. It is essential, therefore, where time is of the essence, to check availability and manufacturing lead times with us.

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