






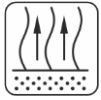



TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>CRYSTAL</p> <p>ACRYLIC CLEARCOAT HS 2:1</p>	
<p>PRODUCTS</p> <p>CRYSTAL HS 2:1 Acrylic Clear Coat Hardener STANDARD 1:2 for clear coat CRYSTAL Hardener SLOW 1:2 for clear coat CRYSTAL (for application at temp. > 25°C) Hardener FAST 1:2 for clear coat CRYSTAL (for application at temp. < 18°C) Thinner for acrylic systems INTER TROTON</p>	
<p>PRODUCT DESCRIPTION</p> <p>High quality 2K HS acrylic clearcoat recommended for complete or fast partial car body repairs. The product creates a hard and crystal clear coating with increased scratch resistance (SR), which does not change the shade of the basecoat colour. Long open time and good stability on vertical elements allow the achievement, if desired, of an orange peel effect (structure) identical to the original factory painting.</p> <ul style="list-style-type: none"> • Crystal clear coating. • Very high and durable gloss. • Ability to create the desired structure identical to the original factory painting. • Good stability on vertical elements. • Hard and durable finish. • High scratch resistance. • Long open time and very good overspray absorption. 	
<p>COLOUR: transparent</p> <p>GLOSS GRADE: high gloss</p>	

<p>VOLATILE ORGANIC COMPOUNDS</p> <p>VOC for the mixture 529 g/l</p> <p><i>This product meets the requirements of the European Union Directive (2004/42/EC/II B), which for this product category (e) sets the VOC value at 840 g/l.</i></p>	
<p>SURFACE PREPARATION</p> <p>Acrylic clear coats can be applied over:</p> <ul style="list-style-type: none"> • Basecoats. • Existing coatings in good condition after sanding and degreasing. <p>For matting we recommend:</p> <ul style="list-style-type: none"> • grey non-woven abrasive cloth with matting compound. • sanding paper 600÷800 (for wet sanding), • sanding paper 360÷500 (for machine sanding). 	

APPLICATION PROCESS										
	<p>USE</p> <p>For automotive refinishing repairs that require a durable finish.</p>			<p>SPRAYING VISCOSITY</p> <p>15÷17 seconds at 20°C.</p>						
	<p>MIXING RATIO By volume</p> <table border="1" style="width: 100%;"> <tr> <td>Clear coat</td> <td>2</td> </tr> <tr> <td>Hardener</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>10%</td> </tr> </table>		Clear coat	2	Hardener	1	Thinner	10%		<p>POT LIFE</p> <p>about 5 hours at 20°C.</p>
Clear coat	2									
Hardener	1									
Thinner	10%									
	<p>NUMBER OF LAYERS AND GUN PARAMETERS</p> <p>Number of layers 2 full layers, approx. 50 µm of dry coating</p> <p>RP gun parameters Nozzle: 1.2÷1.4 mm; Pressure: 2,0÷2,2 bar.</p> <p>HVLP gun parameters Nozzle: 1.2÷1.4 mm; Inlet pressure: 2,0 bar.</p>			<p>DRYING TIME</p> <p>At temperature of 20°C Dust free: after about 30-35min Ready to polish: after drying overnight.</p> <p>At panel temperature of 60°C Clear coat is ready to polish after about 30 minutes of baking and cooling down (about 2 hours). Temperatures below 20°C significantly increases the drying time.</p>						
	<p>FLASH OFF TIME</p> <table border="1" style="width: 100%;"> <tr> <td>Between layers:</td> <td>5÷7 minutes</td> </tr> <tr> <td>Before baking:</td> <td>Approx. 10 minutes</td> </tr> </table>		Between layers:	5÷7 minutes	Before baking:	Approx. 10 minutes		<p>IR DRYING</p> <p>15÷20 minutes under short waves, depending of the layer thickness and type of radiator. Do not exceed temperature of 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting IR drying.</p>		
Between layers:	5÷7 minutes									
Before baking:	Approx. 10 minutes									

EFICIENCY

1 liter of mixture is enough to cover a surface of 9 m² with a layer thickness of 50 µm.

SHADING

Make sure you have covered the whole area with the base coat and the shading is done only on a previously prepared area. Use FADE OUT THINNER to blend the dust that has settled around the repaired surface and to eliminate optical gloss differences between the old lacquer and the newly applied acrylic clear coat.

POLISHING AND ELIMINATING DEFECTS

Usually polishing is unnecessary, as the CRYSTAL MS 2:1 gives the surface a perfect finish immediately after application. However, if some dirt inclusions appear, we recommend removing them and then polishing the surface with an abrasive compound.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved by painting at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and airways.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: To maintain safety, always follow the instructions given in the MSDS for the products.

STORAGE

Store the product components under temperatures of 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use close the container with products immediately.
2. Protect the hardener against frost and humidity!

WARRANTY PERIOD

CRYSTAL HS 2:1 Acrylic Clear Coat	- 24 months from the date of production
Hardener STANDARD 1:2 for acrylic clear coat CRYSTAL	- 12 months from the date of production
Hardener SLOW 1:2 for acrylic clear coat CRYSTAL	- 12 months from the date of production
Hardener FAST 1:2 for acrylic clear coat CRYSTAL	- 12 months from the date of production
Thinner for acrylic systems INTER TROTON	- 24 months from the date of production

PRODUCTS
ART. No.

CRYSTAL HS 2:1 Acrylic Clear Coat	14949; 14950 (1l; 5l)
Hardener STANDARD 1:2 for acrylic clear coat CRYSTAL	14951; 14952 (0,5l; 2,5l)
Hardener SLOW 1:2 for acrylic clear coat CRYSTAL	14955; 14956 (0,5l; 2,5l)
Hardener FAST 1:2 for acrylic clear coat CRYSTAL	14953; 14954 (0,5l; 2,5l)
Thinner for acrylic systems INTER TROTON	300002236; 300002237 (1l; 5l)

LIMITATION OF LIABILITY

The information contained in this TDS sheet is up-to-date and correct on the day the information is released.

Because TROTON cannot control or predict the conditions under which a product will be used, each user should review the information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products and for work that is not in line with good craftsmanship.

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