

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### C38 VHS 2:1

ACRYL CLEAR COAT

#### PRODUCTS

Acryl Clear Coat C 38 VHS 2:1  
 Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS  
 Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS  
 Thinner for acrylic systems MASTER

#### PRODUCT DESCRIPTION

High quality 2-component acrylic clearcoat for car repairs with a very low content of volatile compounds.

- For the repair of small and large surfaces.
- Very high solid content > 55%.
- Excellent coat appearance.
- High gloss.
- Easy to apply.
- Ideal absorption of spray mist.
- Excellent flow.

\* ambient temperature 20°C, air humidity not higher than 80%.



**COLOUR:** transparent

**GLOSS GRADE:** high gloss

#### VOLATILE ORGANIC COMPOUNDS

VOC for the mixture 2:1 without thinner = 385 [g/l],

VOC for the mixture 2:1 with 5% of thinner = 405 [g/l].

This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (d), at 420 g/l.

#### SURFACE PREPARATION

Acrylic Clear Coats can be applied over:

- Base Coats,
- Old finishes in good condition after matting and degreasing.

For matting we recommend the following:

- grey abrasive fabric with a polishing compound,
- sanding paper with gradation of 600÷800 (wet sanding),
- sanding paper with gradation of 360÷500 (machine sanding).

#### APPLICATION PROCESS

| USE             |   | NUMBER OF LAYERS      |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
|-----------------|---|-----------------------|--|------|-----------------|-----------|-----------|----------------|---------|-----------|-----|---------|-----------------|------|--------------------|----------------|--------|-----------------------|
|                 | Paint repairs on small and large surfaces.  |                       | <b>1.5 layers</b> – 1 medium (thin) and then a full layer with 2 minutes of flash off between the layers in order to obtain a dry film thickness of 50-60 µm.<br><b>2 layers:</b> 2 full layers, total dry film thickness of 60÷75 µm.<br><b>Gun parameters:</b><br>RP nozzle: 1.2÷1.4mm; Pressure of input: 2.0÷2.2 bars.<br>HVLP nozzle: 1.3÷1.4mm; Inlet pressure: 2.0 bars.<br>Note: follow the gun producer's recommendations.                  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
|                 | <b>MIXING RATIO</b> by volume<br>Clear Coat 2 parts<br>Hardener 1 part<br>Thinner: 0÷5%   |                       | <b>HARDENING TIME</b><br>STANDARD Hardener <table border="1"> <thead> <tr> <th></th> <th>20°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>Dust dry</td> <td>40 min.</td> <td>10 min.</td> </tr> <tr> <td>Touch dry</td> <td>3 h</td> <td>15 min.</td> </tr> <tr> <td>Hardness to use</td> <td>13 h</td> <td>15 min. + 4 h/20°C</td> </tr> <tr> <td>Total hardness</td> <td>7 days</td> <td>15 min. + 4 days/20°C</td> </tr> </tbody> </table> |      | 20°C            | 60°C      | Dust dry  | 40 min.        | 10 min. | Touch dry | 3 h | 15 min. | Hardness to use | 13 h | 15 min. + 4 h/20°C | Total hardness | 7 days | 15 min. + 4 days/20°C |
|                 | 20°C  | 60°C                  |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Dust dry        | 40 min.   | 10 min.               |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Touch dry       | 3 h   | 15 min.               |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Hardness to use | 13 h  | 15 min. + 4 h/20°C    |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Total hardness  | 7 days  | 15 min. + 4 days/20°C |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
|                 | <b>SPRAYING VISCOSITY</b><br>17÷19 seconds at 20°C/DIN4.  |                       | Temperature below 20°C significantly increases the hardening time.   |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
|                 | <b>POT LIFE</b><br>Hardener STANDARD: 3.5 hours at 20°C<br>Hardener FAST: 2 hours at 20°C   |                       | <b>IR DRYING</b><br>10÷15 minutes of short waves, depending on the layer thickness and the type of radiator.<br>Do not exceed 60°C.<br>Use as recommended by the equipment manufacturer.<br>Wait about 10 minutes before starting the heater drying.   |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
|                 | <b>EVAPORATION TIME</b> <table border="1"> <thead> <tr> <th></th> <th>STANDARD</th> <th>FAST</th> </tr> </thead> <tbody> <tr> <td>Between layers:</td> <td>5÷10 min.</td> <td>5÷10 min.</td> </tr> <tr> <td>Before baking:</td> <td>10 min.</td> <td>10 min.</td> </tr> </tbody> </table> |                       | STANDARD   | FAST | Between layers: | 5÷10 min. | 5÷10 min. | Before baking: | 10 min. | 10 min.   |     |         |                 |      |                    |                |        |                       |
|                 | STANDARD  | FAST                  |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Between layers: | 5÷10 min.   | 5÷10 min.             |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |
| Before baking:  | 10 min.   | 10 min.               |  |      |                 |           |           |                |         |           |     |         |                 |      |                    |                |        |                       |

## PRODUCT EFFICIENCY

1 liter of mixture is enough to cover 10 m<sup>2</sup> with a dry layer with thickness of 60 µm.

## POLISHING AND REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the C38 VHS Clear Coat 2:1 gives the surface a perfect look 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 hardener!
- Best results achieved at room temperature. The ambient temperature and the temperature of the used product should be the same.
- When working with 2K products, it is recommended to use personal protective equipment. Protect the eyes and the respiratory system.
- 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 product.

## STORAGE

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

### Caution:

1. Close the containers immediately after application.
2. Protect hardener against freeze and humidity!

## WARRANTY PERIOD

|   |   |
|---|---|
| Acryl Clear Coat C 38 VHS 2:1                       | – 24 months from the date of production |
| Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS | – 12 months from the date of production |
| Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS     | – 12 months from the date of production |
| Thinner for acrylic systems MASTER                  | – 24 months from the date of production |

| PRODUCTS  | ART. No.                      |
|---|-------------------------------|
| Acryl Clear Coat C 38 VHS 2:1                       | 13090; 13092 (1l; 5l)         |
| Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS | 13091; 13093 (0,5l; 2,5l)     |
| Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS     | 13101; 13102 (0,5l; 2,5l)     |
| Hardener SLOW 1:2 for Acryl Clear Coat C 38 VHS     | 14268; 14269 (0,5l; 2,5l)     |
| Thinner for acrylic systems MASTER                  | 300002253; 300002790 (1l; 5l) |

## LIMITATION OF LIABILITY

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