



## **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%.
- Excellet coat appearence.
- 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**

USE

Acrylic Clear Coats can be applied over:

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

For matting we recommend the following:

**NUMBER OF LAYERS** 

- · 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



Paint repairs on small and large surfaces.



**1.5 layers** – 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.

2 layers: 2 full layers, total dry film thickness of 60÷75  $\mu m.$  Gun parameters:

RP nozzle: 1.2÷1.4mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.3÷1.4mm; Inlet pressure: 2.0 bars. Note: follow the gun producer's recommendations.



MIXING RATIO by volume

Clear Coat 2 parts
Hardener 1 part
Thinner: 0÷5%

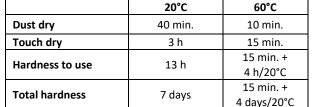


# HARDENING TIME

STANDARD Hardener



17÷19 seconds at 20°C/DIN4.



Temperature below 20°C significantly increases the hardening time.



## POT LIFE

Hardener STANDARD: 3.5 hours at 20°C Hardener FAST: 2 hours at 20°C



## **EVAPORATION TIME**

**SPRAYING VISCOSITY** 

STANDARDFASTBetween layers:5÷10 min.5÷10 min.Before baking:10 min.10 min.



# IR DRYING

 $10 \! \div \! 15$  minutes of short waves, depending on the layer thickness and the type of radiator.

Do not exceed 60°C.

Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.

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#### 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!

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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

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

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