
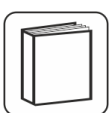

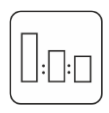

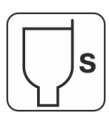

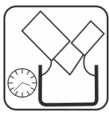

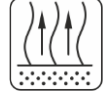



TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h3>HS MASTER 2:1</h3> <p>ACRYLIC CLEAR COAT</p>	
<p>PRODUCTS</p> <p>HS MASTER Acrylic Topcoat Clear Coat 2:1 STANDARD Hardener 1:2 for HS MASTER Acrylic Clear Coat SLOW Hardener 1:2 for HS MASTER Acrylic Clear Coat - dedicated to temperatures higher than 25°C FAST Hardener 1:2 for HS MASTER Acrylic Clear Coat- dedicated to temperatures lower than 18°C Thinner for acrylic systems</p>	
<p>PRODUCT DESCRIPTION</p> <p>High quality 2K acrylic clear coat for car repairs with low content of volatile compounds and increased Scratch Resistance.</p> <ul style="list-style-type: none"> • High contents of resin. • Short hardening time. • Very high gloss. • Excellent look of the coat. • Easy to apply. 	<p>COLOUR: transparent</p> <p>GLOSS GRADE: high gloss</p>

<p>VOLATILE ORGANIC COMPOUNDS</p>	
<p>VOC for mixture = 510 [g/l], This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (e), at 840 g/l.</p>	
<p>SURFACE PREPARATION</p>	
<p>Acrylic Clear Coats can be applied over:</p> <ul style="list-style-type: none"> • Base Coats, • Old finishes in good condition after matting and degreasing. 	<p>For matting we recommend the following:</p> <ul style="list-style-type: none"> • grey abrasive fabric with a polishing compound, • sanding paper with gradation of 600÷800 (wet sanding), • sanding paper with gradation of 360÷400 (machine sanding).

APPLICATION PROCESS															
	<p>USE</p> <p>For car body paint repair that requires a durable finish.</p>		<p>NUMBER OF LAYERS</p> <p>2 full layers, total dry film thickness of approx. 60 µm.</p> <p>Gun parameters: RP nozzle: 1.3÷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.</p>												
	<p>MIXING RATIO by volume</p> <table border="1" data-bbox="231 1534 694 1624"> <tr> <td>Clear Coat</td> <td>2 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner</td> <td>max. 10%</td> </tr> </table>	Clear Coat	2 parts	Hardener	1 part	Thinner	max. 10%		<p>HARDENING TIME</p> <table border="1" data-bbox="853 1556 1444 1713"> <tr> <td>Dust dry at 20°C:</td> <td>15 minutes</td> </tr> <tr> <td>Baking at 60°C: (temperature of the panel)</td> <td>30 minutes</td> </tr> <tr> <td>Ready to polish:</td> <td>after drying overnight</td> </tr> </table> <p>Temperature below 20°C significantly increases the hardening time.</p>	Dust dry at 20°C:	15 minutes	Baking at 60°C: (temperature of the panel)	30 minutes	Ready to polish:	after drying overnight
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	<p>SPRAYING VISCOSITY</p> <p>15÷16 seconds at 20°C/DIN4 with 10% thinner</p>		<p>IR DRYING</p> <p>15÷20 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.</p>												
	<p>POT LIFE</p> <p>Approx. 2 h at 20°C.</p>		<p>EVAPORATION TIME</p> <table border="1" data-bbox="231 1971 694 2038"> <tr> <td>Between layers:</td> <td>approx. 5÷7 minutes</td> </tr> <tr> <td>Before banking:</td> <td>approx. 5÷10 minutes</td> </tr> </table>	Between layers:	approx. 5÷7 minutes	Before banking:	approx. 5÷10 minutes								
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PRODUCT EFFICIENCY

1 liter of mixture is enough to cover 8÷10 m² with a dry layer with thickness of 60 µm.

SHADING

Make sure you have covered all the surface with the clear coat. You should only shade the surface that has been covered and treated. Use Inter Troton FADE OUT THINNER to clean any dust or dirt from the surface and to level out the optical gloss differences between the older and new applied coating.

POLISHING AND REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the HS MASTER 2:1 Acrylic Clear Coat 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 the hardener!
- The best repair results can be achieved 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 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 products.*

STORAGE

Store the product between 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 the container with product should be immediately closed.
2. Protect the hardener from frost and dampness!

WARRANTY PERIOD

HS MASTER Acrylic Topcoat Clear Coat 2:1	– 24 months from the date of production
STANDARD Hardener 1:2 for HS MASTER Acrylic Clear Coat	– 12 months from the date of production
SLOW Hardener 1:2 for HS MASTER Acrylic Clear Coat	– 12 months from the date of production
FAST Hardener 1:2 for HS MASTER Acrylic Clear Coat	– 12 months from the date of production
Thinner for acrylic systems	– 12 months from the date of production

PRODUCT	ART. No.
HS MASTER Acrylic Topcoat Clear Coat 2:1	2238; 2239 (1l; 5l)
STANDARD Hardener 1:2 for HS MASTER Acrylic Clear Coat	1804; 1836 (0,5l; 2,5l)
SLOW Hardener 1:2 for HS MASTER Acrylic Clear Coat	5978; 5948 (0,5l; 2,5l)
FAST Hardener 1:2 for HS MASTER Acrylic Clear Coat	8578; 8553 (0,5l; 2,5l)
EXTRA SLOW Hardener 1:2 for HS MASTER Acrylic Clear Coat	9977; 9968 (0,5l; 2,5l)
Thinner for acrylic systems	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.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review 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 are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

TROTON Sp. z o.o.
Ząbrowo, Poland.