

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>SPARK 07 UHS 2:1 ACRYLIC CLEARCOAT UHS 2:1</p>	
<p>PRODUCTS</p> <p>SPARK 07 Acrylic Clear Coat UHS 2:1 – Topcoat Clear Coat EXTRA SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat STANDARD hardener 1:2 for SPARK 07 Acrylic Clear Coat FAST hardener 1:2 for SPARK 07 Acrylic Clear Coat</p>	
<p>PRODUCT DESCRIPTION</p> <p>High quality 2K acrylic transparent clear coat for fast repairs with low content of volatile compounds.</p> <ul style="list-style-type: none"> • High contents of resin. • Very high gloss. • Excellent look of the surface. 	<p>COLOUR: transparent</p> <p>GLOSS GRADE: high gloss</p>

<p>VOLATILE ORGANIC COMPOUNDS</p> <p>VOC for the mixture = 408 [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.</p>			
<p>SURFACE PREPARATION</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; padding: 5px; vertical-align: top;"> Acrylic Clear Coats can be applied over: <ul style="list-style-type: none"> • Base Coats, • Old finishes in good condition after matting and degreasing. </td> <td style="width: 50%; padding: 5px; vertical-align: top;"> For matting we recommend the following: <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÷500 (machine sanding). </td> </tr> </table>		Acrylic Clear Coats can be applied over: <ul style="list-style-type: none"> • Base Coats, • Old finishes in good condition after matting and degreasing. 	For matting we recommend the following: <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÷500 (machine sanding).
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APPLICATION PROCESS															
	<p>USE</p> <p>For repairs of all sizes.</p>		<p>EVAPORATION TIME</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th>Between layers:</th> <th>Before baking:</th> </tr> </thead> <tbody> <tr> <td>SLOW</td> <td>15÷16 min.</td> <td>20 min.</td> </tr> <tr> <td>STANDARD</td> <td>7÷8 min.</td> <td>15 min.</td> </tr> <tr> <td>FAST</td> <td>6÷7 min.</td> <td>10÷15 min.</td> </tr> </tbody> </table>		Between layers:	Before baking:	SLOW	15÷16 min.	20 min.	STANDARD	7÷8 min.	15 min.	FAST	6÷7 min.	10÷15 min.
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	<p>MIXING RATIO by volume</p> <p>Clear Coat 2 parts Hardener 1 part This clear coat does not require thinner!</p>		<p>HARDENING TIME</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th>Dust free at 20°C:</th> <th>Baking at 60°C (temperature of baking item):</th> </tr> </thead> <tbody> <tr> <td>SLOW</td> <td>50÷60 min.</td> <td rowspan="3">25÷30 min.</td> </tr> <tr> <td>STANDARD</td> <td>35÷40 min.</td> </tr> <tr> <td>FAST</td> <td>25÷30 min.</td> </tr> </tbody> </table> <p>Further work: Polishing – approx. 2 hours after cooling of the coating. Temperature below 20°C significantly increases the hardening time.</p>		Dust free at 20°C:	Baking at 60°C (temperature of baking item):	SLOW	50÷60 min.	25÷30 min.	STANDARD	35÷40 min.	FAST	25÷30 min.		
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	<p>SPRAYING VISCOSITY</p> <p>18÷20 seconds at 20°C/DIN4.</p>														
	<p>POT LIFE</p> <p>1.5 hours at 20°C.</p>														
	<p>GUN PARAMETERS</p> <p>Number of layers: 2 thin layers. Wet film thickness = max. 140 µm Dry film thickness = 50÷60 µm</p> <p>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.</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>												

PRODUCT EFFICIENCY

1 liter of mixture is enough to cover 10÷12 m² with a dry layer with thickness of 50÷60 µm.

SHADING

Make sure you have covered the whole area with the base coat and do the shading 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 REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the SPARK 07 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

SPARK 07 Acrylic Clear Coat 2:1	– 24 months from the date of production
EXTRA SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat	– 12 months from the date of production
SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat	– 12 months from the date of production
STANDARD hardener 1:2 for SPARK 07 Acrylic Clear Coat	– 12 months from the date of production
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PRODUCT	ART. No.
SPARK 07 Acrylic Clear Coat 2:1	7447; 8760 (1l; 5l)
EXTRA SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat	9969; 9970 (0,5l; 2,5l)
SLOW hardener 1:2 for SPARK 07 Acrylic Clear Coat	15411; 11867 (0,5l; 2,5l)
STANDARD hardener 1:2 for SPARK 07 Acrylic Clear Coat	7448; 8761 (0,5l; 2,5l)
FAST hardener 1:2 for SPARK 07 Acrylic Clear Coat	9428; 9248 (0,5l; 2,5l)

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.