

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>SPARK 57 UHS 2:1 ACRYLIC CLEARCOAT UHS 2:1</p>	
<p>PRODUCTS</p> <p>SPARK 57 Acrylic Clear Coat UHS 2:1 – Transparent Topcoat Clear Coat. STANDARD hardener 1:2 for UHS SPARK 57 Acrylic Clear Coat. FAST hardener 1:2 for UHS SPARK 57 Acrylic Clear Coat.</p>	
<p>PRODUCT DESCRIPTION</p> <p>High quality 2K acrylic transparent clear coat for fast repairs with very low content of volatile compounds. This Clear Coat was designed for car paint shops that struggle every day with the problem of quickly returning the repaired vehicles to their owners. The use of the new generation of raw materials helped to achieve fast curing time.*</p> <ul style="list-style-type: none"> • Very high contents of resin. • Very high gloss. • Excellent look of the surface. <p>*ambient temperature 20°C, air humidity not higher than 80%.</p>	<p>COLOUR: transparent</p> <p>GLOSS GRADE: high gloss</p>

VOLATILE ORGANIC COMPOUNDS	
VOC for the mixture = 355 [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: <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).

APPLICATION PROCESS																						
	<p>USE</p> <p>For quick car body paint repairs that require a durable finish.</p>		<p>EVAPORATION TIME</p> <p>Between layers: 2 minutes</p>																			
	<p>MIXING RATIO by volume</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 60%;">Clear Coat</td> <td style="width: 40%;">2 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> </table> <p>This clear coat does not require thinner!</p>	Clear Coat	2 parts	Hardener	1 part		<p>HARDENING TIME</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">Hardening time at 20° C</th> <th style="text-align: center;">STANDARD</th> <th style="text-align: center;">FAST</th> </tr> </thead> <tbody> <tr> <td>Dust dry</td> <td style="text-align: center;">30÷35 min.</td> <td style="text-align: center;">20÷25 min.</td> </tr> <tr> <td>Touch dry</td> <td style="text-align: center;">90 minutes</td> <td style="text-align: center;">60 minutes</td> </tr> <tr> <td>Before baking</td> <td style="text-align: center;">10 minutes</td> <td style="text-align: center;">10 minutes</td> </tr> <tr> <td>Baking at 60°C (temperature of baked object)</td> <td style="text-align: center;">5 minutes</td> <td style="text-align: center;">-</td> </tr> </tbody> </table> <p>Temperature below 20°C significantly increases the hardening time.</p>	Hardening time at 20° C	STANDARD	FAST	Dust dry	30÷35 min.	20÷25 min.	Touch dry	90 minutes	60 minutes	Before baking	10 minutes	10 minutes	Baking at 60°C (temperature of baked object)	5 minutes	-
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	<p>SPRAYING VISCOSITY</p> <p>19÷21 seconds at 20°C/DIN4.</p>																					
	<p>POT LIFE</p> <p>STANDARD hardener–90 minutes at 20°C FAST hardener–60 minutes at 20°C</p>																					
	<p>GUN PARAMETERS</p> <p>1.5 layers – 1 middle (thin), then full layer with distance of 2 minutes between evaporation of layers, to achieve dry film thickness of 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>5 ÷ 7 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±11 m² with a dry layer with thickness of 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 57 UHS 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 57 UHS 2:1 Acrylic Clear Coat	– 24 months from the date of production
STANDARD hardener 1:2 for SPARK 57 UHS Acrylic Clear Coat	– 12 months from the date of production
FAST hardener 1:2 for SPARK 57 UHS Acrylic Clear Coat	– 12 months from the date of production

PRODUCT	ART. No.
SPARK 57 UHS 2:1 Acrylic Clear Coat	13550; 13552 (1l; 5l)
STANDARD hardener 1:2 for SPARK 57 UHS Acrylic Clear Coat	13554; 13556 (0,5l; 2,5l)
FAST hardener 1:2 for SPARK 57 UHS Acrylic Clear Coat	14039; 14041 (0,5l; 2,5l)
SLOW hardener 1:2 for SPARK 57 UHS Acrylic Clear Coat	14038; 14040 (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.

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