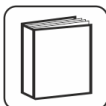
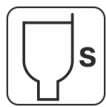
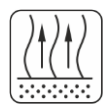


TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

HS 2:1 2K URETHANE CLEARCOAT	
PRODUCTS HS 2:1 2K Urethane Clearcoat MEDIUM Hardener 1:2 for HS 2K Urethane Clearcoat SLOW Hardener 1:2 for HS 2K Urethane Clearcoat - dedicated to temperatures higher than 25°C FAST Hardener 1:2 for HS 2K Urethane Clearcoat - dedicated to temperatures lower than 18°C Urethane Reducer MASTER	
PRODUCT DESCRIPTION High quality 2K urethane clearcoat for car repairs with low content of volatile compounds and increased Scratch Resistance. Extremely easy to apply thanks to its great fluidity, exceptional leveling and fast hardening time. Provides perfect finish and high gloss. Available hardeners: medium, fast and slow. • High solids content. • Short hardening time. • Very high gloss. • Excellent look of the coat. • Easy to apply.	
	COLOR: transparent
	GLOSS GRADE: very high gloss

VOLATILE ORGANIC COMPOUNDS	
VOC for mixture = 510 [g/l] – 4,256 [lb/gal]	
SURFACE PREPARATION	
Urethane clearcoats can be applied over: • Basecoats. • Properly cleaned and sanded OEM finishes.	For application over recommended basecoat system: • Allow basecoats sufficient dry times. • Over OEM sand finish dull with P800 or gray scuff pad.

APPLICATION PROCESS								
	USE			NUMBER OF COATS & SPRAY GUN SETTINGS				
	For car body paint repair that requires a durable finish.			2 coats: 2 full coats, total dry film thickness of approx. 60 µm (2.4 mils). Compliant (RP) spray gun: 1.3÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) HVLP spray gun: 1.3÷1.4 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar). Note: follow the gun producer's recommendations.				
	MIXING RATIO by volume			HARDENING TIME				
	Clearcoat	2 parts		<table><tr><td>Dust dry at 68°F (20°C):</td><td>15 minutes</td></tr><tr><td>Baking at 140°F (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> Temperature below 68°F (20°C) significantly increases the hardening time.	Dust dry at 68°F (20°C):	15 minutes	Baking at 140°F (60°C): (temperature of the panel)	30 minutes
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Baking at 140°F (60°C): (temperature of the panel)	30 minutes							
Ready to polish:	after drying overnight							
	SPRAYING VISCOSITY			IR DRYING				
	15÷16 seconds at 68°F (20°C)/DIN4 with 10% reducer				15÷20 minutes of short waves, , depending on the coat thickness and the type of radiator. Do not exceed 140°F (60°C). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.			
	POT LIFE							
	Approx. 2 h at 68°F (20°C)							
	EVAPORATION TIME							
	Between layers:	approx. 5÷7 minutes						
	Before banking:	approx. 5÷10 minutes						

PRODUCT EFFICIENCY

1 liter of mixture is enough to cover $8\div 10\text{ m}^2$, yielding a dry film thickness of $60\text{ }\mu\text{m}$ (2.36 mils).

POLISHING AND REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the HS MASTER 2:1 2K Urethane Clearcoat 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 59 to 77°F (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 2:1 2K Urethane Clearcoat	– 24 months from the date of production
MEDIUM Hardener 1:2 for HS 2K Urethane Clearcoat	– 12 months from the date of production
SLOW Hardener 1:2 for HS2K Urethane Clearcoat	– 12 months from the date of production
FAST Hardener 1:2 for HS 2K Urethane Clearcoat	– 12 months from the date of production
Urethane Reducer MASTER	– 24 months from the date of production

PRODUCT	ART. No.
HS 2:1 2K Urethane Clearcoat	15652; 15653 (1l; 5l)
MEDIUM Hardener 1:2 for HS 2K Urethane Clearcoat	15654; 15655 (0,5l; 2,5l)
SLOW Hardener 1:2 for HS 2K Urethane Clearcoat	15658; 15659 (0,5l; 2,5l)
FAST Hardener 1:2 for HS 2K Urethane Clearcoat	15656; 15657 (0,5l; 2,5l)
Urethane Reducer MASTER	Medium - 300010232; 300009053 (1l; 5l) Fast- 15305; 13414 (1l; 5l) Slow- 15306; 15307 (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.

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