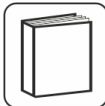
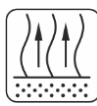
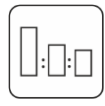
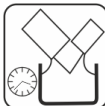


TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

HS 2:1 VOC 2.1 2K URETHANE CLEARCOAT		
PRODUCTS		
HS 2:1 VOC 2.1 2K Urethane Clearcoat MEDIUM Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat SLOW Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat - dedicated to temperatures higher than 25°C FAST Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat - dedicated to temperatures lower than 18°C Urethane Reducers VOC ZERO MASTER		
PRODUCT DESCRIPTION		
Highest quality urethane HS 2K clearcoat for fast car body repairs. Features very easy application, high durability, and the ultimate gloss and depth.		
• Excellent flow, leveling and sag resistance. • Very fast dry and polish times. • Extremely high gloss. • High hardness with anti-scratch effect.		
		COLOR: transparent
		GLOSS GRADE: very high gloss

VOLATILE ORGANIC COMPOUNDS	
VOC = 246.667 g/l – 2.0585 lbs/gal (<2.1 lbs/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			EVAPORATION TIME	
	For car body repair.			Between layers: approx. 4÷8 minutes Before baking: approx. 5÷10 minutes	
	MIXING RATIO by volume			NUMBER OF COATS & SPRAY GUN SETTINGS	
	Clearcoat	2 parts		2 coats: 2 full coats, total dry film thickness of approx. 60÷70 µm (2,36÷2,75 mils). Compliant (RP) spray gun: 1.2÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) HVLP spray gun: 1.2÷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.	
	Hardener	1 part			
	Reducer	0÷5%			
	SPRAYING VISCOSITY				
	15÷17 seconds at 20°C (68°F)/DIN4 for mixing ratio 2:1+5%.				
	POT LIFE				
	3 hour at 20°C (68°F)/DIN4.				
	HARDENING TIME at 20°C (68°F):				
	HARDENER	FLASH-OFF TIME [min]	DUST FREE [min]	DRY TO SAND [h]	READY FOR DELIVERY [h]
	FAST	5÷7	40	14	15 min/60°C (140°F)
	MEDIUM	5÷7	50	15	20 min/60°C (140°F)
	SLOW	8÷10	60	16	30 min/60°C (140°F)
	Temperature below 20°C (68°F) significantly decreases the hardening time.				

PRODUCT EFFICIENCY	
1 liter of mixture is enough to cover approx. $8,0 \div 8,5 \text{ m}^2$ (86,1÷91,5 ft²), yielding a dry film thickness of 60 µm (2.36 mils).	
POLISHING AND REMOVING IMPURITY INCLUSIONS	
Usually polishing is unnecessary, as the HS VOC 2.1 2K Urethane clearcoat 2:1 gives the surface a perfect look immediately after having been used. However, if some dirt inclusions appear, one recommends removing them wet, using abrasive paper with gradation of 1500-2000 and then polishing the surface with abrasive compound.	
The easiest way of polishing 2K-surfaces is to do it 6÷24 hours after the film cooled down.	
GENERAL NOTES	
• Do not exceed recommended doses of the hardener! • Using such clear coats one shall remember of spraying first the edges and cavities and leaving front surfaces for the last stage of application process. Thus we can avoid superfluous dust creation and achieve smooth surface. • Best results of application are achieved when using a professional chamber-oven, or when varnishing in a room specially suited for this goal, at least at room temperature, i.e. at 20°C (68°F). • 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: <i>To maintain safety, always follow the instructions given in the MSDS for the products.</i>	
STORAGE	
Store the product between 15 to 25°C (59 to 77°F), 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 VOC 2.1 2K Urethane Clearcoat	– 24 months from the date of production
Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat	– 12 months from the date of production
Urethane Reducer VOC ZERO	– 24 months from the date of production

PRODUCT	ART. No.
HS 2:1 VOC 2.1 2K Urethane Clearcoat	16450 (1l); 16433 (5l)
MEDIUM Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat	16451 (0,5l); 16434 (2,5l)
FAST Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat	16557 (0,5l); 16507 (2,5l)
SLOW Hardener 1:2 for HS VOC 2.1 2K Urethane Clearcoat	16556 (0,5l); 16508 (2,5l)
Urethane Reducer MEDIUM VOC ZERO	8562; 8561 (1l; 5l)
Urethane Reducer FAST VOC ZERO	7868; 8557 (1l; 5l)
Urethane Reducer SLOW VOC ZERO	2289; 9235 (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.