

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

HS MASTER HS Acryl Clear Coat 2:1

PRODUCTS

HS MASTER Acryl Clear Coat 2:1
Hardener 1:2 for HS MASTER Acryl Clear Coat
Thinner for acrylic systems
EXPRESS Thinner for acrylic systems

PRODUCT DESCRIPTION

High quality 2-pack acrylic clear coat for quick car repairs with low content of volatile compounds.

- ✓ High content of solid.
- ✓ Short hardening time.
- ✓ Very high gloss.
- ✓ Excellent coat appearance.

Color - Colorless.

Gloss Grade – High gloss.

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 540 [g/l]

The share of VOC is below 840 g/l. Due to that these products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (B/5), as 840 g/l.

SUBSTRATES AND PREPARATION

Master Acryl Clear Coat 2:1 can be applied over:

- ✓ Base Coats.
- ✓ The existing Coatings.

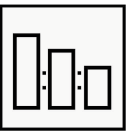
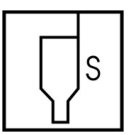

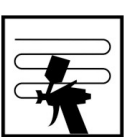
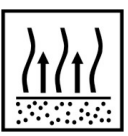

Existing Paintwork should first be sanded and cleaned with Silicon Remover.



For dulling the color we recommend the following :

- ✓ Grey unwoven abrasive fabric with a dulling paste,
- ✓ Abrasive paper with gradation of 600÷800 (for dulling on wet).
- ✓ Abrasive paper with gradation of 360÷400 (for dulling by machine).

APPLICATION PROCESS

	Standard System <i>Big surfaces</i>	Express System <i>Small panels</i>
 MIXING RATIO	Clear Coat 2 Hardener 1 Thinner max.10%	Clear Coat 2 Hardener 1 Express Thinner max.10%
 VISCOSITY	15÷16 seconds at 20°C, with 10% of thinner	15÷16 seconds at 20°C, with 10% of Express thinner
 POT LIFE	approx. 7 hours w 20°C	45 minutes at 20°C
 NOZZLE	Gravity: 1.3÷1.4 mm. Pressure: – According to gun`s producer recommendations. Number of layers: 1 and half or 2 full coats. Dry film thickness: approx. 60 µm.	
	Evaporation time	
	Between layers: Before baking:	approx. 5÷7 minutes approx. 5÷10 minutes
	<u>Hardening time at 20°C</u> Dust free - 10÷12 minutes Tack free – 6÷8 hours <u>Hardening time at 60°C:</u> 25 minutes	<u>Hardening time at 20°C</u> Dust free - 8÷10 minutes Tack free – 2 hours <u>Hardening time at 60°C:</u> 10 minutes
	Temperature below 20°C significantly increases hardening time	

PRODUCT EFFICIENCY

1 liter of the mixture is enough to get approx. $7.5 \div 8.0 \text{ m}^2$ of 60 μm thickness dry layer.

Mixing according to the mass (do not rate the scales!!)

Total	Clear Coat	Clear Coat + Hardener	Clear Coat + Hardener + Thinner (10%)
100 ml	67 g	100 g	109 g
150 ml	100 g	149 g	163 g
200 ml	133 g	199 g	217 g
250 ml	166 g	249 g	272 g
350 ml	233 g	349 g	380 g
450 ml	299 g	448 g	489 g
550 ml	366 g	548 g	597 g
650 ml	432 g	648 g	706 g
750 ml	499 g	747 g	815 g
1,0 L	665 g	996 g	1086 g
1,5 L	998 g	1495 g	1630 g
2,0 L	1331 g	1993 g	2173 g
2,5 L	1663 g	2491 g	2716 g

POLISHING AND REMOVING IMPURITIES INCLUSIONS

Usually polishing is unnecessary, as the Master Clear Coat 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-clear coats is to do it 6-24 hours after the film cooled down.

GENERAL NOTES

- ✓ Do not exceed recommended doses of 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.
- ✓ Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

Caution: To maintain safety, always follow the instructions given in the MSDS for the product.

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *After each use the container with products shall be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

HS MASTER Acryl Clear Coat 2:1- 12 months from the date of Manufacture.

Hardener 1:2 for HS MASTER Acryl Clear Coat – 6 months from the date of Manufacture.

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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