

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### C38VHS 2:1

ACRYL CLEAR COAT

#### PRODUCTS

Acryl Clear Coat C 38 VHS 2:1  
 Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS  
 Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS  
 Thinner for acrylic systems

#### PRODUCT DESCRIPTION

High quality 2-component acrylic clearcoat for car repairs with a very low content of volatile compounds.

- For the repair of small and large surfaces.
- Very high solid content > 55%.
- Excellent coat appearance.
- High gloss.
- Easy to apply.
- Ideal absorption of spray mist.
- Excellent flow.

\* ambient temperature 20°C, air humidity not higher than 80%.



**COLOUR:** transparent

**GLOSS GRADE:** high gloss

#### VOLATILE ORGANIC COMPOUNDS

VOC for the mixture 2:1 without thinner = 385 [g/l],

VOC for the mixture 2:1 with 5% of thinner = 405 [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:

- Base Coats,
- Old finishes in good condition after matting and degreasing.

For matting we recommend the following:

- 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

USE		NUMBER OF LAYERS																
	Paint repairs on small and large surfaces.		<p><b>1.5 layers</b> – 1 medium (thin) and then a full layer with 2 minutes of flash off between the layers in order to obtain a dry film thickness of 50-60 µm.</p> <p><b>2 layers:</b> 2 full layers, total dry film thickness of 60÷75 µm.</p> <p><b>Gun parameters:</b>                      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><b>MIXING RATIO</b> by volume</p> <p>Clear Coat 2 parts                      Hardener 1 part                      Thinner: 0÷5%</p>		<p><b>HARDENING TIME</b></p> <p>STANDARD Hardener</p> <table border="1"> <thead> <tr> <th></th> <th>20°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>Dust dry</td> <td>40 min.</td> <td>10 min.</td> </tr> <tr> <td>Touch dry</td> <td>3 h</td> <td>15 min.</td> </tr> <tr> <td>Hardness to use</td> <td>13 h</td> <td>15 min. + 4 h/20°C</td> </tr> <tr> <td>Total hardness</td> <td>7 days</td> <td>15 min. + 4 h/20°C</td> </tr> </tbody> </table> <p>Temperature below 20°C significantly increases the hardening time.</p>		20°C	60°C	Dust dry	40 min.	10 min.	Touch dry	3 h	15 min.	Hardness to use	13 h	15 min. + 4 h/20°C	Total hardness	7 days	15 min. + 4 h/20°C
	20°C	60°C																
Dust dry	40 min.	10 min.																
Touch dry	3 h	15 min.																
Hardness to use	13 h	15 min. + 4 h/20°C																
Total hardness	7 days	15 min. + 4 h/20°C																
	<p><b>SPRAYING VISCOSITY</b></p> <p>17÷19 seconds at 20°C/DIN4.</p>		<p><b>IR DRYING</b></p> <p>10÷15 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>															
	<p><b>POT LIFE</b></p> <p>Hardener STANDARD: 3.5 hours at 20°C                      Hardener FAST: 2 hours at 20°C</p>																	
	<p><b>EVAPORATION TIME</b></p> <table border="1"> <thead> <tr> <th></th> <th>STANDARD</th> <th>FAST</th> </tr> </thead> <tbody> <tr> <td>Between layers:</td> <td>5÷10 min.</td> <td>5÷10 min.</td> </tr> <tr> <td>Before baking:</td> <td>10 min.</td> <td>10 min.</td> </tr> </tbody> </table>		STANDARD	FAST	Between layers:	5÷10 min.	5÷10 min.	Before baking:	10 min.	10 min.								
	STANDARD	FAST																
Between layers:	5÷10 min.	5÷10 min.																
Before baking:	10 min.	10 min.																

**PRODUCT EFFICIENCY**

1 liter of mixture is enough to cover 10 m<sup>2</sup> with a dry layer with thickness of 60 µm.

**POLISHING AND REMOVING IMPURITY INCLUSIONS**

Usually polishing is unnecessary, as the C38 VHS Clear Coat 2:1 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 hardener!
- Best results achieved at room temperature. The ambient temperature and the temperature of the used product should be the same.
- When working with 2K products, it is recommended to use personal protective equipment. Protect the eyes and the 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 product.*

**STORAGE**

Store the product components between 15 and 25°C, in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Caution:**

1. Close the containers immediately after application.
2. Protect hardener against freeze and humidity!

**WARRANTY PERIOD**

Acryl Clear Coat C 38 VHS 2:1	– 24 months from the date of production
Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS	– 12 months from the date of production
Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS	– 12 months from the date of production
Thinner for acrylic systems	– 12 months from the date of production

<b>PRODUCTS</b>	<b>ART. No.</b>
Acryl Clear Coat C 38 VHS 2:1	13090; 13092 (1l; 5l)
Hardener STANDARD 1:2 for Acryl Clear Coat C 38 VHS	13091; 13093 (0,5l; 2,5l)
Hardener FAST 1:2 for Acryl Clear Coat C 38 VHS	13101; 13102 (0,5l; 2,5l)
Hardener SLOW 1:2 for Acryl Clear Coat C 38 VHS	14268; 14269 (0,5l; 2,5l)
Thinner for acrylic systems	300002253; 300002790 (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.