

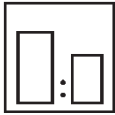


PROFESSIONAL QUALITY

Automotive Clearcoat



VOC 4.2 CLEARCOAT



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Description:

Two-pack high build VOC compliant Clearcoat. It has excellent gloss and flow characteristics. **METALUX 2** VOC 4.2 Clearcoat ensures a higher film build after application of only two coats. This means substantial savings in both application time and product usage. Designed for spot and panel application over basecoat. **METALUX 2** VOC 4.2 Clearcoat has a VOC of <4.2 lbs/gal.

Product and Additives:

METALUX 2 VOC 4.2 Clearcoat, 9700
METALUX 2 MS Hardener Fast, 9091/
Medium, 9092/Ultra Fast, 9082

} *Note: Own special Hardener*

Special Additives:

METALUX 2 2K Matting Base, 8794
METALUX 2 Softflex Additive, 8795

Basic Raw Materials:

METALUX 2 VOC 4.2 Clearcoat :acrylic resin
METALUX 2 Ultrafast Hardener :poly-isocyanate resin

Suitable Substrates:

METALUX 2 VOC 4.2 Clearcoat has been designed to be applied over **METALUX 2** Basecoat.

Mixing Ratio:

100 parts by volume of **METALUX 2** VOC 4.2 Clearcoat
50 parts by volume of **METALUX 2** Ultra Fast Hardener
Accelerator not recommended
Plastic Parts
- Softflex additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic).
Next add the Hardener.

Pot Life:

When mixed 3 hours at 25°C
Do not try to thin clear after thickening has occurred.
Do not use.
Note: Accelerators and temperature will affect pot life.

Process:

As an overall or full-panel clearcoat
- Allow basecoat to dry for 15 minutes
- Apply one medium wet coat and then
- Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum). Excessive amounts of clear will retard drying and curing, and may cause die-back.
- A 3rd coat may be applied if extensive sanding and polishing is anticipated.
- Do not apply more clear after 1 hour of applying previous coats of clear.

Full Bake Cycle For Heavy Buffing/Compounding or Assembly

- No purge time is necessary.
- Bake 30-35 minutes at 60°C.
- Allow a 1-2 hour cool down prior to assembling or buffing.
- Do not bake basecoat prior to clearing adhesion loss between colour and clear may occur.

Quick Bake Cycle For Light Polishing or Out of Dust

- No purge time is necessary
- Bake 10-15 minutes at 60°C
- Allow a 1-2 hour cool down prior to assembling of buffing.



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VOC 4.2 CLEARCOAT - Continued



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Special Notes

- Use in shop temperatures that are maintained above 25°C for the first 24 hours of cure cycle.
- Ensure surfaces are up to shop temperature prior work.
- Use a mixing cup for accurate volume measurements.
- **METALUX 2** VOC 4.2 Clearcoat will be water resistant in 24 hours. Note: Do not allow raindrops to dry on a new finish for 3-4 days to prevent staining.
- Urethane coatings take 5-7 days to properly cure. Care should be taken during first week of washing. Do not use a pressure washer on fresh clear.
- Do not use over lacquer.

Spray Gun Settings: Gravity Feed: 1.2mm - 1.5mm 3 - 4 bar
Syphon Feed: 1.8mm - 2.2mm 3 - 4 bar

Film Build: 25 30 micron per coat for MS Clear

Cleaning of Equipment: Clean equipment immediately after use with lacquer thinners.

Drying Time: Dust Free - 15 mins @ 25°C
Dry to Polish - 1,5 hours @ 25°C
Dry to Buff - 6-8 hours @ 25°C
Force Dry - 15 mins @ 60°C metal (light polish)
35 mins @ 60°C metal (heavy buffing)

Health & Safety: Refer to text on label.
Flammable - keep away from sources of ignition.
No smoking.
Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.