

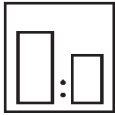


PROFESSIONAL QUALITY

Automotive Clearcoat



2K MS CLEARCOAT



2:1
10-20%
2K Thinner



Visc.
15-18 Secs



Description:

Two-pack high build medium solids clear coat formulated for the **METALUX 2** basecoat system. It has excellent gloss and flow characteristics. **METALUX 2** MS Clear ensures a higher film build after application of only two coats. This means substantial savings in both application time and product usage.

Product and Additives:

METALUX 2 2K MS Clearcoat, 9090
METALUX 2 MS Hardener Fast, 9091 / Medium, 9092 / Slow, 9093 / Ultra Fast, 9082
Note: Own Special Hardener
METALUX 2 Thinner Normal, 1159 / Fast, 1177 / Slow, 1171

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784
METALUX 2 Soft Flex Additive, 8795

Basic Raw Materials:

METALUX 2 Clear: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K MS Clearcoat has been designed to be applied over **METALUX 2** Basecoats.

Mixing Ratio:

100 parts by volume of **METALUX 2** 2K MS Clearcoat
50 parts by volume **METALUX 2** MS Hardener of your choice
Thin 10-20% with **METALUX 2** 2K Thinner to 15-18 secs
Ford 4 @ 25°C

Note: For the Ultra Fast system (9082).

Mix 100 parts by volume **METALUX 2** 2K MS Clearcoat
50 parts by volume **METALUX 2** 2K Ultra Fast
50 parts by volume **METALUX 2** 2K Thinners

METALUX 2 Accelerator. Add 2% to 5%. Next add hardener and thinner as specified (not recommended for with Ultra Fast Hardener)

Plastic Parts Softflex Additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic). Next add hardener and thinner as specified.

Pot Life:

When mixed 4 hours @ 25°C for 9091, 9092 & 9093
When mixed 3 hours @ 25°C for 9082

Process:

Apply two single wet coats with 5 10 minutes flash off between coats for **METALUX 2** 2K MS Clearcoat.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	3 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	3 - 4 bar

Film Build:

25 30 micron per coat for MS Clear.

Cleaning of Equipment:

Use lacquer thinners



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2K MS CLEARCOAT - Continued



2:1
10-20%
2K Thinner



Visc.
15-18 Secs



Drying Time:

Dust free	30 min @ 25°C
Hard Dry	24 hours @ 25°C
Recoat able	after full cure (± 7 days @ 25°C)
Force dry	45 min @ 60°C metal when using 9091, 9092 & 9093
	15 min @ 60°C metal when using 9082

Health & Safety:

Ref 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.