

## HS MASTER HS Acrylic Clear Coat 2:1

### PRODUCTS

## TECHNICAL INFORMATION

### FOR PROFESSIONAL USE ONLY



HS MASTER Acrylic Clear Coat 2:1

Hardener 1:2 for HS MASTER Acrylic Clear Coat

Hardener 1:2 for HS MASTER Acrylic Clear Coat- dedicated for temperatures higher than 25°C

Hardener 1:2 for HS MASTER Acrylic Clear Coat- dedicated for temperatures lower than 18°C.

Thinner for acrylic systems

EXPRESS Thinner for acrylic systems

### PRODUCT DESCRIPTION

High quality 2K 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.
- ✓ Easy to apply

Color -Transparent .

Gloss Grade – High gloss.

### VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 510 [g/l]

The share of VOC is below 840 g/l. These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIB), at 840 g/l.

## SURFACE PREPARATION



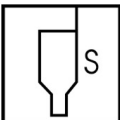
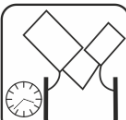
Master Acrylic Clear Coat 2:1 can be applied over:




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

For dulling the color we recommend the following :

- ✓ Grey abrasive cloth with matting compound.
- ✓ Sanding paper with gradation of 600÷800 (for dulling on wet).
- ✓ Sanding paper with gradation of 360÷400 (for dulling by machine).

## APPLICATION PROCESS

	<p><b>Use</b> Car body repairs that require a durable finish.</p>								
	<table border="0"> <tr> <td><b>Mixing Ratio</b></td> <td>By Volume</td> </tr> <tr> <td>HS Clear Coat</td> <td>2</td> </tr> <tr> <td>Hardener to HS clear coat</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>Max.10%</td> </tr> </table>	<b>Mixing Ratio</b>	By Volume	HS Clear Coat	2	Hardener to HS clear coat	1	Thinner	Max.10%
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HS Clear Coat	2								
Hardener to HS clear coat	1								
Thinner	Max.10%								
	<p><b>Spraying Viscosity</b> 15÷16 seconds at 20°C. With 10% thinner</p>								
	<p><b>Pot Life</b> Approximately 2 hours at 20°C.</p>								

	<p><b>Number of layers:</b> 2 full layers, total dry thickness approx. 60 µm</p> <p><b>RP gun parameters:</b> Nozzle: 1,3÷1,4 mm, Pressure: 2,0÷2,2 bar</p> <p><b>HVLP gun parameters:</b> Nozzle: 1,3÷1,4 mm; Pressure: 2,0 bar</p> <p>Follow gun producer's instructions.</p>
	<p><b>Evaporation Time</b></p> <p>Between Layers: approx. 5÷7 minutes Before Baking: approx. 5÷10 minutes Temperature below 20°C significantly increases the hardening time.</p>
	<p><b>IR Drying</b></p> <p>10÷20 minutes of short waves, depending on the thickness of the layer and IR dryer.</p>

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

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

**EFFICIENCY**

1 liter of mixture is enough to cover a surface of 8-10 m<sup>2</sup> with a 60µm thick dry layer.

**SHADING**

Make sure you have covered the whole area with the base coat and do the shading only on a previously prepared area. Use FADE OUT THINNER to blend the dust that has settled around the repaired surface and to eliminate optical gloss differences between the old lacquer and the newly applied acrylic clear coat.

**POLISHING AND ELIMINATING DEFECTS**

Usually polishing is unnecessary, as the HS Master Acrylic Clear Coat gives the surface a perfect look immediately after use. However, if some dirt inclusions appear, it is recommended to remove them wet, using sanding paper with gradation of 1500-2000 and then polish the surface with polishing compound.

The easiest way of polishing 2K surfaces is to do it within 24 hours after the coat has cooled down.

**GENERAL NOTES**

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ 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 should be immediately closed! Protect the hardener against freeze and humidity!*

**WARRANTY PERIOD**

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

Hardener Standard 1:2 for HS MASTER Acrylic Clear Coat – 9 months from the date of Manufacture.

Hardener Slow 1:2 for HS MASTER Acrylic Clear Coat – 9 months from the date of Manufacture.  
Hardener Fast 1:2 for HS MASTER Acrylic Clear Coat – 9 months from the date of Manufacture.

**Important Information:**

The information contained in this document corresponds to our present knowledge and is a guide to our products and their uses.

Read all directions and warnings prior to using Troton products - Safety Data Sheets can be found online at [www.troton.com.pl](http://www.troton.com.pl) or will be sent according to your request: [troton@troton.com.pl](mailto:troton@troton.com.pl)

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If used as instructed, this product is designed to comply with the European Volatile Organic Compound (VOC) Emission Standard for Automotive Refinish Coatings. Confirm compliance with your country, state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Troton assumes no obligation or liability for use of this information.