



TECHNICAL DATA SHEET No. 30

## ACRYLIC CLEARCOAT CLASSIC 2K HS 2:1

*Product intended for professional use.*

### PRODUCT RANGE:

43 192	Acrylic clearcoat CLASSIC 2K HS 2:1 500 mL
43 194	Hardener CLASSIC Normal 1:2 250 mL
43 195	Hardener CLASSIC Fast 1:2 250 mL
43 140	Acrylic clearcoat CLASSIC 2K HS 2:1 1 L
43 142	Hardener CLASSIC Normal 1:2 500 mL
43 212	Hardener CLASSIC Fast 1:2 500 mL
43 227	Acrylic clearcoat CLASSIC 2K HS 2:1 5 L
43 229	Hardener CLASSIC Normal 1:2 2.5 L
43 228	Hardener CLASSIC Fast 1:2 2.5 L
43 146	Thinner for acrylic products 500 mL
43 230	Thinner for acrylic products 5 L

### CHARACTERISTICS:

An acrylic HS clearcoat with a high solids content. It is characterized by an optimum hardness and excellent gloss. Resistance to UV rays and changing weather conditions guarantees excellent coat appearance and durability. A good flow and fast drying enable easy renovation and reduce the vehicle's time in the painting chamber. Problem-free polishing using generally available polishing systems. Recommended for overhauls and local repairs. Offered in two versions: with normal or fast hardener. The choice of the right hardener depends on the application conditions.

### PHYSICAL AND CHEMICAL PROPERTIES:

Colourless liquid with a solvent-ester smell. Volatile organic compounds content in ready-to-use product < 840 g/L.

### APPLICATIONS

#### SUBSTRATE:

- solvent-borne basecoats,
- water-borne basecoats,
- paint coatings,
- plastics,
- wood.



### PRODUCT PREPARATION:

INGREDIENTS:		MIXING PROPORTIONS BY VOLUME	
		Without thinner	With thinner
	CLASSIC clearcoat	2	2
	CLASSIC hardener	1	1
	POLFILL thinner for acrylic products	0%	5%
Mix the clearcoat with hardener thoroughly; if necessary, add POLFILL thinner for acrylic products; mix until a homogeneous consistency.			
<b>Do not exceed the recommended amounts of thinner and hardener.</b>			

### HARDENER USED:

Normal or Fast Classic hardener sold together with the clearcoat.

### SPRAY VISCOSITY:

AMOUNT OF THINNER ADDED	SPRAY VISCOSITY ACHIEVED
	0% 5%
	16 - 17 s, Ø 4/20°C 15 - 16 s, Ø 4/20°C

### APPLICATION:

	Apply with a spray gun equipped with a 1.2 - 1.4 mm diameter nozzle at the pressure recommended by the equipment manufacturer. Number of layers: 2
	Mixture pot life: up to 60 minutes at 20°C.
	Evaporation time between layers: 10 - 12 minutes at 20°C.

### APPLICATION CONDITIONS:

Use at temperatures from 10°C to 28°C and relative humidity ≤ 75%



**DRYING TIME:**

	Dust dry:	30 minutes at 20°C	
		3 minutes at 50°C	
	Usable hardness:	20°C - 14 hours	
		60°C - 35 minutes	
	IR heater	Flash-off	4 minutes
		Full-bake	2 x 8 minutes*
		* Complete the procedure, then cool the processed part down to the ambient temperature, and repeat the full-bake process.	
	Full cure:	3 - 4 days	
<b>Temperatures below 20°C extend the curing time.</b>			

**CLEANING THE EQUIPMENT:**

Clean the equipment immediately after work.

POLFILL NITRO thinner  
 POLFILL thinner for ACRYLIC PRODUCTS

**STORAGE:**

Store in original, tightly closed containers, in a dry, cool place, away from sources of heat and ignition, at a temperature 5 to 25°C. Do not expose to direct sunlight.

**WARRANTY PERIOD:**

The warranty period is given on the product label.

**HEALTH & SAFETY RECOMMENDATIONS:**

Product safety data sheet and applicable health and safety regulations for working with chemical agents.

*The information contained in this sheet has been developed based on our knowledge and practice. However, no individual product properties can be guaranteed under different conditions of use beyond our control. Therefore, we cannot accept full responsibility for the results obtained in specific conditions of use. It is necessary to test the application of the product on a small area, due to the potential differences in the product performance depending on the substrate on which it is applied. We guarantee proper quality when used in accordance with the instructions contained in this Technical Data Sheet.*