TECHNICAL DATA SHEET No. 77

ACRYLIC CLEARCOAT
RACER EVOLUTION 2K HS 2:1

Product intended for professional use.

PRODUCT RANGE:

43 385	Acrylic clearcoat RACER Evolution 2K HS 2:1; 500 mL
43 388	Hardener RACER Evolution 1:2; 250 mL
43 386	Acrylic clearcoat RACER Evolution 2K HS 2:1; 1 L
43 389	Hardener RACER Evolution 1:2; 500 mL
43 230	Thinner for acrylic products 5 L
43 146	Thinner for acrylic products 500 mL

CHARACTERISTICS:

Fast-drying HS-class acrylic clearcoat designed for quick paint work repairs. It is characterized by very good drying parameters and high hardness whilst maintaining adequate flexibility and excellent gloss. Racer Evolution clearcoat proves its value at lower ambient temperatures and the time to obtain final performance parameters of the coat is only about 4 hours after painting, which means that the vehicle's stay time in the repair can be significantly reduced. Recommended for partial and SMART repairs.
Racer Evolution clearcoat is easy to apply and polish with generally available polishing systems. Resistance to UV rays and changing weather conditions guarantees an excellent appearance of the painted shell. Available with a dedicated Racer Evolution hardener. Suggested number of layers: 1.5 – 2.

PHYSICAL AND CHEMICAL PROPERTIES:

Colourless liquid with an aromatic, sweet smell.
Volatile organic compounds content in ready-to-use product < 840 g/L.

APPLICATIONS:

SUBSTRATE:

- solvent-borne basecoats,
- water-borne basecoats,
- plastics,
- cured varnish coatings,
- wood.

LERG SA
Pustków-Osiedle 59d
39-206 Pustków 3
Poland

CUSTOMER SERVICE
tel.: +48 (14) 680 62 85
e-mail: polfill@lerg.pl
www.polfill.pl

PRODUCT PREPARATION:

INGREDIENTS:		**MIXING PROPORTIONS BY VOLUME**
	RACER Evolution clearcoat	2
	RACER Evolution 1:2 hardener	1
	POLFILL thinner for acrylic products	0 – 10%. Up to 20% for spot repairs.
Mix the clearcoat with curing agent thoroughly; if necessary, add POLFILL thinner for acrylic products; mix until a homogeneous consistency.		
Do not exceed the recommended amounts of thinner and hardener. ***Do not add an accelerator for acrylic products***		

HARDENER USED:

RACER Evolution hardener sold together with the clearcoat**.**

SPRAY VISCOSITY:

AMOUNT OF THINNER ADDED		**SPRAY VISCOSITY ACHIEVED**
	0% 5% 10%	18 - 20 s, Ø 4/20°C 17 - 18 s, Ø 4/20°C 16 - 17 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: 1.5 – 2
	Mixture pot life: 15 - 20 minutes at 20°C.
	Evaporation time between layers: 5 - 6 minutes at 20°C.

APPLICATION CONDITIONS:

Use at temperatures from 8°C to 25°C and relative humidity ≤ 75%. Above 25°C, limit the use to spot repairs only.

DRYING TIME:

	Dust dry:	15 minutes at 20°C	
	Usable hardener:	4 - 6 hours at 20°C	
		40°C - 20-25 minutes (and after the ambient temperature has been reached). Wait 10-12 minutes before flashing off. Do not exceed 40°C	
	IR heater	Flash-off	3 minutes
		Full-bake	2 x 4-5 minutes*
		* Complete the procedure, then cool the processed part down to the ambient temperature, and repeat the full-bake process.	
	Full cure:	2 - 3 days	
	Temperatures below 20°C extend the curing time.		

NOTE:

Fast-drying product. When spray-painting, strictly follow the recommendations of the equipment manufacturer. Incorrect application parameters (pressure, distance) or too intensive a drying process can lead to coat paint defects, such as sinkage (loss of gloss). In ambient temperatures above 26°C, the use of the clearcoat should be limited to spot repairs only.

CLEANING THE EQUIPMENT:

Clean the equipment immediately after work, using:

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.