

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>SPARK 27 ACRYLIC CLEARCOAT UHS 2:1</p> <p>PRODUCTS</p> <p>SPARK 27 Acrylic Clear Coat UHS 2:1 – transparent topcoat Clear Coat STANDARD hardener 1:2 for SPARK 27 Acrylic Clear Coat FAST hardener 1:2 for SPARK 27 Acrylic Clear Coat</p> <p>PRODUCT DESCRIPTION</p> <p>High quality 2K acrylic transparent clear coat for fast repairs with low content of volatile compounds.</p> <ul style="list-style-type: none"> • Small and large body car repair. • Very high content of solids >55%. • Excellent coat look. • High gloss. • Easy application. • Very good absorption of spray mist. • Excellent flow. <p>* ambient temperature 20oC, humidity not higher than 80%.</p>	
	COLOUR: transparent
	GLOSS GRADE: high gloss

VOLATILE ORGANIC COMPOUNDS	
VOC for 2:1 the mixture - 385 g/l VOC for 2:1 the mixture 2:1 + 5% of thinner - 405 g/l This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (d), at 420 g/l.	
SURFACE PREPARATION	
Acrylic Clear Coats can be applied over: <ul style="list-style-type: none"> • Base Coats, • Old finishes in good condition after matting and degreasing. 	For matting we recommend the following: <ul style="list-style-type: none"> • grey abrasive fabric with a polishing compound, • sanding paper with gradation of 600÷800 (wet sanding), • sanding paper with gradation of 360÷500 (machine sanding).

APPLICATION PROCESS																		
	USE		EVAPORATION TIME															
	For quick car body repairs that require a durable finish.		<table border="1" style="width: 100%;"> <thead> <tr> <th></th> <th style="text-align: center;">STANDARD</th> <th style="text-align: center;">FAST</th> </tr> </thead> <tbody> <tr> <td>Between layers:</td> <td style="text-align: center;">5÷10 min.</td> <td style="text-align: center;">5÷10 min.</td> </tr> <tr> <td>Before baking:</td> <td style="text-align: center;">10 min.</td> <td style="text-align: center;">10 min.</td> </tr> </tbody> </table>		STANDARD	FAST	Between layers:	5÷10 min.	5÷10 min.	Before baking:	10 min.	10 min.						
	STANDARD	FAST																
Between layers:	5÷10 min.	5÷10 min.																
Before baking:	10 min.	10 min.																
	MIXING RATIO by volume		NUMBER OF LAYERS															
	<table border="1" style="width: 100%;"> <tbody> <tr> <td>Clear Coat</td> <td style="text-align: center;">2 parts</td> </tr> <tr> <td>Hardener</td> <td style="text-align: center;">1 part</td> </tr> <tr> <td>Thinner</td> <td style="text-align: center;">0÷5%</td> </tr> </tbody> </table>	Clear Coat	2 parts	Hardener	1 part	Thinner	0÷5%		<p>1.5 layers – 1 middle (thin), then full layer with distance of 2 minutes between evaporation of layers, to achieve dry film thickness of 50-60 µm.</p> <p>2 layers – 2 full layers with evaporation time of 5-10 minutes, to achieve dry film thickness of 60-75 µm.</p>									
Clear Coat	2 parts																	
Hardener	1 part																	
Thinner	0÷5%																	
	SPRAYING VISCOSITY		Gun parameters:															
	17÷19 seconds at 20°C/DIN4.		RP nozzle: 1.2÷1.4mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.3÷1.4mm; Inlet pressure: 2.0 bars. Note: follow the gun producer's recommendations.															
	POT LIFE		IR DRYING															
	STANDARD hardener – 3.5 hours at 20°C FAST hardener – 2 hours at w 20°C		10 ÷ 15 minutes of short waves, depending on the layer thickness and the type of radiator. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.															
	HARDENING TIME																	
	<table border="1" style="width: 100%;"> <thead> <tr> <th></th> <th style="text-align: center;">20 °C</th> <th style="text-align: center;">60°C</th> </tr> </thead> <tbody> <tr> <td>Dust dry</td> <td style="text-align: center;">40 min.</td> <td style="text-align: center;">10 min.</td> </tr> <tr> <td>Touch dry</td> <td style="text-align: center;">3 hours</td> <td style="text-align: center;">15 min.</td> </tr> <tr> <td>Hardness to use</td> <td style="text-align: center;">13 hours</td> <td style="text-align: center;">15 min. + 4 hours /20°C</td> </tr> <tr> <td>Total hardness</td> <td style="text-align: center;">7 days</td> <td style="text-align: center;">15 min. + 4 days/20°C</td> </tr> </tbody> </table> Temperature below 20°C significantly increases the hardening time.		20 °C	60°C	Dust dry	40 min.	10 min.	Touch dry	3 hours	15 min.	Hardness to use	13 hours	15 min. + 4 hours /20°C	Total hardness	7 days	15 min. + 4 days/20°C		
	20 °C	60°C																
Dust dry	40 min.	10 min.																
Touch dry	3 hours	15 min.																
Hardness to use	13 hours	15 min. + 4 hours /20°C																
Total hardness	7 days	15 min. + 4 days/20°C																

PRODUCT EFFICIENCY

1 liter of mixture is enough to cover 10 m² with a dry layer with thickness of 60 µm.

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 REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the SPARK 27 UHS 2:1 Acrylic Clear Coat gives the surface a perfect look immediately after application. However, if some dirt inclusions appear, we recommend removing them and then polishing the surface with an abrasive compound.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use the container with product should be immediately closed.
2. Protect the hardener from frost and dampness!

WARRANTY PERIOD

SPARK 27 Acrylic Clear Coat UHS 2:1	– 24 months from the date of production
STANDARD hardener 1:2 for SPARK 27 Acrylic Clear Coat	– 12 months from the date of production
FAST hardener 1:2 for SPARK 27 Acrylic Clear Coat	– 12 months from the date of production

PRODUCT	ART. No.
SPARK 27 Acrylic Clear Coat UHS 2:1	13549; 13551 (1l; 5l)
STANDARD hardener 1:2 for SPARK 27 Acrylic Clear Coat	13553; 13555 (0,5l; 2,5l)
FAST hardener 1:2 for SPARK 27 Acrylic Clear Coat	14035; 14037 (0,5l; 2,5l)
SLOW hardener 1:2 for SPARK 27 Acrylic Clear Coat	14034; 14036 (0,5l; 2,5l)

LIMITATION OF LIABILITY

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

TROTON Sp. z o.o.
Ząbrowo, Poland.