

Technical Data Sheet

Properties:

Low-solvent 2-component clearcoat. The product is characterized by the following properties:

- complies with VOC guidelines 2004/42/EG[2004/42/2B(d)(420)]
- easy to use
- optimal processability even under unfavourable booth conditions
- very high solid content
- high stability
- excellent resistance to weathering
- very good resistance to yellowing
- adjustable to very fast drying times
- very high efficiency
- excellent flow properties
- can be easily polished once cured
- high gloss level

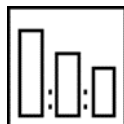
Application Area:

An UHS clear coat for apply on all degreased and sanded old paintworks, two-pack paints, base coats and polyester laminates for use on

- spot repair
- partial painting
- complete repainting

Instructions for Use:

1. Existing finishes must be cleaned, degreased and flat with P1200 – P1500.
2. Pre- and post cleaning with anti-silicone degreaser.

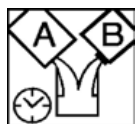


3. Mixing ratio
In volume
100 parts
50 parts
0 - 20 %

Turbo Gloss
Hardener
Thinner normal or fast



4. Mix thoroughly in a suitable mixing cup.



5. Pot life normal hardener: 60 minutes at 20°C and 65% RH
Pot life fast hardener: 45 minutes at 20°C and 65% RH



6. Gun setups & air pressure

	Nozzle size:	Spray pressure:
Compliant	1.2 - 1.3 mm	1.8 - 2.2 bar (spray pressure)*
HVLP	1.3 - 1.4 mm	0.7 bar (atomising pressure)*

*Refer to the manufacturer's directions for gun specific recommendations.

Technical Data Sheet



7. 2 layers
Apply a medium-wet coat followed by a full-wet coat. Wait about 10 minutes between each coat.



8. Flash before booth or force dry 10 minutes (depending on the heating cabine).



9. Dry times
Normal hardener: 120 minutes at room temperature (20°C)
20 - 30 minutes at 60°C object temperature

Fast hardener: 10 minutes at 60°C object temperature
60 minutes at 20°C

Fast hardener and max. 5% Thinner fast 20 minutes at 40°C object temperature



IR drying
Short wave Flash-off 10 minutes at 45°C
Drying 15 minutes at 60°C

Special Notes:

AKEMI® Iron Gloss Anti Scratch is an UHS-Clearcoat and best results are achieved if the clear coat is brought to the spraying temperature before application (20 - 25°C). The practical material consumption depends on several factors, e.g. shape of the object, structure of the surface, application method, pressure and application circumstances.

Technical Data:

Chemical base comp. A:	acrylic resin with hydroxyl groups
Chemical base Comp. B:	polyisocyanate
Solid content:	approx. 59.3% (of the mixture)
Solid volume:	approx. 54.4% (of the mixture)
Density:	approx. 1.02 g/ml (of the mixture)
Recommended dry film thickness:	40 - 60 µm
Theoretical coverage:	approx. 9.1 m ² per litre (at 60 µm)
Delivery viscosity at 20°C:	mixture approx. 20 s/4mm (DIN 53211) clearcoat approx. 45 s/4mm (DIN 53211) hardener approx. 12 s/4mm (DIN 53211)
VOC:	≤ 420 g/l

Storage:

If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production (clear coat and hardener).

Health & Safety:

Read Safety Data Sheet before handling or using this product.

Technical Data Sheet

Page 3 of 3

Important Notice:

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area or fabrication of a sample piece.