OPTIC Acryl Topcoat 2+1 *

Characteristics:
OPTIC Acryl Topcoat 2+1 is a two-component coloured topcoat for a spray gun application. The first component is a solution of pigments in high quality acrylic resin in suitable thinners. The second one - the hardener is a solution of isocyanate resin. OPTIC acryl topcoat is characterised by ideal gloss, perfect hiding power, UV durability, changeable weather conditions and excellent adhesion. Good flow, cover and short dry time simplify the work.

Substrates:
- all Novol acryl, polyurethane and epoxy primers,
- old paint coatings (including thermoplastic paints),
- polyester laminates.

Substrates preparation:
- old paint coatings: degrease and sand dry P280 - P360,
- primers: degrease, matt using sand dry P240 - P360 or abrasive needled cloth (e.g. Scotch Very Fine). Repair damage places in the primer layer,
- polyester laminates: degrease and sand dry P280 or matt using abrasive needled cloth (e.g. Scotch Very Fine).

Notice: special attention must be paid on times when topcoat is applied on primer.

Mixing ratio:

	volume
OPTIC Acryl Topcoat 2+1	2
OPTIC Hardener for Acryl Topcoat 2+1	1
Acryl thinner THIN 850	20 %

Amount of solvent calculate on topcoat.

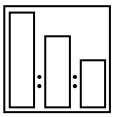
Complementary products:
OPTIC Hardener for Acryl Topcoat 2+1, Fast, Standard, Slow.
Acryl Thinner THIN 850 Fast, Standard, Slow.
Accelerating Agent PLUS 750.
Elasticity Increasing Agent PLUS 770.

Potlife:
Using OPTIC Hardener for Acryl Topcoat 2+1 Standard and Slow:
ca. 6 h at the temperature of 20℃
Using OPTIC Hardener for Acryl Topcoat 2+1 Fast:
ca. 2 h at the temperature of 20℃

Spray viscosity, nozzle, pressure:
Thin with an Acryl Thinner THIN 850 approx. 20%:
DIN 4/20°C 18÷22 s, ∅1.3÷1.4mm, 3÷4 bar

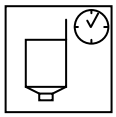
Contents of volatile organic compounds:
VOC=630 g/L (ready to apply mixture)

Procedure:
OPTIC Acryl Topcoat should be applied on finish and degreased surfaces. Apply two or three single layers leaving 5 ÷ 10 min time for evaporation after each one (depends on the temperature and the thickness of the layer). 15 min after the last layer was applied the coat can be force-dried.



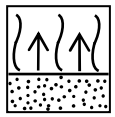
Enamel 100
Hardener 50

Measuring stick
2+1



Thinned:
DIN 4/20℃ 18-22s

2-3 x; 3-4 bar
∅ 1.3 - 1.4 mm
Thinner 20



5÷10 min

Operation hardness
14 h/20℃
45 min/60℃

Layer thickness:
20÷30 µm for each layer.

Application:
- OPTIC Hardener for Acryl Topcoat 2+1 Fast
  Use for small and larger repairs. Recommended working temperature below 18℃.
- OPTIC Hardener for Acryl Topcoat 2+1 Standard
  Use for small and larger repairs as well as for complete body painting. Recommended working temperature 18 - 25℃.
- OPTIC Hardener for Acryl Topcoat 2+1 Slow
  Use for larger repairs. Recommended working temperature 25 - 40℃.

Drying time:
- In the temperature of 20℃

	OPTIC Acryl Topcoat 2+1		
	OPTIC Hardener for Acryl Topcoat 2+1 Fast	OPTIC Hardener for Acryl Topcoat 2+1 Standard	OPTIC Hardener for Acryl Topcoat 2+1 Slow
Dust-free	12 min.	15 min.	20 min.
Tack-free	1.2 h.	3.0 h.	3.5 h.
Operation hardness	12 h.	14 h.	14 h.
End hardness	5 days	7 days	7 days

- In the temperature of 60℃

	OPTIC Acryl Topcoat 2+1		
	OPTIC Hardener for Acryl Topcoat 2+1 Fast	OPTIC Hardener for Acryl Topcoat 2+1 Standard	OPTIC Hardener for Acryl Topcoat 2+1 Slow
Dust-free	5 min.	5 min.	6 min.
Tack-free	10 min.	10 min.	15 min.
Operation hardness	35 min.	45 min.	45 min.
End hardness	50 min.	60 min.	60 min.

Notice: Drying topcoat with fast hardener in higher temperature can cause loss of gloss and necessity of polishing.
Fast hardener shouldn't be used together with Accelerating Agent PLUS 750

Yield:
A set (1L of OPTIC Acryl Topcoat + hardener in recommended ratio) is enough to get ca. 10.5 m^2 of 50 µm thickness dry layer.

Color:
RAL, according to customer pattern.

Tools cleaning:
NC solvent or Acryl Thinner THIN 850.

Storage time and conditions:
Store in a dry, cool place, away from sources of fire and heat. Direct sunlight should be avoided.

OPTIC Acryl Topcoat 2+1:	24 months at a temperature of 20℃.
OPTIC Hardener for Acryl Topcoat 2+1:	9 months at a temperature of 20℃.

Industrial safety:
See Safety Data Sheet of this article.

* Product for professional use only. Do not compliant with directive UE 2004/42/CE.
The product could be applied around the EU only when it meets the additional requirements of the directive UE 1999/13/WE and national regulations which are the implementation of the directive mentioned above.