

# TECHNICAL INFORMATION

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16.06.2016.



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**Product Name: Two-Component Acrylic Clear Top Coat**  
**APP 2K Acryl Klarlack Compact**  
**APP No: 020115-0.5L, 020116-1L and 020117-5L.**

Two-component acrylic clear top coat of high gloss and quick hardening time. Features with very good levelling properties and clarity. It is resistant to weather conditions in different climatic zones. UV filters ensure basecoat colour fastness.

Package:	Top coat -0.5L, 1L, 5L; Hardener -0.2L, 0.5L, 2.5L.
Product and additives:	APP 2K Acryl Klarlack Compact 2:1 APP 2K Compact Harter XLCH quick – quick setting time APP 2K Compact Harter XLCH standard – standard setting time. APP 2K Acryl Verdunnung AVN/AVS
Special additives:	APP 2K Elastic APP Anti-Silikon.
Basic components:	APP 2K Acryl Klarlack Compact 2:1 – Acrylic resin APP 2K Compact Harter HLCH - Isocyanate hardeners.
Colour:	Transparent, clear of high gloss.
Coverage:	9-10m <sup>2</sup> /L Caution! In practice coverage depends on different factors including: shape, substrate roughness, application method and operating conditions.
<u>Application:</u>	Purposed for repairs of both parts and whole car bodies, to be applied as high quality top layer of car body in case of two coats systems. To be used with water borne and traditional basecoats paints.
<u>Substrate:</u>	<ul style="list-style-type: none"><li>• APP Modular Special Base</li><li>• Old top coats</li><li>• Typical water borne and traditional basecoats applied during car body repairs.</li></ul>
<u>Substrate preparation:</u>	Before spraying, firstly clean the basecoat surface and remove any lose and dry dust.

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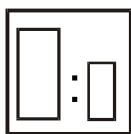
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## Use

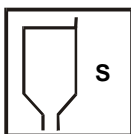
Mixing ratio:



- A) At temperature from 18°C to 25°C:  
2 by volume APP 2K Acryl Klarlack Compact  
1 by volume APP 2K Compact Harter XLCH Standard

- B) At temperature below + 18°C:  
2 by volume APP 2K Acryl Klarlack Compact  
1 by volume APP 2K Compact Harter XLCH Quick

- C) Mixing ratio by weight:  
100 APP 2K Acryl Klarlack Compact  
49.5 APP 2K Compact Harter XLCH  
Standard/Quick



Spraying viscosity at +20°C: 14sec. 4 mm DIN.

### Caution!

Use only APP 2K Compact Harter XLCH hardener purposed for acrylic top coat. Follow strictly specified hardener volume. To control spray viscosity, apply up to 5% of APP 2K Acryl Verdunnung AVN/AVS thinner only. If necessary add 2 to 5% of APP Anti-Silikon. Before mixing with hardener add APP 2K Elastic plasticizer according to mixing table, if necessary (in case of plastic).

Application:



Apply with a spray gun fitted with  $\varnothing 1.2$ - $\varnothing 1.5$ mm nozzle at air pressure of 1.7 to 2.1bar.



Coat qty: 2 x 1.  
Dry coat thickness: 50-60  $\mu\text{m}$  (2 x 1).  
Recommended ambient conditions:  
- Minimum temperature: +10°C

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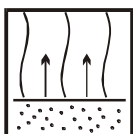


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- Maximum relative humidity: 70%.



Evaporation time between coats at temperature +20°C:

- 3-5min.

Workability time:

- 3-4h.

### Drying



At temperature +20°C:

Dust dry:

9-10min.

Touch dry:

2-3h

Workability time:

4-5h

Total hardening:

6-7h



At temperature +50°C:

15-20 min.

IR radiator:

8-10 min.

### Grinding



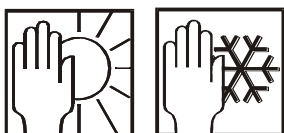
Following total hardening, namely after 8-9h at temperature +20°C you may remove defects and inclusions with abrasive materials:

- Manually with water resistant sandpaper  
APP P1500- APP P2500
- Mechanically with abrasive material  
APP P1500- APP P3000
- Spot damages and inclusions may be repaired with abrasive material APP P1500- APP P2500.

### Tools cleaning:

Nitrocellulose or acrylic thinner.

### Storage:



Store in closed, original containers, in dry and well ventilated spaces.

Protect against freezing.

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## Occupational safety:



Product for professional use only.  
See: labels on containers and MSDS.  
User shall follow locally and regionally applicable industrial safety regulations.

## VOC:

Permitted VOC in g/L of product ready to use:  
840g/L for APP 2K Acryl Klarlack Compact.  
Maximum VOC in g/L of product ready to use:  
530g/L for APP 2K Acryl Klarlack Compact.

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