

Technical Instruction Sheet

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Characteristics:

AKEMI® 2K HS-Acrylic-Transparent-Lacquer is a high quality solvent Polyurethane coat based on acrylate hardened with isocyanates. The product is distinguished by the following qualities:

- high solid contents
- excellent filling properties
- easy to apply
- excellent reliability against environmental and weather influence
- outstanding maintenance of brightness
- offers durable protection for the vehicle

Instruction for Use:

1. Do not apply at object temperature below + 10°C. Best application temperature +15to+25°C
2. Two parts by volume of AKEMI® 2K HS-Acrylic-Transparent-Lacquer are thoroughly mixed with one part by volume of AKEMI® Hardener normal for 2K HS-Acrylic-Transparent-Lacquer.
3. Adjust spray viscosity with a high quality PUR/Acrylate-Thinner
Spray-gun:
Viscosity: 17-22 s/4 mm DIN cup, add 5 - 15% thinner
Nozzle: 1,3 - 1,4 mm, air pressure: 4 - 5 bar

Spray-gun HLVP:
Viscosity: 17 - 22 s/4 mm DIN cup, add 5 - 15% thinner
Nozzle: 1,3 - 1,5 mm, pressure: 3 bar, HVLP-pressure: 0,7 bar.
4. Potlife 2,5 - 4 hours with spray-gun at 20 °C and 65 % rel. humidity.
5. Spray 1 coat for adhesion, 2-3 minutes flash-off time, spray 1 coat evenly
6. Drying Time:
Dust free: approx. 1 h
Touch dry: approx. 6 h
The drying times are based on test at 20°C and 65% relative humidity with a dry film thickness of appr. 60 ljm
Oven drying:
Flash-off time: 5-15 minutes (depending on room temperature)
Drying time: After 30 minutes at 60°C object temperature
7. Tools can be cleaned with PUR/Acrylate-Thinner.
8. Empty the Container fully before disposing of it.

Technical specifications:	Colour:	transparent
	Gloss:	high gloss
	Solids of weight:	ca. 51 + / -1 % (of mixture)
	Solids of volume:	ca. 45+ / -1 % (of mixture)
	Density:	ca. 1,00 g/ml (of mixture)
	Recommended dryfilm:	50-70jjm
	Theoretical coverage at 60 jjm DFT:	approx. 7,5 m ² /kg The practical coverage may be lower depending on the kind of application, design, roughness of Substrate or application conditions
	Theoretical consumption at 60 jjm DTF:	approx. 135 gr/m ²
	Viscosity as supplied at 20°C:	(Base component) approx. 75 s/4mm DIN Cup (DIN 53211) (Hardener) approx. 13 s/4mm DIN Cup (DIN 53211)
	Shelf life:	12 months in originally sealed Containers stored at cool place, hardener 6 months

Safety notices: Please refer to the EC safety data-sheet

Notice: The above information is based on the latest stage of our 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.