

TECHNICAL DATA SHEET

AUTOCRYL

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Bodywork, farming machine, trailers, cranes, electric light sign, ...

Because of its fast drying, this acrylic endlayer offers the possibility to assemble very fast

PRODUCT INFORMATION

Type of paint	Two components acrylic polyester
Finish	High Gloss (+90%)
Color	RAL
Density	1.1 kg/L
Solids content	60 vol% 66 m%
VOC (Volatile Organic Compounds)	330 g/L
Recommended dry film thickness (DFT)	50 – 80 µm
Theoretical spreading rate	13 m ² /L
Practical spreading rate (Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience)	Brush/Roller: 85-90% of the theoretical spreading rate Spraying: 50-70% of the theoretical spreading rate
Flashpoint	>21°C
Dry temperature resistance	110°C

DRYING TIMES

For d.f.t. up to 50µm

	20°C
Dust dry	1 hour
Manageable	4 hours
Dry	24 hours

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.

APPLICATION-INSTRUCTIONS

Mixing ratio: Volume: base-hardener 2 – 1 Flex hardener
Mixing instructions: Base and hardener should be mixed and applied at temperatures above 10°C
At lower temperatures extra thinner is needed which gives a slighter resistance against sagging and which will delay hardening.
Pot life after mixing: ca 4 hours at 20°C
Application conditions: During application and hardening the temperature should be above 5°C to attain maximum resistance against chemical and mechanical influences.

Application at lower temperatures (up to 5°C) is possible, however hardening will take considerably more time and complete resistance will be achieved much later.

The surface should remain free from water and ice and the temperature of the surface should at least be 3°C above dew point.

During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

Usage information	Airless	Air spray
Type of thinner	Thinner PU	Thinner PU
Recommended thinner	0-5 vol%	5-10 vol%
Nozzle orifice	0.28-0.33 mm 0.011-0.013 inch	1.5-2.0 mm
Nozzle pressure	130-160 bar	2-3 bar
Cleaning	Thinner Cellulose	Thinner Cellulose

SURFACE CONDITIONS

As primer Epoxy primer ZNF or All Meta Cryl or washprimer can be applied.

Repair and maintenance:
Clean the surface thoroughly with suitable cleaning preparation or by steam cleaning.
Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.
Remove rust a.o. by blasing Sa2½ or derust mechanical until St.2-3
Apply the advised paint system on a clean surface.
- Mechanical or hand derusting gives less quality than blasing and will result in less protection of the applied paint system.

DURABILITY

At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

PACKAGING

1 L + 0,5 L 5 L + 2,5 L 20 L + 10 L

These data have been drawn up to the best of our knowledge and were correct at the data of issue. However we cannot accept full responsibility, because the choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.