










## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p><b>SPECULAR 2:1</b></p> <p>ACRYLIC - URETHANE CLEARCOAT 2:1</p>	
<p><b>PRODUCTS</b></p> <p>SPEC SPECULAR 2:1 – clearcoat                  SPEC SPECULAR 1:2 STANDARD / SLOW / FAST - hardener for clearcoat                  SPEC UNIVERSAL THINNER Acrylic Systems - Thinner for Acrylic Systems</p>	
<p><b>PRODUCT DESCRIPTION</b></p> <p>2k acrylic- urethane clearcoat designed for industrial applications. It creates a hard, high-gloss coating with increased scratch resistance (SR). Simple mixing of components and easy application make it a highly versatile clearcoat.</p> <ul style="list-style-type: none"> <li>• High gloss.</li> <li>• Easy application and universal use.</li> <li>• Hard and durable finish.</li> <li>• Very good chemical and mechanical resistance.</li> <li>• Very good levelling.</li> <li>• Increased scratch resistance (SR).</li> </ul>	<p><b>COLOUR:</b> transparent</p> <p><b>GLOSS GRADE:</b> high gloss</p>

<p><b>VOLATILE ORGANIC COMPOUNDS</b></p> <p>VOC for the mixture = 556 g/l (2:1:1)  <i>This product meets the EU directive (2004/42/EC) that sets the VOC value for its category IIB(e) at 840 g/l.</i></p>	
<p><b>SURFACE PREPARATION</b></p>	
<p>Clearcoat SPECULAR can be applied over:</p> <ul style="list-style-type: none"> <li>• Base Coats,</li> <li>• Old finishes in good condition after matting and degreasing.</li> </ul>	<p>For matting we recommend the following:</p> <ul style="list-style-type: none"> <li>• grey abrasive fabric with a polishing compound,</li> <li>• sanding paper with gradation of 360÷500 (machine sanding).</li> </ul>

APPLICATION PROCESS									
	<p><b>USE</b></p> <p>Paint repairs of commercial vehicle bodies, trucks, and other means of transport, which require a durable finish.</p>		<p><b>SPRAYING VISCOSITY</b></p> <p>14÷15 seconds at 20°C.</p>						
	<p><b>MIXING RATIO</b> by volume</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 70%;">Clearcoat</td> <td style="text-align: right;">2</td> </tr> <tr> <td>Hardener</td> <td style="text-align: right;">1</td> </tr> <tr> <td>Thinner</td> <td style="text-align: right;">1</td> </tr> </table> <p>* To achieve increased filling, a 2:1:0.5 ratio can be used</p>	Clearcoat	2	Hardener	1	Thinner	1		<p><b>POT LIFE</b></p> <p>about 6÷8 hours at 20°C.</p>
Clearcoat	2								
Hardener	1								
Thinner	1								
	<p><b>NUMBER OF LAYERS AND GUN PARAMETERS</b></p> <p><b>Number of layers</b> 2-3 full layers, dry thickness of a single layer approx. 50 µm.</p> <p><b>RP Gun parameters</b> Nozzle: 1.3÷1.4 mm; Pressure of input: 2,0÷2,2 bars.</p> <p><b>HVLP Gun parameters</b> Nozzle: 1.3÷1.4 mm; Inlet pressure: 2,0 bars.</p>		<p><b>HARDENING TIME</b></p> <p><b>At the temperature of 20°C</b> Dust free: after about 35-40 minutes Ready to polish: after drying overnight</p> <p><b>At an object temperature of 60°C</b> Clearcoat is ready to polish after about 30 minutes of baking and cooling down (about 2 hours). Temperature below 20°C significantly increases the hardening time.</p>						
	<p><b>EVAPORATION TIME</b></p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 60%;">Between layers:</td> <td style="text-align: right;">approx. 5 minutes</td> </tr> <tr> <td>Before baking:</td> <td style="text-align: right;">approx. 10 minutes</td> </tr> </table>	Between layers:	approx. 5 minutes	Before baking:	approx. 10 minutes		<p><b>IR DRYING</b></p> <p>15÷20 minutes of short waves, depending on the layer thickness and the type of radiator. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>		
Between layers:	approx. 5 minutes								
Before baking:	approx. 10 minutes								

<b>PRODUCT EFFICIENCY</b>
1 liter of mixture is enough to cover 8,5 m <sup>2</sup> with a dry layer with thickness of 50 µm.
<b>SHADING</b>
Make sure you have covered all the surface with the clear coat. You should only shade the surface that has been covered and treated. Use FADE OUT THINNER from Troton to clean any dust or dirt from the surface and to level out the optical gloss differences between the older and new applied coating.
<b>POLISHING AND REMOVING IMPURITY INCLUSIONS</b>
Usually polishing is unnecessary, as the SPECULAR 2:1 clearcoat gives the surface a perfect look immediately after application. However, if some dirt inclusions appear, we recommend removing them and then polishing the surface with an abrasive compound.
<b>GENERAL NOTES</b>
<ul style="list-style-type: none"> <li>Do not exceed recommended doses of the hardener!</li> <li>The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.</li> <li>When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.</li> <li>The rooms should be well ventilated.</li> <li>Clean the guns and equipment immediately after use..</li> </ul> <p><b>Caution:</b> To maintain safety, always follow the instructions given in the MSDS for the products.</p>
<b>STORAGE</b>
Store the product between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight. <b>Note:</b> 1. After each use the container with product should be immediately closed. 2. Protect the hardener from frost and dampness!
<b>WARRANTY PERIOD</b>
SPEC SPECULAR 2:1 Acrylic- urethane clearcoat - 24 months from the date of production SPEC HARDENER SPECULAR 1:2 Hardener for clearcoat - 12 months from the date of production SPEC UNIVERSAL THINNER Acrylic Systems - 12 months from the date of production

PRODUCT	Art. No.
SPEC SPECULAR 2:1	16264 (5 l)
SPEC HARDENER SPECULAR 1:2 STANDARD, FAST , SLOW	16265 (2,5l standard), 16524 (2,5l fast), 16523 (2,5l slow)
SPEC UNIVERSAL THINNER Acrylic Systems - STANDARD (18-25°C)	300010563 (5l standard)
SPEC UNIVERSAL THINNER Acrylic Systems - FAST (< 18°C)	16525 (5l fast)
SPEC UNIVERSAL THINNER Acrylic Systems - SLOW (>25°C)	16526 (5l slow)

<b>LIMITATION OF LIABILITY</b>
<p>The information contained in the TDS is up-to-date and correct on the day the information is released. Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS. Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage. Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.</p> <p>All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.</p> <p style="text-align: right;">TROTON Sp. z o.o. Ząbrowo, Poland.</p>