


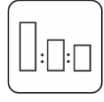


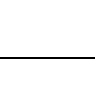
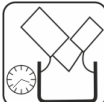





TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>TIX HS 2:1 ACRYLIC CLEARCOAT</p>	
<p>PRODUCTS</p>	
<p>TIX HS 2:1 Acrylic Clearcoat STANDARD Hardener 1:2 for TIX HS Acrylic Clearcoat FAST Hardener 1:2 for TIX HS Acrylic Clearcoat Thinner for Acrylic Systems MASTER</p>	<p>COLOUR: transparent GLOSS GRADE: high gloss</p>
<p>PRODUCT DESCRIPTION</p>	
<p>High-quality 2K acrylic clearcoat with increased scratch resistance (SR - Scratch Resistant) for automotive repairs. It features a hard and durable high-gloss finish, exceptionally easy application, and outstanding anti-sagging properties.</p> <ul style="list-style-type: none"> • Excellent stability on vertical surfaces minimizing the risk of runs. • Very easy application. • High gloss and excellent coating appearance. • Hard and durable finish. • Suitable for both spot repairs and full-body painting. 	

<p>VOLATILE ORGANIC COMPOUNDS</p>
<p>VOC for mixture = 525 [g/l], This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (e), at 840 g/l.</p>
<p>SURFACE PREPARATION</p>
<p>Acrylic clearcoats can be applied over:</p> <ul style="list-style-type: none"> • Basecoats, • Old finishes in good condition after matting and degreasing.

APPLICATION PROCESS															
	<p>USE</p> <p>For car body paint repair that requires a durable finish.</p>		<p>NUMBER OF LAYERS</p> <p>2 full layers, total dry film thickness of approx. 60 µm.</p> <p>Spray gun parameters: RP nozzle: 1.3÷1.4mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.3÷1.4mm; Inlet pressure: 2.0 bars. Note: follow the spray gun producer's recommendations.</p>												
	<p>MIXING RATIO by volume</p> <table border="1" data-bbox="247 1444 710 1545"> <tr> <td>Clearcoat</td> <td>2 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner</td> <td>20÷25%</td> </tr> </table>	Clearcoat	2 parts	Hardener	1 part	Thinner	20÷25%		<p>HARDENING TIME</p> <table border="1" data-bbox="869 1467 1476 1624"> <tr> <td>Dust dry at 20°C:</td> <td>35÷40 minutes</td> </tr> <tr> <td>Baking at 60°C: (temperature of the panel)</td> <td>30 minutes</td> </tr> <tr> <td>Ready to polish:</td> <td>after drying overnight</td> </tr> </table> <p>Temperature below 20°C significantly increases the hardening time.</p>	Dust dry at 20°C:	35÷40 minutes	Baking at 60°C: (temperature of the panel)	30 minutes	Ready to polish:	after drying overnight
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	<p>SPRAYING VISCOSITY</p> <p>16÷18 seconds at 20°C/DIN4 with 10% thinner</p>		<p>IR DRYING</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.</p> <p>Wait about 10 minutes before starting the heater drying.</p>												
	<p>POT LIFE</p> <p>Approx. 6÷8 h at 20°C.</p>														
	<p>EVAPORATION TIME</p> <table border="1" data-bbox="247 1904 710 1982"> <tr> <td>Between layers:</td> <td>approx. 5÷10 minutes</td> </tr> <tr> <td>Before banking:</td> <td>approx. 15 minutes</td> </tr> </table>	Between layers:	approx. 5÷10 minutes	Before banking:	approx. 15 minutes										
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<p>PRODUCT EFFICIENCY</p>
<p>1 liter of mixture is enough to cover 8 m² with a dry layer with thickness of 60 µm.</p>

SHADING

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 Inter Troton FADE OUT THINNER to clean any dust or dirt from the surface and to level out the optical gloss differences between the older and new applied coating.

POLISHING AND REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the MASTER THIX HS 2:1 acrylic 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.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- 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.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

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.

Note:

1. *After each use the container with product should be immediately closed.*
2. *Protect the hardener from frost and dampness!*

WARRANTY PERIOD

TIX HS 2:1 Acrylic Clearcoat	– 24 months from the date of production
STANDARD Hardener 1:2 for TIX HS Acrylic Clearcoat	– 12 months from the date of production
FAST Hardener 1:2 for TIX HS Acrylic Clearcoat	– 12 months from the date of production
Thinner for Acrylic Systems MASTER	– 24 months from the date of production

PRODUCT**ART. No.**

TIX HS 2:1 Acrylic Clearcoat	16933; 16937 (1l; 5l)
STANDARD Hardener 1:2 for TIX HS Acrylic Clearcoat	16934; 16938 (0,5l; 2,5l)
FAST Hardener 1:2 for TIX HS Acrylic Clearcoat	16935; 16939 (0,5l; 2,5l)
Thinner for Acrylic Systems MASTER	(1l; 5l): 300002253, 300002790; fast (1l; 5l): 15554, 9908 / slow 1l; 5l): 6152, 6153

LIMITATION OF LIABILITY

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.

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.

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