FREEWORLD
AUTOMOTIVE COATINGS

Data Sheet Number:
APU-04-3
APU Topcoats

APU Topcoats: Acryline 2K High Performance Topcoats

- 2K MS Topcoat
- Excellent gloss, flow, colour retention and UV durability
- High mechanical and chemical resistance
- Resistant to weathering

Technical Description

- Mix 2:1 with Acryline 2K MS Hardeners
- Pot Life 4 hours @ 23°C
- Air dry / force drying possible

Single Panel / Spot Repairs

- For extra fast air drying add 5 - 10% Acryline Air Dry Promoter (ATH 313 refer to appropriate part of datasheet)

APU Topcoats: Acryline 2K High Performance Topcoats

WORKING PROCESS:

2:1 MS SYSTEM

SUBSTRATE:

- Through-hardened sanded paintwork
- All Acryline Primers and Fillers

PRETREATMENT / CLEANING:

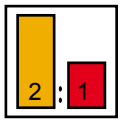
Ensure that all surfaces are clean, free from Dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310)

APPLICATION:

Use air fed respirator.
Refer to relevant Health and Safety Data sheets.

Special Notes:

- Do not use Fast Hardener in combination with Slow Thinner.
- Do not use Slow Hardener with Fast Thinner.
- Medium Hardener may be used with either Fast or Slow Thinner.

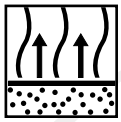


2:1 with Acryline 2K MS Hardeners
Potlife 4 hours @ 23°C

5 - 10% Acryline 2K Thinner
18 - 20“ DIN 4 @ 23°C

1.3 - 1.4 mm
HVLP: 1.8 - 2 bar
Conventional: 3 - 4 bar
2 coats = 30 - 40 micron (approx.)

1.5 - 1.7 mm
Conventional: 3 - 4 bar
2 coats = 30 - 40 micron (approx.)



5 - 10 min @ 23°C
Flash off between coats and final flash off

Touch dry:	1 hour @ 23°C
Hard dry:	12 - 15 hours @ 23°C
Force dry:	30min @ 60°C panel temperature

APU Topcoats: Acryline 2K High Performance Topcoats

WORKING PROCESS:

2:1 MS SYSTEM - METTALIC (APU 2 & APU 4)

SUBSTRATE:

- Through-hardened sanded paintwork
- All Acryline Primers and Fillers

PRETREATMENT / CLEANING:

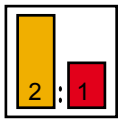
Ensure that all surfaces are clean, free from Dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310)

APPLICATION:

Use air fed respirator.
Refer to relevant Health and Safety Data sheets.

Special Notes:

- Do not use Fast Hardener in combination with Slow Thinner.
- Do not use Slow Hardener with Fast Thinner.
- Medium Hardener may be used with either Fast or Slow Thinner.



2:1 with Acryline 2K MS Hardeners
Potlife 4 hours @ 23°C

5 - 10% Acryline 2K Thinner
18 - 20“ DIN 4 @ 23°C

1.3 - 1.4 mm
HVLP: 1.8 - 2 bar
Conventional: 3 - 4 bar
2 coats = 30 - 40 micron (approx.)

1.5 - 1.7 mm
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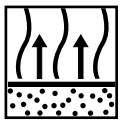
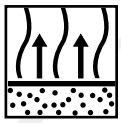


5 - 10 min @ 23°C
Flash off between coats and final flash off



Allow 10 mins flash off before the third coat (Mist coat)

Touch dry:	1 hour @ 23°C
Hard dry:	12 - 15 hours @ 23°C
Force dry:	30min @ 60°C panel temperature

APU Topcoats: Acryline 2K High Performance Topcoats

WORKING PROCESS:

2:1 MS ACCELERATED SYSTEM FOR SINGLE PANEL SPOT REPAIR USING AIR DRY PROMOTER ATH 313

SUBSTRATE:

- Through-hardened sanded paintwork
- All Acryline Primers and Fillers

PRETREATMENT / CLEANING:

Ensure that all surfaces are clean, free from Dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310)

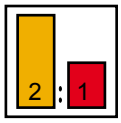
APPLICATION:

Extra fast drying for single panel / spot repairs add controlled additions of Acryline Air Dry Promoter ATH 313

Use air fed respirator.
Refer to relevant Health and Safety Data sheets.

Special Notes:

- Do not use Fast Hardener in combination with Slow Thinner.
- Do not use Slow Hardener with Fast Thinner.
- Medium Hardener may be used with either Fast or Slow Thinner.

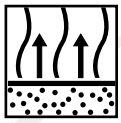


2:1 MS Acryline 2K Hardeners

5 - 10 % Acryline Air Dry Promoter (ATH 313)
Add sufficiant Acryline 2K Thinner to give 18 - 20“ Din 4 @ 23°C

1.3 - 1.4 mm
HVLP: 1.8 - 2 bar
Conventional: 3 - 4 bar
2 coats = 30 - 40 micron (approx.)

1.5 - 1.7 mm
Conventional: 3 - 4 bar
2 coats = 30 - 40 micron (approx.)



5 min @ 23°C
Flash off between coats and final flash off

Air Dry 20 - 30 mins @ 23°C

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Flashpoint:	Specific Gravity:	Solid content:
23°C	0.9 - 1.3 g/cm³ Dependant on colour	+/- 50% (by weight)

Average DFT: Minimum 40 micron.

Raw Material: 2-pack acrylic resins.

Cleaning of Equipment: Clean after use with Lacquer Thinners.

Shelf Life: 12 months @ 20 - 25°C in original sealed packaging.

Important remarks:

- For professional use only.
- Acryline 2K Topcoat cannot be used over Acrylic lacquers and synthetic enamels.

Protect from sunlight

Working areas should be well ventilated.
Booth must have good extraction.
Refer to Material Safety Data Sheet (MSDS)

Protect from severe cold

This Product contains flammable materials.
Keep away from sparks & open flames.
No smoking permitted in the area.

Warning:
2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Note:
The information contained here represents the current state of our knowledge and is intended as a guide to our products and their uses. It is not intended as an insurance of certain product properties or of their specific applications. The warnings displayed on the product labels should be followed. Any industrial property rights should be observed. We guarantee perfect product quality under the terms of our general conditions of sale.

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