

EURO 2.1

PRODUCT FEATURES

- Excellent Bake or Air-Dry Clear
- Outstanding Gloss
- Compatible with Any Base-coat or Single Stage System
- Easy to Sand and Buff
- VOC Compliant



AVAILABILITY

Clear (Part A)				Activator (Part B)			
		Unit	Per Case			Unit	Per Case
ACL-1310-5L	EURO 2.1	5 Liters	2	BCL-1311-2L	Fast Activator	2.5 Liters	2
ACL-1310-4	EURO 2.1	Quarts	2	BCL-1311-8	Fast Activator	Pint	6
				BCL-1312-2L	Medium Activator	2.5 Liters	2
				BCL-1312-8	Medium Activator	Pint	6
				BCL-1313-2L	Slow Activator	2.5 Liters	2
				BCL-1313-8	Slow Activator	Pint	6

PHYSICAL PROPERTIES

Color	Transparent	Weight Solids (RTS)	37.00 – 37.06 %
Pot Life	2 hours	Theoretical Coverage @ 1 mil (A+B)	603.8 sq ft
Flash Point	1°F	Gloss 20°/60°	80GU "Gloss Units" / 90GU "Gloss Units"
Dry Film Build	2.5 to 3.1 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	16-19" #2 Zahn Cup	Reparability Catalyzed	Excellent
VOC (RTS)	<2.1 (lb./gal)		
Humidity Resistant	Excellent		

DRY TIMES @ 70 F



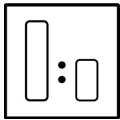
Air Dry	
Dust Free	20 minutes
Flash	Until Hand Slick (approximately 15-20 min).
Print Free	5 hours
Sand & Buff	12 to 24 hours

Force Dry
Flash for 15 minutes then bake @ 140°F for 30-45 minutes.

Note: Only use slow activators and reducers when force drying. Allow vehicle to cool down to room temperature before sanding and buffing.

Note: All tests are performed at 70°F, higher temperatures will provide faster drying and buffing times.

MIX RATIO



2	Parts Clear	EURO 2.1 CLEAR
1	Part Activator	Activator (see availability table for options)

Note Reduce as necessary with ALR Series Urethane Reducer to improve flow. Do not add more than 20% by volume of urethane reducer.

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure. One-half (1/2) fluid ounces of AXIS 2K PERFORMANCE ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.3-1.4 mm	7-10 PSI
Conventional	1.3-1.4 mm	45-55 PSI

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects.

SURFACE PREPARATION



Follow all procedures from your basecoat manufacturer for surface preparation, dry and recoat times. DO NOT DEVIATE FROM THESE RECOMMENDATIONS.

ACTIVATOR SELECTOR

Temperature Range

Recommended Activator

	BCL-1311	BCL-1312	BCL-1313
60-75° F	Yes	Yes	
75-85° F		Yes	Yes
80° F or more		Yes	Yes

GENERAL INFORMATION

- Always consider the following when choosing an activator: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.

APPLICATION



Apply two to three medium wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 15-20 min) before applying the next coat. Apply all coats within 1½ hour. If sanding and buffing, three coats of clear must be applied for long-term durability.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.