

### PRODUCT FEATURES

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

### AVAILABILITY

SKU	Description	Size
ACL-1810-5L	EUROPEAN WORLD CLEAR - Acrylic Urethane	5 Liters
BCL-1817-2L	EUROPEAN WORLD CLEAR - Fast Activator	2.5 Liters
BCL-1818-2L	EUROPEAN WORLD CLEAR - Medium Activator	2.5 Liters
BCL-1819-2L	EUROPEAN WORLD CLEAR - Slow Activator	2.5 Liters

### PHYSICAL PROPERTIES

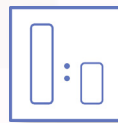
Color	Transparent
Mix Ratio	2:1
Pot Life	5 ½ hours
Flash Point	1°F
Recommended Dry Film Build	3.1 mils
Inter Coat Adhesion	Excellent
Repairability Catalyzed	Excellent
Humidity Resistant	Excellent
Sprayable Viscosity (rts)	18" #2 Zahn Cup
Gloss 20°/60°	89GU "Gloss Units" / 94GU "Gloss Units"
Weight Solids (rts)	35.64 – 36.22 %
VOC (rts)	< 4.2 (lb./gal)

### DRY TIMES @ 70 °F

Dust Free	20 minutes
Flash Between Coats	Until Hand Slick (aprox. 15-20 min).
Print Free	5 hours
Force Dry	Flash 15 mins then bake @ 140°F for 30-45 mins
Sand, Buff and Deliver	16 to 18 hours



### MIXING RATIO



<b>2</b> Parts Clear	ACL-1810-5L
<b>1</b> Part Activator	BCL-1817-2L, 1818-2L & 1819-2L

Note: Choose activator depending on your shop conditions and job requirements. No reducer necessary.

### SPRAY GUN SETUP



Gravity HVLP	1.2–1.4 mm	7-10 PSI
Siphon HVLP	1.2–1.4 mm	7-10 PSI
Conventional	1.3–1.4 mm	50-55 PSI

Note: The pressure on an HVLP gun is measured at the cap, on a conventional gun pressure is measured at the gun.

# EUROPEAN WORLD CLEAR

Part (A): Clear ACL-1810-5L

Part (B): Activator BCL-1817-2L, 1818-2L and 1819-2L



## SURFACE PREPARATION



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

## 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.

## 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.

## GENERAL NOTES

◆ 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 (aprox. 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.



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## BUFFING



- Force Dry: Cool to room temperature before sanding and buffing.
- Air Dry: Allow to dry 16 to 18 hours before sanding, buffing and delivering.
- ◆ Sand with 1200 grit sandpaper or finer and buff with a fine buffing compound that will remove at least 1200 grit scratches.

## 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 4 hours @ 55-70°F or more than 2 hour @ >70°F.



## 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.

For more detailed recommendations, please contact your local Axis Performance Coatings distributor. These products may require several components and must be mixed properly to comply with V.O.C. regulations. These products are not recommended as part of a multi-coat system if the V.O.C. exceeds local, state or Federal regulations.

### Limited Warranty

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Vogel Automotive Coatings does not control the application of its products, or the condition of the surfaces to which they are applied, Vogel Automotive Coatings liability will under no circumstances exceed replacement of the product.