

TECHNICAL DATA SHEET

MIRROR CLEAR II - QUICK SET



PRODUCT FEATURES

- 3 to 10 minutes dust free times
- Buff and deliver the same day
- Excellent long term durability
- Compatible with any basecoat/clearcoat system

AVAILABILITY

Clear (Part A)		Unit	Per Case	Activator (Part B)		Unit	Per Case
ACL-1210-1	Mirror Clear II	GAL	2	BCL-1217-4	Panel Activator	QT	2
ACL-1210-4	Mirror Clear II	QT	6	BCL-1217-6	Panel Activator	HP	6
				BCL-1218-4	Multi-Panel Activator	QT	2
				BCL-1218-6	Multi-Panel Activator	HP	6
				BCL-1219-4	Overall Activator	QT	2
				BCL-1219-6	Overall Activator	HP	6

PHYSICAL PROPERTIES

Color	Transparent	Weight Solids (RTS)	32.6%
Pot Life	4 hours	Theoretical Coverage @ 1 mil (A+B)	515.52 sq ft
Flash Point	1°F	Gloss 20°/60°	85GU "Gloss Units" / 94GU "Gloss Units"
Dry Film Build	2.1 to 2.6 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	15" #2 Zahn Cup	Reparability Catalyzed	Excellent
VOC (RTS)	<2.1 (lb./gal)		
Humidity Resistant	Excellent		

ACRYLIC URETHANE CLEAR

DRY TIMES @ 70 F



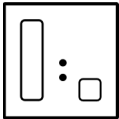
Air Dry	
Flash	Until Hand Slick (approximately 10 to 15 min).
Print Free	12 hours
Sand & Buff	12 to 16 hours

Force Dry
Flash for 10 minutes then bake @ 140°F for 30 minutes.

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

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

MIX RATIO



4 Parts Clear	Mirror Clear II—Quick Set
1 Part Activator	Activator (see availability table for options)

Note Reduce as necessary with ZERO VOC Urethane Reducer to improve flow. Do not add more than 15% 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.

SURFACE PREPARATION

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

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.
- Do not combine slow reducers with fast activators; this combination may cause solvent pop.
- Always follow the recommendations on the table above when selecting a activator/reducer combination.

APPLICATION

Apply two to three medium wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 10 to 15 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.