



# ALUMINUM CLEAR 2.1 VOC

acrylic urethane clearcoat



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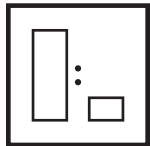
### »DESCRIPTION

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### »AVAILABILITY

Clear (Part A)		Unit	Per Case
ACL-3200-1	ALUMINUM CLEAR 2.1 VOC	Gallon	2
ACL-3200-4	ALUMINUM CLEAR 2.1 VOC	Quart	6
Activator (Part B)			
BCL-3201-4	ALUMINUM CLEAR 2.1-FAST	Quart	4
BCL-3201-6	ALUMINUM CLEAR 2.1-FAST	Half-Pint	6
BCL-3202-4	ALUMINUM CLEAR 2.1-MED.	Quart	4
BCL-3202-6	ALUMINUM CLEAR 2.1-MED.	Half-Pint	6
BCL-3203-4	ALUMINUM CLEAR 2.1-SLOW	Quart	4
BCL-3203-6	ALUMINUM CLEAR 2.1-SLOW	Half-Pint	6

### »MIX RATIO



4 Parts A: Aluminum Clear 2.1 VOC  
1 Part B: Aluminum Clear 2.1 VOC Activator

### »SURFACE PREP

Previously coated surfaces must be stripped or scuffed with 400 grit sandpaper. Clean the scuffed or bare metal surface with generous amounts of AXIS water based Pre-Clean (ASC-PC-1), changing rags frequently. Allow the surface to dry completely before clear coating

### »SPRAY GUN SETUP

Follow the spray gun manufacturers recommendation for proper setup.

### »APPLICATION

Apply 2-3 full wet coats from a distance of 6 to 8 inches. A wet on wet "limited flash" application can be used allowing 5 to 15 minutes between coats.

### »DRY TIMES

Pot Life:	4 Hours
Dust Free Time:	15 minutes
Print Free Time:	8-12 Hours
Sand and Buff:	Overnight

### »FORCE DRY

Flash for 10 minutes then bake at 140°F for 30 minutes. Allow surface to cool to room temperature before sanding and buffing. Do not use Fast (BCL-3201) activator when force drying.

### »TECHNICAL DATA

Sprayable Viscosity:	13-15" #2 Zahn
EPA VOC (RTS):	≤ 1.12 lbs/gal
Actual VOC (RTS):	≤ 0.38 lbs/gal
Dry Film Build:	1.2-1.5 mils per coat
Gloss Units 60/20:	90+GU/80+GU
Theoretical Coverage:	466.72 sq ft @ 1 mil
Flash Point:	1° F

### »OTHER INFORMATION

Moisture and humidity adversely affects clear coat products. Equipment should be clean and dry before use. Close containers immediately after use. Keep containers tightly sealed.

FOR PRODUCT SAFETY INFORMATION,  
REFER TO THE SAFETY DATA SHEET.

