



TECHNICAL DATA SHEET

PRODUCTION II CLEAR
ACL3421-1/ACL3421-4

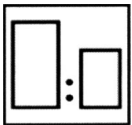
Description

Production II Clear is a National Rule V.O.C. Compliant Acrylic Urethane Clear that works well over urethane color systems. ACL3421 has excellent leveling properties and gloss retention. This clear is an excellent economical alternative for shops where warranty is not an issue.



Use suitable respiratory protection

Axis recommends to use fresh air supply respirator
Shake well before mixing



4 Production II Clear
1 Production II Activator

Activators: Fast (BCL3422-4/BCL3422-6), Medium (BCL3423-4/BCL3423-6), or
 Slow (BCL3424-4/BCL3424-6)

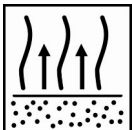


Gravity spray gun set-up:
1.3 - 1.5 mm

Application pressure:
50-60 PSI at the air cap
Check gun manufacturer specification



2-3 Wet Coats



Between coats:

5 - 12 Minutes



4-5 Minutes (Dust Free - depending on temperature and activator selection)

5-12 Minutes (Tack Free - depending on activator speed)

6-8 Hours (Buff Time)

Air Dry @ 72°F

10 Minutes (Froce Dry)

30 Minutes (Baked @140°F)

Recommended: 2 mm DFT for UV Protection
Read complete TDS for detailed product information

MANUFACTURED FOR / FABRICADO PARA:

Axis™ - Liberty Bell Equipment Corp. 810 N. Jefferson Ave. St. Louis, MO 63106 Phone/Teléfono (888) 646-1400 www.axiscoatings.com



TECHNICAL DATA SHEET

PRODUCTION II CLEAR
ACL3421-1/ACL3421-4

Description

Production II Clear is a National Rule V.O.C. Compliant Acrylic Urethane Clear that works well over urethane color systems. ACL3421 has excellent leveling properties and gloss retention. This clear is an excellent economical alternative for shops where warranty is not an issue.

FEATURES:

- ☞ Fast Dust Free Time
- ☞ Excellent Gloss Retention and D.O.I
- ☞ Excellent Leveling Properties
- ☞ Easy to Buff
- ☞ Competitive Pricing

Product and additives

- Product:** - Production II Clear (ACL3421-1/ACL3421-4)
- Activators:** - Production II Fast (BCL3422-4/BCL3422-6), Production II Medium (BCL3423-4/BCL3423-6), Production II Slow (BCL3424-4/BCL3424-6)
- *Fast(3422) = spot panel & Medium (3423) = Multi-panel

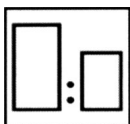
Recommended Substrates

- Various Basecoat Color Systems
- Polyurethane Enamel (after 8 hour dry)
- Acrylic Urethane Enamel (After 8 hour dry)
- Gel Coat (Must be Properly Prepared)

Suitable Substrates

- Acrylic or polyester basecoats
- Waterborne basecoat systems
- Activated polyurethane enamel (must be cured at least 8 hours)
- Activated acrylic urethane enamel (must be cured at least 8 hours)
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending.

Mixing Instructions



- 4 - Production II Clear (ACL3421-1/ACL3421-4)
- 1 - Production II Activator

Activators: Fast (BCL3422-4/BCL3422-6), Medium (BCL3423-4/BCL3423-6), Slow (BCL3424-4/BCL3424-6)

Technical Data

Color	Clear
Pot Life:	3 hours @ 72 F
Mix Ratio:	4:1
Recommended Film Build:	2 mm DFT for UV Protection
V.O.C w / 3201 Activator	3.844 lbs/gal (460.613 g/l) Ready To Spray
V.O.C w / 3202 Activator	3.874 lbs/gal (464.207 g/l) Ready To Spray

MANUFACTURED FOR / FABRICADO PARA:



TECHNICAL DATA SHEET
PRODUCTION II CLEAR
ACL3421-1/ACL3421-4

Spray gun and pressure

	Fluid Tip	Spraying Pressure
	1.3mm -1.5mm	50-60 psi @ gun

Application Instructions

1. Apply basecoat color per recommended procedures Note: Allow polyurethane and acrylic enamel basecoat to dry at least 8 hours before applying clear.
2. Mix Production II Clear with appropriate activator per above instructions and shop conditions.
3. Apply 2-3 wet coats of using 50-60 P.S.I. at the gun for a conventional spray gun. Use mfr. Recommended pressure and 1.3 – 1.5 mm fluid tip and cap with HVLP.
4. Allow 5-12 minutes flash between coats.
5. Dry times: Dust Free 4-5 minutes depending on temperature and activator selection. Tack Free 5-12 minutes depending on activator speed. Buff Time 6-8 hours air dry @ 72 F Force Dry 10 minute flash; bake 30 minutes at 140 F
6. Pot Life: 3 hours @ 72 F

Application method

Apply 2-3 wet coats

Flash times

Flash Time between coats: 5 - 12 minutes

Buffability

Production II Clear can be wet sanded and buffed within 6-8 hours when kept at 72 F. It is very easy to buff however, it is designed to gain hardness after 72 hours and will become more difficult to buff.

Cleaning of equipment

Use good quality lacquer thinner or urethane reducer to thoroughly clean all equipment.
Do not leave activated clear in gun longer than 3 hours.

VOC / Regulatory information

Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air- supplied respirator when exposed to vapors or spray mist.

HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.

Revision Date: June 3rd 2019

MANUFACTURED FOR / FABRICADO PARA:

Axis™ - Liberty Bell Equipment Corp. 810 N. Jefferson Ave. St. Louis, MO 63106 Phone/Teléfono (888) 646-1400 www.axiscoatings.com