



TECHNICAL DATA SHEET

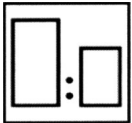
LIGHTNING II CLEAR
ACL3520-1/ACL3520-4

Description

Lightning Clear (85101/85104) is a 2.1 VOC (50-state compliant) high production clear system developed for spot repair and one panel repair. This 4:1 clear is a 3 coat system that can be sanded and buffed in 20-25 minutes air dry or baked for 5 minutes at 130°F



Use suitable respiratory protection
Axis recommends to use fresh air supply respirator



4 Lightning II Clear
1 Lightning II Activator

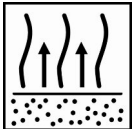


Gravity spray gun set-up:
1.3 - 1.4 mm

Application pressure:
10 PSI at the air cap
Check gun manufacturer specification



3 x 1 light coat



Between coats:
Apply back to back (no flash)



25 Minutes (air dry)
5 Minutes (baked @130°F metal temp)

Recommended: 2 mm DFT for UV Protection

Read complete TDS for detailed product information

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Product and additives

- Product:** - Lightning II Clear (ACL3520-1/ACL3520-4)
Activators: - Lightning II Activator (BCL3521-4/BCL3521-6)
Additives - Reducer if needed(no more than 10%)

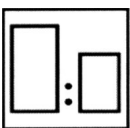
Basic raw materials

- Lightning II Clear (ACL3520-1/ACL3520-4): hydroxyl acrylic resins
- Lightning II Activator (BCL3521-4/BCL3521-6): polyisocyanate resins

Suitable surfaces

- 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 ratios



- 4 - Lightning II Clear (ACL3520-1/ACL3520-4)
1 - Lightning II Activator (BCL3521-4/BCL3521-6)

Optional Reducer +10% Urethane Grade Reducer

Potlife

30-45 minutes (72°F (22.2°C) 50% RH)

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Spray gun and pressure

	Fluid Tip	Spraying Pressure
HVLP gravity	1.3mm -1.4mm	8-10 psi @ air cap
Mini-Jet Gravity Fed	1.0mm-1.3mm	8-10 psi @ air cap

Application method

Apply 3 light coats.

Flash times

Flash Time between coats: None required (apply wet-on-wet)

Dry times

Below is a table showing the drying times of Lightning II Clear . The air-dry times stated may increase with insufficient airflow.

Metal Temp.	Drying	Zip Ultra II Clear (85101/85104)
70°F (20°C)	Dust Free	2 min
	Dry	25 min
	Stripe/Decal	120 min
130°F (54°C)	Dust Free	2 min
	Dry	5 min
	Stripe/Decal	60 min after cool

Recoatability

Lightning II Clear can be re-coated with itself at any stage. Sanding will become necessary after 24 hours.

Film thickness

1.0 mil per coat.

Coverage rate

Coverage 450 sq. ft. / gal @ 1 coat @1 mil

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Polishing

Lightning II Clear can be wet sanded and buffed after 25 minutes.
If baked, it can be lightly de-nibbed or sanded after cool down

Decals and Lettering

Decals can be applied after 2 hours at 70°F (20°C)

Hand striping or lettering must be applied within 2 hours for good adhesion. After 2 hours, scuff with a gray scuffing pad.

Cleaning of equipment

Clean spray Gun immediately with Cleaning Solvent or Lacquer Thinner.

Stock keeping

Color: Clear

Shelf life: Lightning II Clear (ACL3520-1/ACL3520-4): Two years if stored unopened at room temperature.
Lightning II Activator (BCL3521-4/BCL3521-6): One year if stored unopened at room temperature.

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.

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