



TECHNICAL DATA SHEET

**PREMIUM 2:1 HS CLEAR NR**  
**ACL 80200-1/ACL 80200-4**

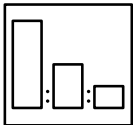
**Description**

PREMIUM 2:1 HS CLEAR is a premium quality overall urethane clearcoat. Utilizing European resin technology, this clear produces extra brilliant gloss and depth. It is a medium to high solid product that meets National Rule standards when mixed properly (can not be used in 2.1 VOC areas). It also works extremely well in hot humid environments as well as down draft baking applications.



**Use suitable respiratory protection**

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



2 Premium 2:1 HS Clear NR  
1 Activator  
1/2 Urethane Reducer



Gravity spray gun set-up:  
1.3 - 1.4 mm

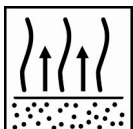
Application pressure:

10 @ air cap

Check gun manufacturer specification

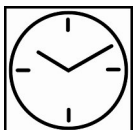


2 wet coats



Between coats:

10 minutes



Dust Free: 10 - 15 Minutes

Bake: 30 Minutes @ 140°F

Recommended Film Build: 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



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**DESCRIPTION:**

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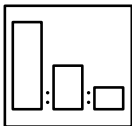
**Product and additives**

- Product:** - Premium 2.1 HS Clear (80200)
- Activators:** - Activator: Fast (80250), Med (80270), Slow (80280), or Ex-Slow (80290)
- Additives** - Urethane Reducer (fast, med, slow, or ex-slow)

**Suitable surfaces**

1. All acrylic and polyester basecoat color systems
2. Polyurethane enamel (after 8 hour dry)
3. Acrylic urethane enamel (after 8 hour dry)
4. Gel coat (must be properly prepared)
5. Waterborne Basecoat Systems

**Mixing ratios**



- 2 Premium 2.1 HS Clear  
1 Activator  
1/2 Urethane Reducer

**Features**

1. Premium overall character
2. Excellent flow, leveling
3. Highest gloss and D.O.I.
4. Apply over most basecoat systems
5. Thoroughly tested for long term durability
6. Easy buffing within 12-72 hours
7. Excellent gloss retention

**Spray gun and pressure**

	<b>Fluid Tip</b>	<b>Spraying Pressure</b>
HVLP	(1.3- 1.4 mm)	10 @ air cap

**Application method**

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 ACL80200 with appropriate activator and reducer as per instructions.
3. Apply 2 wet coats of clear using 10 PSI at gun for a conventional spray gun. Use mfr. Recommended pressure and 1.3 – 1.4 mm fluid tip and cap with HVLP.
4. Allow 10 minutes flash between coats.

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#### Flash times

Flash Time between coats: 10 minutes

Optional: On small jobs (i.e. fenders & doors) one tack coat can be applied followed by one full wet coat with no flash time between coats. Tack coat must be applied evenly.

#### Dry times

Dust Free: 10-15 minutes depending on temperature and activator selection

Tack Free: 30-40 minutes depending on activator speed

Buff Time: Minimum 12 hours air time

Maximum 7 days

Force Dry: 10 minutes flash bake 30 minutes at 140 F Delivery 6-8 hours

#### Buffability

Premium can be wet sanded and buffed between 12 hours and up to 7 days after applying. It should be buffed within 72 hours. Finish will become difficult to buff after 7 days.

#### 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.

#### Film Build

Recommended Film Build: 2 mm DFT for UV Protection

#### Technical Data

Color:	Clear
Pot Life:	5 hours at 75 F
Coverage:	1 mil 600 sq. ft.
Mix Ratio:	2:1:1/2 part (4.4 V.O.C.)
Sprayable Viscosity:	18 sec. #2 Zahn
Flash Point:	76 F TCC
Recommended Film Build:	2.0 - 2.5 Mils DFT
Gloss:	92 Plus
Weight Solids:	44%
V.O.C. Sprayable 2:1:1/2	4.4 lb. Per gallon (528 g/l)

Note: Gasoline Resistance : After 30 days full cure, Care should be taken after 7 days until full cure.

#### 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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