



# ACRYLINE APU 10 CLEAR

## PRODUCT DATA SHEET

**ACRYLINE APU 10 CLEAR** is a two component aliphatic isocyanate cured, polyurethane acrylic clear coat. **ACRYLINE APU 10 CLEAR** cures to a film that has excellent flow, good film hardness, low dirt retention, good gloss and flow. It is resistant to weather, water and mild chemicals.

THIS IS A TWO-PACK SYSTEM. MIX THE TWO COMPONENTS THOROUGHLY BEFORE USE. DO NOT USE THE BLEND AFTER THE POT LIFE LIMIT.

### USAGE

- In the automotive refinishing industry where its good filling properties, smooth finish and high gloss make it suitable for use as a topcoat, on **ACRYLINE FINISH** for cars, commercial vehicles and motor bikes.
- In areas where a high performance high gloss clear coat is required, e.g. bar tops, furniture.
- For interior and exterior use on top of ACRYLINE pigmented finishes.

### TECHNICAL AND PHYSICAL DATA

- **Colour :** Water clear
- **Consistency :** 100 – 110 seconds FORD CUP No.4.
- **Specific Gravity :** 0.98 approximately
- **Volume Solids :** 35% approximately
- **Application temperature:** 3°C above dew point
- **Dry temperature resistance:** Continuous: 70°C, Non-continuous: 90°C
- **Flash Point :** 23°C, closed cup
- **Hardener:** **ACRYLINE HARDENER**
- **Mixing ratio:** 2 parts Base : 1 part Hardener by volume
- **Pot Life:** 4 hours at 25°C
- **Packing :** 1 L, 5 L.

Paints should be stirred before use and occasionally whilst in use.  
Contact your supplier for further information

### APPLICATION

- **Surface preparation:** Surfaces must be clean, dry, free of dust, dirt, oil, grease or any other contaminants.

**For automotive applications:**

Apply wet on wet on **ACRYLINE FINISH**. Allow **ACRYLINE FINISH** to flash off for 10 – 15 minutes.

**Reworking:**

Minor defects such as runs and dirt can be removed by sanding with P1200 lubricated with **TESTBENZIN** and restored to gloss by polishing with a non abrasive polish for 2K topcoats.

- **Application method:** Gravity feed spray gun, nozzle orifice 1 – 1.5 mm, nozzle pressures 40 – 60 psi. Airless spray, nozzle orifice 0.007” – 0.013”, nozzle pressure 1000 – 2000 psi.
- **Dilution:** Mix base and hardener prior to diluting with 5% **ACRYLINE THINNER** to obtain correct viscosity for application by conventional spray i.e. 19 - 20 seconds FORD CUP No. 4.
- **Spreading rate / Film thickness:** Apply at a spreading rate of around 9.0 m<sup>2</sup>/l. The dry film thickness will be around 40 microns.
- **Drying time:**

| TOUCH DRY      | OVERCOATING INTERVAL |           | HARD DRY          |
|----------------|----------------------|-----------|-------------------|
|                | °C                   | HOURS     |                   |
| 1 hour at 25°C | 10                   | 2         | 12 hours at 25 °C |
|                | 15                   | 1         |                   |
|                | 25                   | 5 minutes |                   |
|                | 30                   | 5 minutes |                   |

- **Baking:** 30 minutes at 60°C surface temperature.
- **Air drying:** Dust free within 60 minutes at 25°C. Can be taped after overnight drying.
- **Cleaning solvent:** **KARNAMEL THINNER** or **ACRYLINE THINNER**.
- **Preceding coat:** **ACRYLINE FINISH**.
- **Subsequent coat:** **None**.

**SAFETY**

- **ACRYLINE APU 10 CLEAR** is flammable, keep away from ignition source. Do not smoke whilst using.
- Wear adequate protective equipment during application, remove splashes from skin with soap and water. In case of contact with eyes, rinse with ample water and seek medical advice if necessary.
- Ensure good ventilation during application and drying.
- Keep containers tightly closed and away from children.

These recommendations are meant as a guide, no guarantee is implied since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

**This data sheet supersedes those previously issued and may be changed without prior notice.**

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