

## THUNDER COAT

### DEFINITION

Two-component acrylic clearcoat with high dry residue (UHS), featuring a very high hardening speed. The ready-to-use product has excellent rheology, excellent flow and excellent gloss. Once dried, it forms a film of great gloss and hardness, with very high stability characteristics thanks to its excellent resistance to chemical and atmospheric agents.

The pot-life is well calibrated to allow safe application with a single catalyst. It can be used on a water or solvent base.

### CHARACTERISTICS

Part A – THUNDER COAT – UHS fast-drying clearcoat 157TC

- Density:  $1.00 \pm 0.03$  g/cm<sup>3</sup>
- Color: light yellow
- Non-volatile matter:  $60\% \pm 2$

Part B – THUNDER COAT – Hardener 157TCC

- Density:  $1.00 \pm 0.03$  g/cm<sup>3</sup>
- Color: colorless or light yellow
- Non-volatile matter:  $58\% \pm 2$

Ready-to-use product

- Chemical nature: acrylic
- Non-volatile matter:  $60 \pm 2\%$
- Color: colorless
- Viscosity (DIN 4 mm at 20 °C): 16–18 seconds

### SUBSTRATE PREPARATION

Before application, preliminary tests are recommended to verify product compatibility with the surface to be treated, considering the wide variety of application conditions and materials available on the market.

### MIXTURE PREPARATION

By volume: 2 parts of Part A + 1 part of Part B

By weight: 100 g of Part A + 50 g of Part B.

*The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.*

\* For any information about product codes or packs, please see our catalogue, our price list or contact us.

It can be thinned up to 5% with specific thinner (code 80322). Mix the components well before use.

### POT LIFE

At 20°C: 35 minutes

### APPLICATION

Apply with a gravity-feed spray gun, nozzle Ø 1.2-1.3 mm, and pressure according to the spray gun manufacturer's instructions.

Application is recommended at temperatures between 18 and 22 °C and relative humidity between 40 and 60%.

For flat surfaces spray one cross coat without flash-off between coats.

For vertical surfaces spray a light half coat followed by a full coat, without flash-off between coats.

Dry film thickness: 50–60 µm.

During drying, the oven can be used only in "ventilated" mode, without activating heating.

### DRYING TIMES

- Dust-free:  
Air at 20 °C: 30–45 min  
Oven at 50 °C: 8 min
- Sanding:  
Air at 20 °C: 3.5–4 h  
Oven at 50 °C: 15 min + cooling
- Full cure:  
Air at 20 °C: 5 days  
Oven at 50 °C: 15 min + 3 days at 20 °C

Note: before polishing clearcoat dried at 50 °C, allow at least 1 hour for cooling.

IR lamp drying: 8–15 min. Follow the IR lamp manufacturer's instructions. Allow flash-off before drying.

### STORAGE

Store in a cool, dry environment, protected from direct sunlight, and at temperatures between 5°C and 35°C.

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