

# Technical Information

Marz 2008

**PRODUCT FOR PROFESSIONAL USE ONLY**

## ECO-LINE PINUS CLEAR COAT VHS 2:1

### PRODUCTS

ECO-LINE <b>PINUS</b> 2:1	Clearcoat 2K VHS
ECO-LINE <b>PINUS STANDARD</b> 1:2	Hardener standard 2K VHS
ECO-LINE <b>PINUS FAST</b> 1:2	Hardener fast 2K VHS

### PRODUCT DESCRIPTION

PINUS ECO-LINE is a two-component acrylic clear coat with high content of solids. It provides a hard and highly scratch resistant surface with a perfect gloss. Other advantages, such as quick curing capacity and high yield, reduce the lacquering costs greatly.

### CONTENT OF VOLATILE MATTER

VOC (Volatile Organic Compound) for the mix = 390 [g/l], for viscosity of 21 s., DIN 4 at 20°C. This product satisfies requirements of the European Union Directive (2004/42/WE), which for this product category (B/4) gives the limit value of content of volatile matter at the level of 420 [g/l] of the ready-for-use product.

\*ISO 3251:2008

### SUBSTRATE AND PREPARING THE SURFACE

Clearcoat PINUS can be put on:

- basic colours,
- metallic colours,
- existing paintwork in sound condition.

Existing paintwork should first be dried, abraded and cleaned with a silicone remover.


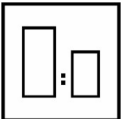
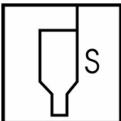




For dulling the colour we recommend the following:

- grey unwoven abrasive fabric with a dulling paste,
- abrasive paper with gradation of 600÷800 (for dulling wet),
- abrasive paper with gradation of 360÷400 (for dulling by machine),


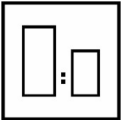
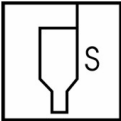




**PRODUCT EFFICIENCY**

1 litre of the mix enables us to get between 6.5 and 7.5 m<sup>2</sup> of dry film, 60 µm thick.

**PROCESS - for fast system**

	<p><b>Application</b> Repairs of all sorts in temperatures under 25°C.</p>	
	<p><b>Proportions for mixing components</b> Clearcoat PINUS 2:1 Hardener PINUS FAST</p>	<p>Parts by volume 2 parts 1 part</p>
<p><b>The cleacoat does not need to be used with a thinner!</b></p>		
	<p><b>Spraying viscosity</b> 21-22 s. DIN 4/20°C</p>	
<p><b>Pot life</b> 1,5 hours at 20°C</p>		
	<p><b>Fluid Tip</b> Gravity Fed: 1.3÷1.4mm, Working pressure: Refer to spraygun manufacturers instructions</p>	
	<p><b>Number of coats</b> 1,5 coat or 2 full coat. <b>Dry film thickness = 50÷70 µm</b></p>	
	<p><b>Evaporation times</b> - between coats  - before holding at high temperatures</p>	<p>0 minute after 0,5 layer 5 minutes after 1 full layer 10÷15 minutes</p>
	<p><b>Drying at 20°C</b> Dust drying 10÷15 minutes <b>Holding at temperature 60°C - 20÷25 minutes</b> <b>Other activities - 6 hours after the film has cooled down.</b></p>	
<p>Temperatures under 20°C considerably lengthen the drying time.</p>		

**PROCESS - for slow system**

	<p><b>Application</b> Repairs of all sorts in high temperatures, over 25°C.</p>	
	<p><b>Proportions for mixing components</b></p> <p>Clearcoat PINUS Hardener PINUS STANDARD</p>	<p>Parts by volume</p> <p>2 parts 1 part</p>
<p><b>The clearcoat does not need to be used with a thinner!</b></p>		
	<p><b>Spraying viscosity</b> 23÷24 s. DIN 4/ 20°C</p> <p><b>Pot life</b> 1 hour and 20 minutes at 20°C</p>	
	<p><b>Fluid Tip</b> Gravity Fed: 1.3÷1.4mm, Working pressure: Refer to spraygun manufacturers instructions</p>	
	<p><b>Number of coats</b> 1,5 ÷ 2 full coats <b>Dry film thickness</b> = 60÷80 µm</p>	
	<p><b>Evaporation times</b></p> <ul style="list-style-type: none"> <li>- between coats</li> <li>- before holding at high temperatures</li> </ul>	<p>0÷5 minutes 15÷20 minutes</p>
	<p><b>Drying at 20°C</b> Dust drying - 25÷35 minutes Holding at temperature 60°C - 25÷30 minutes <b>Other activities</b> – Polishing -6 hours after the film has cooled down. Lacquering- after 24 hours after layers cooling Temperatures under 20°C considerably lengthen the drying time.</p>	

Finally	Clearcoat	Clearcoat + Hardener FAST
100 ml	66 g	101 g
150 ml	99 g	151 g
200 ml	131 g	201 g
250 ml	164 g	252 g
350 ml	230 g	352 g
450 ml	296 g	453 g
550 ml	362 g	554 g
650 ml	427 g	654 g
750 ml	493 g	755 g
1,0 L	657 g	1007 g
1,5 L	986 g	1510 g
2,0 L	1315 g	2013 g
2,5 L	1643 g	2517 g

Finally	Clearcoat	Clearcoat + Hardener STANDARD
100 ml	66 g	101 g
150 ml	99 g	151 g
200 ml	131 g	202 g
250 ml	164 g	252 g
350 ml	230 g	353 g
450 ml	296 g	454 g
550 ml	362 g	555 g
650 ml	427 g	656 g
750 ml	493 g	757 g
1,0 L	657 g	1010 g
1,5 L	986 g	1515 g
2,0 L	1315 g	2020 g
2,5 L	1643 g	2524 g

**MIXING ACCORDING TO THE MASS (Do not tare the scales!)**

**FAST system**

**STANDARD system**

**POLISHING AND REMOVING INCLUSIONS**

Usually polishing is unnecessary, as the ECO-LINE clear coat gives the surface a perfect look immediately after having been used. However, if some dirt inclusions appear, one recommends removing them wet, using abrasive paper with gradation of 1500-2000 and then polishing the surface with abrasive compound.

The easiest way of polishing 2K-surfaces is to do it 5-24 hours after the film cooled down.

**GENERAL REMARKS**

- Best results of application are achieved when using a professional chamber-oven, or when varnishing in a room specially suited for this goal, at least at room temperature, i.e. at 20°C.
  - Object temperature and surrounding temperature shall be equal.
  - Using such clearcoats one shall remember of spraying first the edges and cavities and leaving front surfaces for the last stage of application process.
- Thus we can avoid superfluous dust creation and achieve smooth surface.
- **One must not exceed recommended doses of hardener!**
  - When working with 2K products one must use operating personal protective gear. One shall protect eyes and breathing system.
  - Rooms shall be well ventilated.

- Spraying guns and tools shall be washed directly after use.

Note: For safety reasons one must always strictly observe guidelines on data sheets of dangerous substances for a given product.

### **STORAGE**

Clearcoat and hardeners must be stored in tightly closed containers, in dry and cool compartments, away from fire, heat, and sun rays sources.

Note: After each use the container with clearcoat and another container with hardeners shall be immediately closed! Protect against freeze and humidity!

### **WARRANTY PERIOD**

Clearcoat ECO-LINE 2:1- 12 months after the production date.

Hardener ECO-LINE STANDARD - 9 months after the production date.

Hardener ECO-LINE FAST- 9 months after the production date.

All information is based on thoroughly made laboratory tests and long-year experience. Our strong market position however do not excuses us from the duty of continuous quality control of our products. But we cannot be held responsible for final effects of our products in case they are improperly stored or used at variance with the art of best workmanship.

TROTON sp. z o.o. Ząbrowo.