

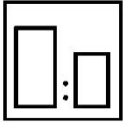


MS Clearcoat

FOR PROFESSIONAL USE ONLY

Description

MS Clearcoat is a two-component, mid-solids polyurethane clearcoat. Provides a high gloss finish two full wet coats. Excellent flow and leveling properties are easily achieved. MS Clearcoat can be used as a final clearcoat or as an integrated clearcoat with the U500 or U350 single stage. The ready to spray VOC is 4.6 lbs/gal.



3 MS Clearcoat
1 MS Activator

Use AkzoNobel Measuring Stick



106

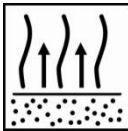


Spray gun setup:

		Check gun manufacture specification	
RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.3 – 1.4mm	30 – 35psi	
HVLP – Pressure	1.0 – 1.2mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.4 – 1.5mm	Max 10psi (cap)	

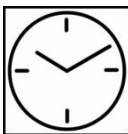


Apply two (2) to three (3) single flowing coats



Between coats
5 minutes at 70°F (21°C)

Final flash before bake
10 – 15 minutes at 70°F (21°C)



Dust free
Dry to handle

70°F (21°C)
45 min
15 hrs

140°F (60°C)
N.A.
45 min



Use suitable respiratory protection
AkzoNobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information



MS Clearcoat

FOR PROFESSIONAL USE ONLY

Description

MS Clearcoat is a two-component, mid-solids polyurethane clearcoat. Provides a high gloss finish two full wet coats. Excellent flow and leveling properties are easily achieved. MS Clearcoat can be used as a final clearcoat or as an integrated clearcoat with the U500 or U350 single stage. The ready to spray VOC is 4.6 lbs/gal.

Suitable Surfaces

U350 Single Stage	System 200	Polybase
U500 Single Stage	3.8 HSP	Polybase Plus
	3.5 HSP	

Existing finishes in the case of spot or blend repair, degrease and sand with #P800 to #P1000 DA. Properly degrease substrate prior to sanding with Autoclean surface cleaner and R859 wax and grease remover.

Product and Additives

Product	MS Clearcoat	
Hardener	MS Activator	
Additives	998 Accelerator	Accelerates dry times
	997 Enhancer	Pot life extender. Slows flash off, allowing better melt-in a high temperatures
	LV Flex Additive	For flexible substrate application
	T890 Flattening Agent	Low gloss additive
	U-TECH SRA Reducer	Special solvent to dissolve fade out areas of spot repairs

Basic Raw Material

MS Clearcoat	Hydroxyl acrylic resins
MS Activator	Polyisocyanate resin and solvent
LV Flex Additive	Special polyester resins

Product Characteristics

WPG (a-component)	8.6 +/- 0.2 lbs/gal	Gloss	High
Volume Solids (RTS)	36 +/- 2%	Color	Clear
Theoretical Coverage	577 ft ² /gal @ 1mil – 100%TE	Pot Life (no additives)	2 hrs @ 70°F (21°C)
		Pot Life (998 Accelerator)	1 hr @ 70°F (21°C)
		Pot Life (997 Enhancer)	2 ½ hrs @ 70°F (21°C)





MS Clearcoat

FOR PROFESSIONAL USE ONLY

Mixing

Standard mix ratio (by volume)

- 3 MS Clearcoat
- 1 MS Activator

Flexible Plastic Parts mix ratio (by volume)

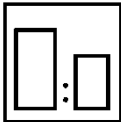
- 100 MS Clearcoat
- 15 LV Flex Additive

Then mix (by volume)

- 3 MS Clearcoat (Flexed)
- 1 MS Activator

Add a maximum of ½ oz of 998 Accelerator per RTS gallon or 3 - 4 grams per RTS quart to speed up cure times

Add a maximum of 2oz of 997 Enhancer per RTS gallon or 12 – 14 grams per RTS quart to extend pot life and improve overspray melt-in



MS Clearcoat Flexed should be used in combination with flexed primers, sealers and topcoats

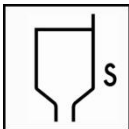
Note: Raw flexible plastic body parts require PAP 722 Clear adhesion promoter

T890 Flattening agent can be used to reduce the gloss units (GU) of the MS Clearcoat. Add T890 after activating the MS Clearcoat using the below table to achieve the desired gloss level. A spray out should be done first to determine desired gloss.

Gloss Level	% of T890 Flattening
Antique (70 – 80 gu)	10%
Eggshell (50 - 60 gu)	20%
Semi gloss (40 -50 gu)	30%
Matte (20 – 30 gu)	40%
Flat (10 – 20 gu)	50%

Use AkzoNobel Measuring Stick #106. Mix thoroughly.

Viscosity



MS Clearcoat

21 – 28 sec
13 – 17 sec

EZ ZAHN #2 at 70°F (21°C)
DIN #4 at 70°F (21°C)

Viscosities are reported as Ready to Spray



MS Clearcoat

FOR PROFESSIONAL USE ONLY

Spray gun set-up / application pressure



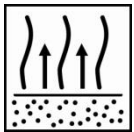
RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.3 – 1.4mm	30 – 35psi	
HVLP – Pressure	1.0 – 1.2mm	Max 10psi (caps)	12 – 16 oz/min
HVLP – Gravity Feed	1.4 – 1.5mm	Max 10psi (caps)	

Application



Apply two (2) or three (3) single wet flowing coats

Flash off



5 minutes at 70°F (21°C) between coats
10 – 15 minutes at 70°F (21°C) final flash before bake

Dry times



	No Additives		½ oz 998 Accelerator per gal		1oz 997 Enhancer per gal	
	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)
Dust Free	45 min	N.A.	12 min	N.A.	1 hr	N.A.
Dry to handle	15 hrs	45 min	3 hrs	20 min	15 hrs	45 min

Note: 998 will decrease pot life. Extreme temperatures may require higher amounts of 997. Using LV Flex will extend curing times and effect the sandability of MS Clearcoat

Dry Film Thickness

2.0 – 2.5 mils

Apply 1.2 - 1.4 mils per coat





MS Clearcoat

FOR PROFESSIONAL USE ONLY

Polishing



Dust and minor damage can be polished out after stated dry times. If baking, allow cool down of the object to ambient temperature.

- Carefully de-nib out dust particles with #P1500 then #P2000 grit paper. Clean and dry the surface to be polished
- Mechanically polish area using quality rubbing compounds followed by polishing glaze

Recoatability

MS Clearcoat is recoatable with itself after full drying cycle. Sanding becomes necessary after 24 hours.

Striping or lettering on MS Clearcoat must be applied within 24 hours for good adhesion. Sanding becomes necessary after 24 hours.

Decals can be applied after 48 hours 70°F (21°C)

Cleaning of equipment

Clean equipment with extra strong cleaning solvents

VOC

MS Clearcoat 4.42 lb/gal 530 g/l

VOC is ready to spray at a mix ratio of 4:1

Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

MS Clearcoat	2 years
MS Activator	1 year
998 Accelerator	1 year
997 Enhancer	1 year
LV Flex Additive	1 year
T890 Flattening Agent	2 years



MS Clearcoat

FOR PROFESSIONAL USE ONLY

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

AkzoNobel Car Refinishes Inc. 3587 Parkway Lane Norcross, GA 30092, USA. www.utech.us