



# INTERNATIONAL SYSTEMS TDS – North America

## METALUX 2™ Lightspeed Clear 9701 4.2VOC

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TD Sheet CS112 rev. 9/26/07

- Description:** Two-pack high build medium solids clear coat formulated for the METALUX 2™ Basecoat system. It is quick dry with excellent gloss and flow characteristics. METALUX 2™ Lightspeed Clear ensures a proper film build after application of only two coats. This means substantial savings in both application time and product usage.
- Product and Additives:** METALUX 2™ Lightspeed Clearcoat, 9701  
METALUX 2™ MS Hardener Fast, 9091 / Medium, 9092 / Slow, 9093 / Ultra Fast, 9082
- Special Additives:** Matting Base, 8794  
Accelerator, 8784  
Softflex Additive, 8795
- Basic Raw Materials:** Clear: acrylic resin  
Hardener: poly-isocyanate resin
- Suitable Substrates:** METALUX 2™ Lightspeed Clear 9701 has been designed to be applied over METALUX 2™ Basecoat.
- Surface Preparations:** Apply basecoat as needed and allow to flash 15 to 20 minutes @ 25°C / 77° F
- Mixing Ratio:** 3 parts by volume METALUX 2™ Lightspeed Clear 9701  
1 part by volume METALUX 2™ MS Hardener  
Mixed VOC 4.2  
**Note:** 8784 Accelerator is not recommended in MS Hardener Ultra Fast 9082
- Pot Life:** When mixed, 3 hours @ 25°C / 77° F  
**Note:** Accelerator will shorten pot life.
- Process:** Apply 2 to 3 single wet coats with 5 to 10 minute flash between coats.  
**Note:** Cooler temperature and thicker films may require longer flash times.
- Spray Gun Settings:**
- |                 |             |                 |               |                |
|-----------------|-------------|-----------------|---------------|----------------|
| HVLP Gravity    | 1.3 – 1.5mm | 0.5 – 0.6 (Bar) | 8 – 10 (PSI)  | *At the cap    |
| High Efficiency | 1.3 – 1.6mm | 2.0 – 2.7 (Bar) | 30 – 40 (PSI) | Inlet Pressure |
| Conventional    | 1.4 – 1.6mm | 2.7 – 4.1 (Bar) | 40 – 60 (PSI) | Inlet Pressure |
- Note:** Refer to spray gun manufacturers for further information regarding inlet pressures.
- Film Thickness:** 25-30 micron / 1- 1.25 mil per coat dry film.
- Drying Time:**
- |                        |                                                                 |
|------------------------|-----------------------------------------------------------------|
| Dust Free:             | 20 minutes @ 25°C / 77° F                                       |
| Hard Dry:              | 24 hours @ 25°C / 77° F                                         |
| Dry to Lightly Polish: | 6 hours @ 25°C / 77° F                                          |
| Dry to Heavy compound: | 10 hours @ 25°C / 77° F                                         |
| Force Dry:             | 30 to 40 minutes @ 48°C / 130° F                                |
| Infrared Short Wave:   | 3 to 5 min half power followed by 10 to 15 min full power @ 36" |
| Repair/Recoat:         | 24 hours, Best after full cure (± 7 days) @ 25°C / 77° F        |
- Cleaning Equipment:** Clean equipment immediately with quality lacquer thinner or urethane reducer.
- Shelf Life:** 1 year @ 25°C / 77° F. See batch No.
- Health & Safety:** Reference text on label. Flammable – keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.