



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ 2.1 VOC Light Speed Clear 9703

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TD Sheet CS114 rev. 6/3/08

Description:	Two-pack high build medium solids clear coat formulated for the METALUX 2™ Basecoat system. It offers excellent gloss and flow characteristics. METALUX 2™ 2.1 VOC Light Speed Clear 9703 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™ 2.1 VOC Clear 9703 METALUX 2™ MS 2.1 VOC Hardeners: Ultra Fast, 9730 / Fast, 9731 / Medium, 9732 and Slow, 9733
Special Additives:	Matting Base, 8794 Accelerator, 8784 Softflex Additive, 8795
Basic Raw Materials:	Clear: acrylic resin Hardener: poly-isocyanate resin
Suitable Substrates:	METALUX 2™ 2.1 VOC Light Speed Clear 9703 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™ 2.1 VOC Light Speed Clear 9703 1 part by volume METALUX 2™ 2.1 VOC Hardener Note: Accelerator 8784 is not recommended in Hardener Ultra Fast 9730
Pot Life:	When mixed, 3 hours @ 25°C / 77° F Note: Accelerator 8784 will shorten pot life.
Process:	Apply 2 to 3 single wet coats with 5 – 10 minute flash between coats.
Spray Gun Settings:	HVLP Gravity 1.3 – 1.5mm 0.5 – 0.6 (Bar) 8 – 10 (PSI) *At the cap High Efficiency 1.3 – 1.4mm 2.0 – 2.7 (Bar) 30 – 40 (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: 30 minutes @ 25°C / 77° F Hard Dry: 24 hours @ 25°C / 77° F Dry to Lightly Polish: 4-6 hours @ 25°C / 77° F Dry to Heavy compound: 10 hours @ 25°C / 77° F Force Dry: 30 to 40 minutes @ 60°C / 140° F Infrared Short Wave: 15 to 20 minutes 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.