



TECHNICAL DATA SHEET

**LOW VOC 1:1 CLEAR**  
**ACL1521-2.5L/ACL1521-4**

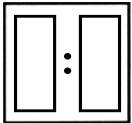
**Description**

Low VOC 1:1 Clear is a crystal-clear acrylic urethane clearcoat designed for 1-3 panel applications. This clearcoat is compliant in all 50 states as well as Canada. This clear sprays and levels easily and has excellent gloss retention and durability. ACL1521 can be air or force dried and is a two-full wet coat system.



**Use suitable respiratory protection**

Axis recommends to use fresh air supply respirator  
Shake well before mixing



1 Low VOC 1:1 Clear  
1 Activator Low VOC

Activators: Fast (BCL1522), Medium (BCL1523), or Slow (BCL1524)

NOTE: 2.1 Easy II Clear can be reduced with compliant urethane grade reducers up to 10%, if needed.



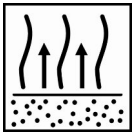
Gravity spray gun set-up:  
1.3 - 1.4 mm

Application pressure:  
8-10 PSI at HVLP

Check gun manufacturer specification



2 full wet coat



Between coats:

5 - 10 Minutes



8 - 12 Hours (air dry)

15 Minutes (Dust Free)

30 Minutes (baked @ 130°F)

Recommended: 2 mm DFT for UV Protection

Read complete TDS for detailed product information

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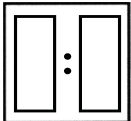
**Product and additives**

- Product:** - Low VOC 1:1 Clear (ACL1521)
- Activators:** - Fast ACT Low VOC (BCL1522), Medium ACT Low VOC (BCL1523),  
Slow ACT Low VOC (BCL1524)

**Suitable Substrates**

- Acrylic or polyester basecoats
- Waterborne basecoat systems
- Activated polyurethane enamel (must be cured at least 8 hours)
- Activated acrylic urethane enamel (must be cured at least 8 hours)
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending.

**Mixing Instructions**



- 1 - Low VOC 1:1 Clear (ACL1521)
- 1 - Activator

**Activators:** Fast ACT Low VOC (BCL1522), Medium ACT Low VOC (BCL1523),  
Slow ACT Low VOC (BCL1524)

**Application method**

Apply 2 full wet coats

**Technical Data**

Color	Clear
Mix Ratio	1:1 (up to 10% Reducer Optional)
Pot Life	60 min. @ 72°F/22.2°C, 50% RH
Gun Setup (HVLP)	1.3 mm – 1.4 mm
Air Pressure	8 – 10 psi HVLP 40 – 45 psi Conventional
% Solids by Weight	40.7% (Sprayable, no reducer)
Shelf Life (Unopened)	12 months
Recommended:	2 mm DFT for UV Protection

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## TECHNICAL DATA SHEET

# LOW VOC 1:1 CLEAR ACL1521-2.5L/ACL1521-4

### VOC / Regulatory information

**Notice:** Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

### HEALTH & SAFETY

#### See Safety Data Sheet and labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.

Revision Date: June 3<sup>rd</sup> 2019

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