



TECHNICAL DATA SHEET

PRODUCTION 2.1 CLEAR
ACL3221-1/ACL3221-4

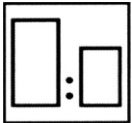
Description

Production II Clear is a premium Acrylic Urethane Clear designed for areas that require certain VOC limits. Production II Clear has excellent gloss retention, leveling and cure properties. Can be air dried or forced dried. Simple 4:1 mix ratio makes this clear easy to use. This clear can be applied over all acrylic water borne and polyester color systems.



Use suitable respiratory protection

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



4 Production 2.1 Clear
1 Production 2.1 Activator

Activators: Fast (BCL3222-4/BCL3222-6), Medium (BCL3223-4/BCL3223-6), or
 Slow (BCL3224-4/BCL3224-6)

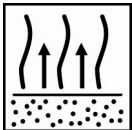


Gravity spray gun set-up:
1.3 - 1.4 mm

Application pressure:
8-10 PSI at the air cap
Check gun manufacturer specification



2 full wet coat



Between coats:
5 - 10 Minutes



10 - 12 hours @ 75°F (air dry)
40 Minutes (baked @ 140°F)

Recommended: 2 mm DFT for UV Protection

Read complete TDS for detailed product information

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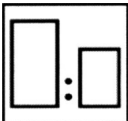
Product and additives

- Product:** - Production 2.1 Clear (ACL3221-1/ACL3221-4)
- Activators:** - Production 2.1 Fast (BCL3222-4/BCL3222-6), Production 2.1 Medium (BCL3223-4/BCL3223-6), Production 2.1 Slow (BCL3224-4/BCL3224-6)

Basecoat

- 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



- 4 - Production 2.1 Clear (ACL3221-1/ACL3221-4)
- 1 - Production 2.1 Activator

Activators: Production 2.1 Fast (BCL3222-4/BCL3222-6), Production 2.1 Medium (BCL3223-4/BCL3223-6), or Production 2.1 Slow (BCL3224-4/BCL3224-6)

Application method

Apply 2 full wet coats

Dry Times

AIR DRY

- Flash between coats: 5-10 minutes
- Dust Free:
- Tack Free: 5 minutes
- Air Dry: 10-12hours@ 75° F(23.9° C)
- Delivery: Next Day
- Stripe/Decal: Next Day
- Recoat: Next Day

EXPRESS DRY

- Flash Between Coats: 5-10 minutes
- Flash Before Force Dry: 5 minutes
- Cycle Time: 40 minutes@ 140° F(60° C)
- Strip Time: 1 hour after cool down
- Decal/Recoat: Next Day

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PRODUCTION 2.1 CLEAR
ACL3221-1/ACL3221-4**Spray gun and pressure**

	Fluid Tip	Spraying Pressure
Conventional Gravity	1.3mm -1.6mm	35-45 psi @ gun
Siphon	1.4mm -1.8mm	35-45 psi @ gun
HVLP	1.3mm -1.4mm	8-10 psi @ air cap

Other Instructions**RECOATABILITY / REPAIR**

Production 2.1 Clear may be recoated for repair after cool down when baked. Air dry repair next day. If recoating after 24 hours scuff with 1200-1500 grit paper.

SANDING, COMPOUNDING, POLISHING▶ **OPTIMUM TIMES**

Express Dry: After cool down

Air Dry:

▶ **SANDING 10-12**

For dirt removal, lightly nib sand with 1500 grit wet paper. For best results compound within 24 hours of application.

▶ **COMPOUNDING**

Using a finishing compound apply a thin ribbon of material to area to be polished. Use a foam polishing pad. Maintain buffer speed at 1500-2200 rpm. Remove excess compound with clean soft cloth before applying polish.

▶ **POLISHING**

Using a finishing polish and foam polishing pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1200-1800 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess polish with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.

(Refer to SDS for proper handling of products listed on this product sheet)

BLENDING

▶ Carefully taper second coat of clear beyond the first.

▶ After the final coat of clear, step out the coating by mixing 1 part blending solvent to 1 part of remaining clear and taper the blend with the resulting mixture.

▶ After the final coat of clear has been blended with the mixture of blending solvent, further reduce the mixture and use the same gun to finish melting in the edge.

Technical Data

Sprayable VOC	2.1 lbs/gal (252 g/l)
% Solids Sprayable by weight	33.8%
Pot Life	1 hours @ 68°F-75°F
Dry Film Thickness	1 mil per coat (D.F.T.)
Shelf Life:	One Year (unopened)
Recommended Film Build:	2 mm DFT for UV Protection

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 3rd 2019

MANUFACTURED FOR / FABRICADO PARA:

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