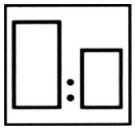
TECHNICAL DATA SHEET

FLAT CLEAR 50 STATE
ACL9000-1/ACL9000-4

Description

Flat Clear 50 State is a matte clearcoat and is 2 component acrylic urethane coating. It mixes in different ratios to achieve different gloss levels. Flat/Eggshell/Semi-Gloss clear coat finish.

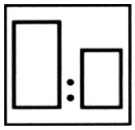
Use suitable respiratory protection
Axis recommends to use fresh air supply respirator
Shake well before mixing



6 Flat Clear 50 State
1 Flat Clear Activator

Flat Finish

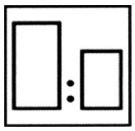
NOTE: For hot temperatures, larger jobs or just for added flow, add 5 – 10% Slow or Extra-Slow Urethane grade reducer



5 Flat Clear 50 State
1 Flat Clear Activator

Eggshell Finish

NOTE: For hot temperatures, larger jobs or just for added flow, add 5 – 10% Slow or Extra-Slow Urethane grade reducer



4 Flat Clear 50 State
1 Flat Clear Activator

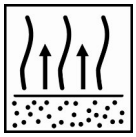
Semi-Gloss Finish

NOTE: For hot temperatures, larger jobs or just for added flow, add 5 – 10% Slow or Extra-Slow Urethane grade reducer

Gravity spray gun set-up:
1.3 - 1.4 mm

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

1 full wet coat + 1 medium coat



Between coats:

5 - 10 Minutes

6 - 8 hours (dry to sand)

Recommended: 2 mm DFT for UV Protection

Read complete TDS for detailed product information

MANUFACTURED FOR / FABRICADO PARA:

Axis™ - Liberty Bell Equipment Corp. 810 N. Jefferson Ave. St. Louis, MO 63106 Phone/Teléfono (888) 646-1400 www.axiscoatings.com

TECHNICAL DATA SHEET

FLAT CLEAR 50 STATE
ACL9000-1/ACL9000-4

Description

Flat Clear 50 State is a matte clearcoat and a 2 component acrylic urethane coating. It mixes in different ratios to achieve different gloss levels. Flat/Eggshell/Semi-Gloss clear coat finish.

INSTRUCTIONS: Make sure product is at room temperature 72˚F (22.2˚C) before mixing

FEATURES:

- Even Finish
- Excellent leveling
- Excellent adhesion
- Excellent chemical resistance
- Flexible
- Long-term durability

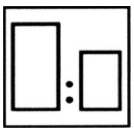
Product and additives

Product:	- Flat Clear 50 State (ACL9000)
Activators:	- Flat Clear Activator (BCL9000)
Additives	- Reducer if needed(no more than 10%)

Suitable surfaces

- **Rigid Plastics**
- Base Coat Systems
- OEM Finishes

Mixing ratios



Flat Finish

6 - Flat Clear 50 State (ACL9000)

1 - Flat Clear Activator (BCL9000)

Semi-Gloss Finish

4 - Flat Clear 50 State (ACL9000)

1 - Flat Clear Activator (BCL9000)

Eggshell Finish

5 - Flat Clear 50 State (ACL9000)

1 - Flat Clear Activator (BCL9000)

Optional Reducer: *For hot temperatures, larger jobs or just for added flow, add 5 – 10% Slow or Extra-Slow Urethane grade reducer*

Technical Data

Potlife	1 hour (72°F (22.2°C) 50% RH
Recommended Film Build:	2 mm DFT for UV Protection

TECHNICAL DATA SHEET

FLAT CLEAR 50 STATE
ACL9000-1/ACL9000-4

Spray gun and pressure

	Fluid Tip	Spraying Pressure
Conventional Gravity	1.3mm -1.4mm	40-45 psi @ gun
Siphon	1.3mm -1.4mm	40-45 psi @ gun
HVLP gravity	1.3mm -1.4mm	8-10 psi @ gun

**Fluid Adjustment for 1.3 mm nozzle—turn out 3 full turns*
**Fluid Adjustment for 1.4 mm nozzle---turn out 2 ½ turns*

Preparation

Surface should be cleaned of all grease, oil, dirt, rust, etc before applying. Wash area with soap and warm water. Thoroughly clean area with a Waterborne Cleaner. Make sure you are using the correct Waterborne Cleaner for your area if VOC restrictions apply.

If applying on top of basecoat, prep surface according to basecoat manufacturers recommendations.
If applying on top of previously clear coated surface or solid colors prep with 400 – 600 grit paper.

Application method

Apply 1 full wet coat followed by 1 medium coat.

Flash times

Flash Time between coats: 5 - 10 minutes

Cleaning of equipment

Clean spray Gun immediately with Cleaning Solvent or Lacquer Thinner.

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: October 14th 2019

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