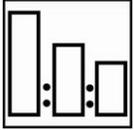


## 2K Topcoats

**FOR PROFESSIONAL USE ONLY**

### Description

Akripol 2K Topcoat is a two-component acrylic topcoat designed for refinishes of passenger cars and commercial vehicles.



100 Akripol 2K Topcoat  
50 Akripol 2K Hardeners  
10-50 Akripol Universal Acrylic Thinners



Use measuring stick

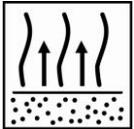


Spray gun set-up:  
1.3-1.4 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2 coats  
First apply a medium closed coat, next apply a full coat



Between coats  
5-10 minutes at 20°C

Before curing  
5-10 minutes at 20°C



	20°C	60°C
Akripol 2K Hardener Extra Fast	8 hours	25 minutes
Akripol 2K Hardener Fast	9 hours	30 minutes
Akripol 2K Hardener Slow	12 hours	30 minutes



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

## 2K Topcoats

FOR PROFESSIONAL USE ONLY

### Description

Akripol 2K Topcoat is a two-component acrylic topcoat designed for refinishes of passenger cars and commercial vehicles.

### Suitable substrates

Existing finishes  
Polyester surfaces  
All AkzoNobel Kemipol primers and fillers products

### Product and additives

Akripol 2K Topcoat

**Hardener** Akripol 2K Hardener Extra Fast: spot and panel repairs at 15°C-25°C  
Akripol 2K Hardener Fast: spot and panel repairs at 20°C-30°C  
Akripol 2K Hardener Slow: larger areas and overall refinishing at 20°C-40°C

**Reducers** Akripol Universal Acrylic Thinner Fast: spot and panel repairs, temperature range: 15°C-25°C.  
Akripol Universal Acrylic Thinner Slow: spot and panel repairs and large areas, temperature range: 20°C-35°C.

**Additives** Akripol Fast-top: spot and panel repairs, temperature range: 15°C-25°C.  
Akripol 2K Accelerator: spot and panel repairs, temperature range: 15°C-25°C.

### Basic raw materials

Akripol 2K Topcoat: Acrylic resins  
Akripol 2K Hardener: Poly-isocyanate resins

### Surface preparation



Remove contamination using an appropriate cleaner



Final sanding step P500  
*For detailed surface preparation see TDS S8.06.02*



Final sanding step P1000  
*For detailed surface preparation see TDS S8.06.02*

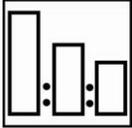


Remove contamination using an appropriate cleaner

## 2K Topcoats

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### Mixing



#### Standard system

**100** Akripol 2K Topcoat  
**50** Akripol 2K Hardeners  
**10-50** Akripol Universal Acrylic Thinners

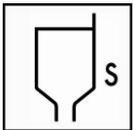
*Use measuring stick*

#### Accelerated systems

**100** Akripol 2K Topcoat  
**50** Akripol 2K Hardeners  
**10-50** Akripol Universal Acrylic Thinners

*Use measuring stick*

### Viscosity



14-16 seconds DIN Cup 4 at 20°C.

### Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.3-1.4 mm

**Application pressure**  
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

### Application process & blending



Apply a medium closed coat, allow for a 5-10 minutes flash-off time and apply a full coat.  
Flash off 5-10 minutes before baking.

### Pot-life

Akripol 2K Hardener Fast  
Akripol 2K Hardener Slow

5 hour

at 20°C

8 hour

at 20°C

### Film thickness

By using recommended application 40 - 50 µm

## 2K Topcoats

**FOR PROFESSIONAL USE ONLY**

### Drying times

Allow for a minimum of 5 minutes flash off time at 20°C before moving the car into a pre-heated drying oven (booth) at 60°C. All drying times relate to standard application and object temperature.  
*Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.*



	20°C		60°C	
	Dust dry	Dry to handle	Dust dry	Dry to handle
Akripol 2K Hardener Extra Fast	15 minutes	8 hours	5 minutes	25 minutes
Akripol 2K Hardener Fast	20 minutes	9 hours	10 minutes	30 minutes
Akripol 2K Hardener Slow	30 minutes	12 hours	10 minutes	30 minutes



Allow 5 minutes flash off prior to infra red curing  
The panel temperature should not exceed 100°C.

### Polishability



Ready to polish after the stated air-dry times or 1 hour after cool down to ambient temperature

### Material usage

By using the recommended application 40µm , the theoretical material usage is ± 9 m<sup>2</sup>/liter RTS mixture.

*The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

### Cleaning of equipment

Akripol Super Cellulosic Thinner

# 2K Topcoats

**FOR PROFESSIONAL USE ONLY****Product storage**

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.



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**HEALTH & SAFETY DATA concerning Akripol 2K Topcoat and additives:**

For professional use only.(See Material Safety Data Sheet). See text on the label of this product. The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

The effectiveness of our systems is based on laboratory research and many years' practical experience. We guarantee that the quality of the work performed according to our system meets the AKZONOBEL KEMİPOL A.Ş standards, provided that our instructions are carefully followed and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.

[www.akripol.com.tr](http://www.akripol.com.tr)

**AKZONOBEL KEMİPOL A.Ş. İzmir, TÜRKİYE**