

ACRITOP FAST

Series 3950

UHS fast drying glossy acrylic top coat for single stage



TECHNICAL FEATURES

Acrylic enamel with particularly fast polymerization that allows it to be used even in natural drying conditions at room temperature without the aid of the oven cabin. The product is characterized by a high sagging stability, excellent flow, important surface hardness, high mechanical resistance and ease of application.

APPLICATION FIELD

Ultra high solid acrylic enamel ideal as a final coat in solid/pastel for car-refinish coating systems, industrial bodywork and industrial vehicles. This product is also applicable for products in the ACE sector when a car-refinish finish is requested, thanks to the features of high quality, body effect and filling power typical of the products. These attitudes relating to the automotive sector allow, in fact, to enhance the finishes of agricultural machinery, earthmoving machinery, high quality industrial machinery, metal structures to the point of elevating them to bodywork products. It is the ideal product where high resistance to atmospheric agents and excellent gloss and color retention are required.

GENERAL INFORMATION

System: Two pack - 2K

Nature: Solvent-based

Packages: 4 l - 4 kg - 20 kg

Tinting Service: Tinting service with solvent-based colorants Series 0615

Colors ready in stock: White

Color fans and color cards: Ral 841 GL, Ral Design, Ncs 1950, ColoradoMix 1040, Colorado Box 2.0

SUBSTRATE PREPARATION

As this is a finishing product, in case of outdoor application or where anticorrosive protection is required, it is necessary to first apply a suitable primer. The preparation of the substrate must be carried out with reference to what is indicated in the specific technical data sheet of the appropriate primer. In order to investigate and select the ideal coating system, it is advisable to consult the technical assistance service or the commercial support in order to obtain the precise indication of the suitable primers to be used according to the type of product and the support to be painted. Finally, it is essential to respect the overcoating times of the primer.

APPLICATION

Application conditions

The application of the coating product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), geometry and laboriousness of the products to be painted, surface profiles and thicknesses to be applied. The application system to be used is of particular importance as, depending on the type of system, various parameters may vary including the transfer efficiency of the coating product, the overspray, the aesthetic appearance obtained, the sagging stability of the product and the ease or complexity of application. For these reasons, prior to applications on systems and lines of considerable scope, it is advisable to contact the technical assistance service in order to carry out the inspection and the necessary surveys for a consultancy activity relating to the application methods and the definition of ad hoc technical details on the plant in question.

Spray application with HVLP/LVLP gravity gun with 1,3 - 1,5 mm nozzle is recommended.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	20" - 30" Ford Cup 4	1,3 - 1,5 mm	2 - 2,5 bar	HVLP/LVLP
AIRMIX	Depending on application parameters	11 - 13	60 - 100 bar	-

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CATALYSIS

SERIES	HARDENER	CATALYSIS	USE	POT LIFE AT 20°C	PACKAGE
1383	STANDARD HS HARDENER	50% by volume (2:1)	Standard	2 hours	1 l - 5 kg
1392	HS PLUS 420 HARDENER	25% by weight (100 + 25) or 4:1 by volume	HS, slow for exterior use	2 hours	1 l - 2,5 l
1385	STANDARD UHS ACRYLIC HARDENER	40% by weight (100+40)	Standard UHS	2 hours	0,5 l - 2,5 l - 25 kg

ENVIRONMENTAL CONDITIONS



ENVIRONMENT
TEMPERATURE

5°C - 35°C



SUBSTRATE
TEMPERATURE

5°C - 35°C



RELATIVE
HUMIDITY

60 %



SHELF LIFE

Store 2 years in original sealed packaging
at +5/+35°C.

TECHNICAL DATA



THEORETICAL AVERAGE SPREADING RATE	APPLICATION	DILUTION	GLOSS	WET FILM THICKNESS EACH COAT	DRY FILM THICKNESS EACH COAT	N° OF COATS	TOTAL DRY FILM THICKNESS	THEORETICAL AVERAGE CONSUMPTION
10,5 m ² /kg each coat at the dry film thickness of 40 µ	Spray	5-10% with PUR Thinner Series 0988	90 - 95 gloss	80 µ	40 µ	1 or 2 coats to achieve the total desired thickness	60 µ	95 g/m ²

DRYING



OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
1 - 48 hours (after it is necessary to sand)	20°C	20 - 30 minutes	1 - 2 hours	24 - 48 hours	7 days	Between the two coats: 1 - 2 minutes at 20°C Before the hot forced air drying: 5 - 10 minutes at 20°C	30 minutes at 50°C - 60°C	80°C continuous exposure

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WARNINGS AND RECOMMENDATIONS

- The use of nitro thinners for the application of polyurethane coating systems can create pitting phenomena on the surface of the dried film. Furthermore, the presence of partially reactive solvents can give rise to undesired reactions, reducing the aesthetic and mechanical features of the system. The choice of unsuitable regenerated thinners can create problems of color change, product sedimentation and less effectiveness in reducing viscosity.
- The product has good resistance to solvents in general, intended as temporary contact and limited in time. Therefore, it is not suitable for permanent immersion contact with solvents.
- The color match is evaluated after the application and drying of the product. It is recommended to carry out practical tests, such as spreading or applying the colored product on small surfaces made of suitable material, before proceeding with the product painting.
- After having colored the product with the suitable colorants, mix it in a short time.
- In order not to incur financial penalties, after having colored a product with tinting machine, send the MSDS and apply the appropriate legal labelling printable using the Databook P&C tinting software.
- For slightly matt colored products (yellow, orange, red) it is recommended to use a suitable white primer.
- Shelf Life Component B: the shelf life of the hardener used with Component A is 12 months.
- The product can be catalysed both with the hardener Series 1383 (standard catalysis), and with the hardener Series 1340 (in case of high temperatures above 30-35°C and for large surfaces). In both cases:
 - for the colors realized from the binder, catalyse at 50% by weight (100+50) and at 50% by volume (2:1)
 - for white color and for the shades derived from white, catalyse at 40% by weight (100+40) and at 50% by volume (2:1)
- With the hardener Series 1340, the use of the thinner Unithinner Slow Series 1507 is recommended.
- If the product is catalysed with HS PLUS 420 HARDENER Series 1392
 - for the shades realized from the binder, catalyse at 25% by weight (100 + 25) and 4:1 by volume
 - for the white color and all colors realized from white, catalyse at 20% by weight (100 + 20) and 4:1 by volume

SUPPLY TECHNICAL DATA

Composition: Hydroxylated modified acrylic

Reference color: White

% solid content by weight: 70,5 ± 2%

% solid content by volume: 58,3 ± 2%

VOC: 385,6 ± 2 g/l

VOS: 29,5 ± 2%

PARAMETER	DATA	TEST METHOD
GLOSS	90 - 95 gloss 60°	ISCOL 6
VISCOSITY	1200 - 1600 mPa.s (20°C) Rod 3 Speed 20	ISCOL 1
SPECIFIC WEIGHT	1 - 1,3 g/ml	ISCOL 2

MIXING RATIO A+B

Specific weight after catalysis (A+B): 1,17 ± 0,05 g/ml

% solid content by weight (A+B): 52 ± 2%

% solid content by volume (A+B): 46 ± 2%

VOC (A+B): 480 ± 2 g/l

VOS (A+B): 47 ± 2%

METHOD	1383 (Binder)	1383 (White)	1392 (Binder)	1392 (White)	1385 (Binder)	1385 (White)
A+B BY WEIGHT	100 + 50	100 + 40	100 + 25	100 + 20	100 + 40	100 + 40
A+B BY VOLUME	2:1	2:1	4:1	4:1	100 + 40	100 + 50

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TINTING SERVICE

BASE	BASE PACKAGING	COLORED PACKAGING	% MIXING RATIO
BINDER	2,8 kg 14 kg	4 kg 20 kg	70 + 30
WHITE BASE	4 l 20 kg	4 l 20 kg	100 + Max 5%

NOTES

Cleaning tools: At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

Sanitary labelling: Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

Additional notes:

- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, different from those suggested or not manufactured by Franchi & Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi & Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- The times related to pot life and drying intervals refer to a standard temperature of 20°C, except when it is expressly indicated.
- The data relating to section mixing ratio A+B are to be considered referring only to the first recommended catalyst.
- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.
- Pot Life times have been defined at the temperature of 20°C, therefore higher or lower temperatures, hardeners, environmental conditions and humidity different from the standard can influence in defect or in excess the duration of the Pot Life.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website www.franchi-kim.com in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

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