

PRODUCT NAME	
Acrythane XSC98/08	
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FORMULA NO	3660
PRODUCT CODE	TOPXSC98/08

**HMG PAINTS LTD**Tel: 0161 205 7631 / Fax: 0161 205 8823
www.hmgpaint.com / sales@hmgpaint.com**PRODUCT DESCRIPTION**

Acrythane XSC98/08 is an Ultra High solids 2K Acrylic Topcoat system for Commercial Vehicles, Coaches, Buses, Rail, Industrial and Marine applications.

It offers outstanding properties including rapid drying even at low temperatures, high gloss, simplicity of usage but above all superb long term durability. Excellent protection is afforded against harsh weather conditions, atmospheric pollution, road dirt, sharp cleaning agents, mechanical car washes and most industrial chemicals.

**MAXIMUM VOC CONTENT (RFU)**

0.415kgs/ltr

REGULATIONS / COMPLIANCE

2004/42 IIB (D) 420

**TECHNICAL INFORMATION**

FLASHPOINT	23°C
TEMP RESISTANCE	120°C
STORAGE	12 months in original sealed containers

**CLEANING**

Ensure surfaces to be coated are dry and free from all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to Preparatory Cleaner index.

**SURFACE PREPARATION**

Please refer to HMG Technical Library for details on surface preparation.

**HEALTH AND SAFETY**

Refer to JD11/77 health and safety data sheet.
Refer to MSDS and tin label prior to use.
Suitable respiratory equipment should be worn when spraying.

APPLICATION METHODS

COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	

MIXING RATIO

COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	
Base 2 Hardener 1 Thinner <0.5	Base 2 Hardener 1 Thinner <0.5	Base 2 Hardener 1 Thinner <0.5	

HARDENER OPTIONS

COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	
Hardener 9039	Hardener 9039	Hardener 9039	

THINNER OPTIONS

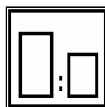
COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	
Thinner 2604	Thinner 2604	Thinner 2604	

VISCOSITY

COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	
19-25 seconds DIN4	19-25 seconds DIN4	19-25 seconds DIN4	

SPRAY GUN SETUP

COMPLIANT SPRAY GUN	PRESSURE POT	AIRLESS/AIR-ASSISTED	
1.8	1.1-1.4	11-13 thou 40/50°	





NUMBER OF COATS			
1 medium + 1 full	1 medium + 1 full	1 full	



FLASH OFF			
15 mins between coats	15 mins between coats		



DRYING TIME							
Hard dry	16 hrs @ 20°C	Hard dry	16 hrs @ 20°C	Hard dry	16 hrs @ 20°C		
Hard dry	30 mins @ 70°C	Hard dry	30 mins @ 70°C	Hard dry	30 mins @ 70°C		



RECOATABILITY / OVERCOATING			
Flat with 500's after Hard Dry	Flat with 500's after Hard Dry	Flat with 500's after Hard Dry	



POT LIFE			
1 hr @ 20°C	1 hr @ 20°C	1 hr @ 20°C	



WET FILM THICKNESS			
80 microns	80 microns	80 microns	



DRY FILM THICKNESS			
50 microns	50 microns	50 microns	

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