

# AUTOEMAIL 2K ACRYLIC PAINT STANDARD

Technical Data Sheet No 615



A high performance two component fast drying acrylic mix system

High gloss finish

Excellent scratch resistance

High mechanical and chemical endurance

## General Technical Description



Mix 2:1 with H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS  
Pot life: 2 - 6 h / 23°C (73°F)  
or 3:1 with 716 SLOW / 717 NORMAL / 718 FAST HARDENER  
Pot life: 1 - 5h / 23°C (73°F)



Thinner addition  
2:1 10-15%  
3:1 10%  
740 ACRYL NORMAL / 741 ACRYL SLOW THINNER



Ready to spray:  
2:1 17-23 s / 23°C (73°F)  
3:1 21-25 s / 23°C (73°F)  
Cup 4 - DIN 53211



20-30 min / 60°C (140°F) panel temperature  
10-14 h / 23°C (73°F)

## Surface

On sanded HB Body primed surfaces

On HB Body wet on wet primed surfaces

On sanded OEM surfaces

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

## Product Application: Apply 2 coats. Keep flash off time between coats.



Mix well



Filter before application



Mix 2:1 with H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS  
Pot life: 2 - 6 h / 23°C (73°F)  
or 3:1 with 716 SLOW / 717 NORMAL / 718 FAST HARDENER  
Pot life: 1 - 5h / 23°C (73°F)



Thinner addition  
2:1 10-15%  
3:1 10%  
740 ACRYL NORMAL / 741 ACRYL SLOW THINNER



Ready to spray:  
2:1 17-23 s / 23°C (73°F)  
3:1 21-25 s / 23°C (73°F)  
Cup 4 - DIN 53211



Compliant Spray gun  
1.3 - 1.5 mm  
2 - 3 bar (29 - 44 psi) inlet pressure  
2 coats = 40-50 micron (1.6 - 2 mil)



HVLP 1.2-1.3 mm  
1.7-2 bar (25-30 psi) inlet pressure  
0.7 bar (10 psi) drop pressure  
2 coats= 40-50 µm (1.6-2 mils)



Flash off time  
8 - 15 min / 23°C (73°F)



20 - 30min / 60°C (140°F) panel temperature  
10 - 14h / 23°C (73°F)



Always wear protective equipment



Follow the application instructions mentioned in this TDS

**Flash Point:**  
28°C / 82°F

**Specific Gravity:**  
0.9 - 1.18 g/cm<sup>3</sup> \*

**Solid Content (No thinner):**  
36 - 58% Weight

**VOC (2004/42/EC)**  
This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 570 g/L.  
2004/42/IB(e)(840)570

**Theoretical Coverage:**  
7-11 m<sup>2</sup> / l at 50 micron dry film thickness

**Cleaning of equipment:**  
Clean after final use with 740 ACRYL NORMAL THINNER or 767 ECO THINN NITRO THINNER

## Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER
- After preparing the area to be painted ensure it that is free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well.
- Application temperature from +10°C to +35°C (50°F - 95°F)

## Storage shelf life:

- Store in a cool place (+5°C - +25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

*\*Specific gravity values lie within a range and depend on the color shade*

**2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.**

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Issue 7 / 2019, October 2019