








Technical data sheet **NOVAKRYL 540**

Acrylic clearcoat

Two-component acrylic clearcoat with increased scratch resistance (SR)

PROPERTIES			
NOVAKRYL 540 – an acrylic clearcoat that is highly scratch resistant (SR). The product has a very short drying time. It is recommended for fast repairs. The product reaches operating hardness in just 20 min at 60°C or after 8 h at 20°C. Does not lose gloss over time. It is UV and weather resistant.			
RELATED PRODUCTS			
H 5140	NOVAKRYL 540 hardener for acrylic clearcoat		
THIN 850	Acrylic thinner Standard, Fast and Slow		
PLUS 770	Elasticity increasing agent		LT-04-01
PLUS 750	Acrylic accelerating agent		LT-04-02
PLUS 760	Antisilicone additive		LT-04-04
THIN 890	Fade out Thinner.		LT-06-05
SUBSTRATES			
Compatible with the majority of solvent and waterborne basecoats available on the market.			
MIXING RATIO			
		Volume ratio	Weight ratio
	NOVAKRYL 540	2	100
	H 5140	1	49
	THIN 850	20%	18
Apply the thinner in the amount calculated for the clearcoat.			
VISCOSITY			
	DIN 4/20°C	16 – 18 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS			
VOC II/B/e limit*		840 g/l	
Actual VOC content		620 g/l	
* For ready to use mixture acc. to EU Directive 2004/42/CE			

APPLICATION CONDITIONS				
<p>It is recommended to apply the clearcoat at a temperature above 15°C and a humidity of no more than 80 %. Under such conditions, the cured coating can be used after no less than 14 hours.</p>				
APPLICATION				
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>		Nozzle	Pressure	Distance
	Conventional gravity fed spray gun	1.3 – 1.4 mm	3 – 4 bar	15 – 20 cm
	Low-pressure gravity fed spray gun	1.2 – 1.3 mm	2 bar	10 – 15 cm
	Number of layers	2 – 3		
	Single dry layer thickness	20 – 25 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	7.2 m ² /l at 50 µm		
	Mixture life at 20°C	30 min		
	Flash off between layers at 20°C	3 – 5 min		
CURING TIMES				
	H 5140			
	20°C	60°C		
Dust-free	15 min	5 min		
Tack-free	2 h	7 min		
Operating hardness	8 h	20 min		
Ending hardness	5 days	20 min + 3 days/20°C		
<p>CAUTION: The curing times apply to the temperatures of the individual elements. Drying the coat with a fast hardener at an increased temperature can deteriorate the gloss and makes it necessary to polish the coat. The fast hardener should not be used with the PLUS 750 acrylic accelerating agent.</p>				
IR DRYING				
	Distance	Follow the recommendations of the equipment manufacturer		
	Time depending on the type and power of the lamp	10 – 25 min		
<p>CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.</p>				

THIN 850 ACRYLIC THINNER			
Surface	15 — 20°C	20 — 25°C	25 — 35°C
Small 1-2 elements, spot repair	THIN 850 Fast	THIN 850 Standard	THIN 850 Slow
Medium 3 elements	THIN 850 Standard / Fast	THIN 850 Standard / Slow	---
EQUIPMENT CLEANING			
THIN 850 acrylic thinner or NC solvent.			
STORAGE CONDITIONS			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			
SHELF LIFE			
NOVAKRYL 540	24 months/20°C		
H 5140	12 months/20°C		
THIN 850	24 months/20°C		
SAFETY			
See Safety Data Sheet.			
OTHER INFORMATION			
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.			

ADDITIONAL INFORMATION			
WEIGHT QUANTITY OF COMPONENTS: 2+1+20%			
CAUTION!			
In order to obtain a paint coating with appropriate parameters it is very important to exactly dose the individual components.			
Mixture quantity	NOVAKRYL 540	H 5140	THIN 850
0.10 l	59 g	29 g	10.5 g
0.15 l	88 g	43 g	16 g
0.20 l	117 g	57 g	21 g
0.25 l	146 g	72 g	26 g
0.30 l	176 g	86 g	31 g
0.40 l	234 g	115 g	42 g
0.50 l	293 g	144 g	52 g
0.75 l	439 g	215 g	78 g
1.00 l	585 g	286 g	105 g