

Technical data sheet

NOVAKRYL 520

Acrylic clearcoat

Two-component VHS acrylic clearcoat

PROPERTIES			
NOVAKRYL 520 is a clearcoat with high solid particle content. The product dries quickly and gives a high gloss and great depth. The clearcoat achieves high ending hardness both at elevated temperatures and without heating. The Novakryl 520 meets the requirements of Directive 2004/42/EC of 21 April 2004 on the limitation of emissions of volatile organic compounds. It is UV and weather resistant.			
RELATED PRODUCTS			
H 5110	Hardener 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			
The product is compatible with the majority of commercial thinner and waterborne basecoats.			
MIXING RATIO			
	NOVAKRYL 520 H 5110	Volume ratio	Weight ratio
		2	100
		1	50
VISCOSITY			
	DIN 4/20°C	17 ÷ 19 s	
VOC CONTENT			
VOC II/B/d limit*		420 g/l	
Actual VOC content		415 g/l	
* For ready to use mixture acc. to EU Directive 2004/42/EC			
APPLICATION CONDITIONS			
It is recommended to apply the clearcoat at temperatures above 15°C and in humidity of no more than 80%. Under these conditions the cured coating can be used after a minimum of 10 hours.			

APPLICATION						
 CAUTION: Instructions of the equipment manufacturer must be followed.	Conventional gravity-fed spray gun		Nozzle	Pressure	Distance	
			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		1.5			
	Single dry layer thickness		30 ÷ 35 µm			
	The yield of the ready to use mixture for the given range of dry layer thickness		10.5 m ² /l at 50 µm			
	Mixture life at 20°C		H 5110 Slow, Standard		H 5110 Fast	
			45 min		30 min	
	Flash off between layers at 20°C		5 ÷ 10 min			
CURING TIMES						
	H 5110 Slow		H 5110 Standard		H 5110 Fast	
	20°C	60°C	20°C	60°C	20°C	60°C
Dust-free	40 min	5 min	30 min	5 min	20 min	5 min
Tack-free	3 h	10 min	3 h	10 min	2 h	10 min
Operating hardness	12 h	35 min	10 h	30 min	9 h	30 min
Ending hardness	7 days	35 min + 3 days/20°C	7 days	30 min + 3 days/20°C	5 days	30 min + 2 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 make polishing the coat necessary. The fast hardener should not be used with PLUS 750 acrylic accelerating agent.</p>						
IR DRYING						
	Distance Time depending on the type and power of the lamp		Follow the recommendations of the equipment manufacturer 10 ÷ 25 min			
<p>CAUTION: Start IR heating at least 10 min after applying the last layer.</p>						

USE			
Surface	15 ÷ 20°C	20 ÷ 25°C	25 ÷ 35°C
Small 1-2 elements, spot repair	H 5110 Fast	H 5110 Standard, Fast	H 5110 Standard
Moderate 3-5 elements	H 5110 Fast	H 5110 Standard	H 5110 Slow
Large over 5 elements	H 5110 Standard	H 5110 Standard	H 5110 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 520	24 months/20°C		
H 5110 Standard, Slow	18 months/20°C		
H 5110 Fast	12 months/20°C		
SAFETY			
See the Safety Data Sheet.			
OTHER INFORMATION			
Registration number: 000024104.			
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 perform 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.			

OTHER INFORMATION

WEIGHT QUANTITY OF COMPONENTS: 2+1

CAUTION! In order to obtain a paint coating with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	NOVAKRYL 520	H 5110
0.10 l	67 g	33 g
0.15 l	100 g	50 g
0.20 l	134 g	67 g
0.25 l	167 g	83 g
0.30 l	201 g	100 g
0.40 l	268 g	133 g
0.50 l	325 g	166 g
0.75 l	502g	250 g
1.00 l	669 g	333 g