

# ACRYLON AIR DRY 5100

2:1 CLEAR COAT

## CHARACTERISTICS

- ultra-fast, VOC compliant 2-pack acrylic clear coat of next generation, enriched with biobased components
- ideal for both, spot repairs and for painting the entire side of the vehicle
- developed for efficient air-dry processes
- easy and quick application
- high throughput
- excellent levelling
- quick flash-off time and extreme drying
- compatible with solvent- and waterborne basecoats

## RELATED PRODUCTS

CLEAR COAT      ACRYLON AIR DRY 5100 (E1-103.036)  
HARDENER      HARDENER 510 (E1-102.077)

## MIXING RATIO



Clear coat  
Hardener

By volume

2  
1

By weight

100  
52

## PROCESS CONDITIONS



temperature 18-22°C, relative air humidity 40-60%

## VISCOSITY



15-17 s DIN 4 mm

## SPRAY GUN SET-UP AND APPLICATION PRESSURE



Gravity feed, 1.3 mm  
Pressure according to spray gun manufacturer's recommendations

## APPLICATION



Number of layers: ½ thin closed coat and 1 full wet coat layers  
film thickness wet/dry: 90-100 µm / 50-60 µm

## FLASH-OFF



between coats: 5-6 min at 20°C, before baking: 10 min at 20°C

## POT LIFE



40 min at 20°C

## DRYING



	20°C	40°C	50°C	60°C
Object temperature	20°C	40°C	50°C	60°C
Dry to touch	30 min	5 min	5 min	4 min
Dry to polish	60 min	15 min	10 min	5 min
Full hardness	4 days	15 min + 4 days/20°C	10 min + 4 days/20°C	5 min + 4 days/20°C

## POLISHABILITY



Ready to polish after the specified air-dry time or one hour after cooling to ambient temperature.

## VOC

VOC 2004/42/IIB(d)(420) max. 420 g/l

## SHELF LIFE

12 months for clear coat  
12 months for hardener

## DENSITY

clear coat: 0.98-1.0 g/cm<sup>3</sup>  
hardener: 1.01-1.03 g/cm<sup>3</sup>

## THEORETICAL EFFICIENCY

10-12 m<sup>2</sup>/l

## COLOUR

clear coat: colourless / slightly yellow  
hardener: colourless / slightly yellow

## REMARKS



Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product at a temperature below 18°C. Low application temperature changes the characteristics of the coating finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

## STORAGE AND TRANSPORTATION CONDITIONS



Protect from freeze, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage temperature: +10 to +30°C.

