Metacryl FL – 2.8 VOC High Solids

COMPONENTS	FL – 2.8 VOC High Solids 7360, 7361,7362 or 7363 Hardener 7373 Reducer
APPLICATION	2 medium wet coats Cross-coated with no flash or 5-10 minute flash time between coats
MIX RATIO	2 : 1 : 2 – 5%
DRY TIME	Hand Slick: 10 Minutes Dust Free: 30 Minutes Dry to Clearcoat: 60 Minutes Dry to Handle: Overnight
VISCOSITY	ZAHN #3 10 – 18 Seconds
VOC	2.8 lbs/gal 335 g/L

GENERAL

DESCRIPTION

Metacryl FL 2.8 VOC High Solids is a state of the art single stage topcoat, that provides excellent hiding and reduced application times. Metacryl FL has excellent chemical resistance and superior weatherability properties with a long lasting high gloss finish. Numerous color formulas are available, including metallic and pearls.

COMPATIBLE SUBSTRATES

- All Metacryl 2K Primers and Sealers
- Properly prepared OEM or aged finishes

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Mix 2 parts FL 2.8 VOC High Solids to 1 part 7360, 7361, 7362 or 7363 Hardener to 2 – 5% 7373* Reducer.
***May be added to aid application.**

Component	Volume
Metacryl FL 2.8 VOC High Solids	2
Metacryl 7360, 7361, 7362 or 7363 Hardener	1
Metacryl 7373 Reducer	2 – 5%

HARDENER SELECTION

- 7360 Fast 65 – 75°F/18 – 24°C
- 7361 Medium 75 – 85°F/24 – 29°C
- 7362 Slow 85 – 95°F/29 – 35°C
- 7363 Extra Slow 85°F+/29°C

SPECIALTY COMPONENTS
7377 Accelerator: 1 – 3%
7376 Fisheye Eliminator: Max 2%
7349 Matting Base

POT LIFE
4 Hours at 77ºF/24ºC / 50% R.H.

APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.5 mm	6 - 10 PSI	*At the cap
High Efficiency	1.3 - 1.5 mm	30 PSI	At gauge
Pressure Pot	1.0 – 1.1 mm	6 - 10 PSI	*At the pot

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

APPLICATION
Spray 2 medium wet coats, can be cross-coated with no flash, or allow 5-10 minutes flash time between coats. Metallic colors may require a mist or drop coat to even the appearance and reduce mottling.

CLEAN-UP
Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.

DRY TIMES

AIR DRY
@ 75°F/23°C

Hand Slick	10 Minutes
Dust Free	30 Minutes
Tape Free	4 – 6 Hours
To Clearcoat	60 Minutes
To Handle	Overnight
Force Dry Time	40 Minutes at 140ºF/60ºC
To Sand/Buff	After Cool Down (1 – 2 Hours)

PHYSICAL PROPERTIES

RTS VOC	2.8 lbs/gallon
RTS Volume Solids	50.0 – 55.0% (Average)
ZAHN #3 Viscosity	10 – 18 Seconds
DFT per Coat	Approximately 1.0 mil
Theoretical Coverage	Approx. 800 SqFt at 1 Mil DFT/mixed gallon
Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6hr Base (NaOH) – No effect, 6hr Skydrol – No effect, 6hr
Flexibility	Pass Conical Mandrel
Film Hardness	2H
Direct Impact	100 in/lbs
Reverse Impact	80 in/lbs
Product Class	2K Single Stage

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

VOC REGULATED AREAS

VOC as Applied	335 grams/liter | 2.8 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States and Canada:
1.855.6.AXALTA
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