




Metalux™ 9354 2K High Solids Clearcoat




COMPONENTS
9354 2K HS Clearcoat
Hardeners (9351,9352)
Reducers (1156,1157,1158)



APPLICATION
1 mist coat + 1 full wet coat
Up to 0-5 minute flash between coats




MIX RATIO
2 : 1 : 5-10%



DRY TIME
To Light Polish - 16 Hours
To Heavy Compound - 24 Hours
Force Dry - 30-40 Minutes



VISCOSITY
Ford #4
17 seconds



VOC
419 grams / liter
3.5 lbs / gallon



GENERAL

DESCRIPTION

Metalux™ 9354 2K HS Clearcoat is a high build, high solids clearcoat has been formulated for the Metalux basecoat system. This clearcoat offers excellent gloss and flow characteristics. The correct film build can be achieved after only one full wet coat.

COMPATIBLE COATINGS

Compatible with Metalux primer, sealer, and clearcoat products

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



MIXING

COMPONENTS

Mix 2 parts Metalux 9354 2K HS Clearcoat to 1 part Metalux 2K HS Hardener (9351 or 9352). Add 5-10% Universal Reducer.

NOTE: If temperatures are bordering 68°F/20°C or cooler, we strongly recommend the use of an accelerator at a level of 9 grams per 24 oz (680 grams). Accelerator is not recommended if baking.

Component	Volume
Metalux 9354 2K HS Clearcoat	2
Metalux 2K HS Hardeners (9351 Fast, 9352 Normal)	1
Metalux Universal Reducers (1156 Fast, 1157 Medium, 1158 Slow)	5-10%



Package Sizes

- 1 gallon (3.75 liters)

INITIAL APPLICATION VISCOSITY

Ford #4 Viscosity 17 seconds



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	2.0 - 2.5 (Bar)	8-10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	2.0 - 2.5 (Bar)	27-32 PSI	At gauge

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

SURFACE PREPARATION

Apply basecoat as needed and allow to flash 15 to 20 minutes @ 77°F/25°C.

NOTE: When using with a water basecoat, allow clearcoat to flash for an additional 20 minutes @ 77°F/25°C after dry process.

APPLICATION

Spray one mist coat followed by an immediate full wet coat or allow up to 5 minute flash between coats. If baking, a purge of 10 minutes is required. Follow the defined bake times.

NOTE: Cooler temperature and thicker films may require longer flash times. Do not expose to rain or excessive moisture for 24 hours. Applying graphics is best after 7 days or full cure.

VERY IMPORTANT: If applying multiple coats, contact Axalta Technical Rep.

RECOAT

Can be recoated after 24 hours. Best after full cure (7 days @ 77°F/25°C).



DRY TIMES

AIR DRY

77°F (25°C)

Hand Slick	10 Minutes
Dust Free	30 Minutes
Hard Dry	24 Hours
To Light Polish	16 Hours
To Heavy Compound	24 Hours
Force Dry Time	30-40 Minutes @140°F (60°C)



PHYSICAL PROPERTIES

Recommended Film Thickness	75+ microns / 3.0 mils per coat
Mixed Volume Solids	59.5% (Average)
Theoretical Coverage	N/A
Recommended Coats	1 Full Wet (x1)
DFT per Coat	Approximately 3.0 mil



STORAGE CONDITIONS

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

PERFORMANCE PROPERTIES

Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6 hrs. Base (NaOH) – No effect, 6 hrs. Skydrol – No effect, 24 hrs.
Film Hardness	2H
Impact Resistance	Forward – 100 in/lbs Reverse – 60 in/lbs
Flexibility	Pass Conical Mandrel
Crosslinking	All crosslinking stop at 60°F/15°C

VOC REGULATED AREAS

VOC as Applied 419 grams/liter | 3.5 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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