

GENERAL INFORMATION

AT001 HS Taping Additive improves curing of the HS420 top coat and prevents the risk of marks caused by masking for multi-colour paintwork on commercial vehicles and passenger cars. AT001 HS Taping Additive allows you to apply multiple colours within a short time frame.

MIXING RATIO



2 : 1 HS420 Top Coat : H2O Octocoat Hardener +
20% AT001 HS Taping Additive

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	2/29
HE	1,2-1,3	2,0-2,5/29-36
Pressure tank	0,85-1,1	-
Airless/ Airmix	0,009"- 0,011"/40°	180-200

APPLICATION



1,5 - 2 coats 50 - 75 µm (2,0 - 3,0 mil)

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	-	Flash off	5 minutes
Dust free	-	Dust free	-
Dry to handle	-	Dry to handle	10 minutes
Dry to tape	-	Dry to tape	After cooling down
Dry to sand	-	Dry to sand	After cooling down
Dry to polish	-	Dry to polish	After cooling down

SUBSTRATES



F00 - F98 Octocoat HS420 System should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/surfacer by checking the TDS of the primer/surfacer.

POT LIFE AT 20°C / 68°F



15 minutes

COMPONENTS



F00 - F98 Octocoat HS420 System
H2O Octocoat Hardener
TA875 Fade-Out Thinner

ADDITIVES



Octocoat Thinner to be replaced by AT001 HS Taping Additive.

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P400 or finer grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with TD20 Silicone Remover wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



PHYSICAL DATA

PHYSICAL DATA AT001 HS TAPING ADDITIVE		
Chemical Base	Mix of organic solvents with catalyst	
Physical Properties	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,92
	Flash Point Closed Cup	27°C / 80,6°F
	Volume % Solids	2,7
	Economy	-
	Gloss	-
	Colour	-

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



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