



OCTORAL

A00 - A98

OCTOCRYL SYSTEM



GENERAL INFORMATION

A00 - A98 Octocryl System is a high gloss 2-pack polyurethane finish, both air drying and force drying. A01 Fleet Additive can be used for commercial vehicles or bigger objects.

MIXING RATIO



2 : 1 Top Coat : 2K/MS Hardener + 0 - 10 % Uni Thinner
3 : 1 Top Coat : HS Hardener + 0 - 10 % Uni Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2 - 1,4	2/29
HE	1,2 - 1,4	1,8 - 2,0 / 26 - 29
Pressure tank	0,85 - 1,2	4,0 - 5,0 / 58 - 73
Airless/ Airmix	0,007 - 0,009"40"	160 - 200

APPLICATION



2 coat 40 - 60 µm (1,6-2,4)

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 15 minutes	Flash off	5 - 15 minutes
Dust free	20 - 30 minutes	Dust free	-
Dry to handle	8 - 12 minutes	Dry to handle	20 - 45 minutes
Dry to tape	8 - 12 hours	Dry to tape	After coolingdown
Dry to sand	8 - 12 hours	Dry to sand	After coolingdown
Dry to polish	8 - 12 hours	Dry to polish	After coolingdown

INFRARED DRYING



After full flash off and at proper distance	
Half-bake	4 min 60°C
Full-bake	8 min 80°C
See IR Manufacturer information	

SUBSTRATES



A00 - A98 Octocryl 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



20 - 30 minutes

COMPONENTS



H14 2K Hardener Fast
H15 2K Hardener Medium
H34 MS Hardener Fast
H35 MS Hardener Medium
H36 MS Hardener Slow
H53 HS Hardener Very Fast
H54 HS Hardener Fast
H55 HS Hardener Medium
H56 HS Hardener Slow
TA900 Uni Thinner Fast
TA910 Uni Thinner Medium
TA920 Uni Thinner Slow
TA875 Fade-Out Thinner

ADDITIVES



AC001 2K Structure Coat Fine
AC002 2K Structure Coat Coarse
AE001 Elastic 2K
AM002 Matting Additive 2K
A01 Fleet Additive

Add before hardener. In COINS is a option button to choose for a colour formulation with or with out A01 Fleet 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 A00 - A98 OCTOCRYL SYSTEM	
Chemical Base	2K Polyurethane Topcoat
Physical Properties	Viscosity (RTS)
	18 - 20 Dincup 4 / 20°C
	Specific Gravity (kg/l)
	0,987
	Flash Point Closed Cup
	29°C / 84,2°F
	Volume % Solids
	35
	Economy
	7 m²/L/50 µm
	240 ft²/Gal/2 mil
	Gloss
	High gloss
	Colour
	-

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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).



NOTES

Specific information for use in Europe (EU): This product (ready for use) is not VOC compliant. Please refer to VOC declaration (2004/42/EC).