

### 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  
TA855 Spot Repair 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 m <sup>2</sup> /L/50 µm
	Gloss	240 ft <sup>2</sup> /Gal/2 mil
	Colour	High 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](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).**