

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)
Ì	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	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 Slow H53 HS 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					
	Viscosity (RTS)	18 - 20 Dincup 4 / 20°C				
	Specific Gravity (kg/l)	0,987				
	Flash Point Closed Cup	29°C / 84,2°F				
Dhusiaal Dranastiaa	Volume % Solids	35				
Physical Properties	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 $10^{\circ}C - 30^{\circ}C / 50^{\circ}F - 90^{\circ}F$) (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).

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