

GENERAL INFORMATION

F00 - F98 Octocoat HS420 System is a VOC compliant high quality 2-pack finish. With a high UV resistance and gloss retention. Specially developed for passenger cars, commercial vehicles and equipment.

MIXING RATIO



2 : 1 HS420 Top Coat : Octocoat Hardener + 20% Thinner
2 : 1 HS420 Top Coat : 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 coat 50 - 75 µm (2,0 - 3,0 mil)
3 - 12 minutes Flash off

FLASH OFF AND DRY TIMES



Type of repair	Hardener	Thinner	Time at 60°C
High temp. total respray objects (van)	H20	TF20	40 minutes
Normal temp. total respray high temp. panel repair	H20	TF10	30 minutes
Normal temp. panel repair	H20	TF00	20 minutes

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



F00 - F98 Octocoat HS420 System should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. 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



30 - 120 minutes

COMPONENTS



H20 Octocoat Hardener
TF00 Octocoat Thinner Fast
TF10 Octocoat Thinner Medium
TF20 Octocoat Thinner Slow
TA855 Spot Repair Thinner
TA875 Fade-Out Thinner

ADDITIVES



AC001 2K Structure Coat Fine
AC002 2K Structure Coat Coarse
AE001 Elastic 2K
AM004 HS Matting Agent
AT001 HS Taping Additive
AE001 2K Elastic

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

EU REGULATIONS F00 - F98 Octocoat HS420 System		
VOC Code		2004/42/IIIB(d)(420)402
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/d. Topcoat - All types. EU limit values: 420 g/l. (2007). This product contains a maximum of 402 g/l VOC.
Chemical Base	2K Polyurethane Topcoat	
Physical Properties	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,034
	Flash Point Closed Cup	28,5°C / 83,3°F
	Volume % Solids	54
	Economy	11 m²/L/50 µm 440 ft²/Gal/2 mil
	Gloss	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

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



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.