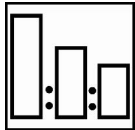


LV 351 Topcoat MM/RM 3519-001

FOR PROFESSIONAL USE ONLY

Description:

High gloss, state of the art 2K High Solids polyurethane topcoat. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles and trailers.



100	Autocoat BT LV 351 Topcoat
40	Autocoat BT LV 351 Hardener Medium or Hi-Flo
30	Autocoat BT LV 351 Reducer



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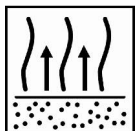


Spray gun set-up:
1.4-1.6 mm

Application pressure:
1.7 – 2.2 bar at the air inlet

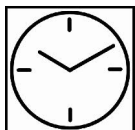


2 x 1 Coat



Between coats
5 -10 minutes at 20°C

Before curing
10 minutes at 20°C



Drying

20°C

60°C

6-8 hours

30 minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information



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High gloss, state of the art 2K High Solids polyurethane topcoat. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles and trailers.

Product and Additives:

Autocoat BT LV 351 Topcoat MM/RM	3519-001
Autocoat BT LV 351 Hardener Medium	3519-104
Autocoat BT LV 351 Hardener Hi-Flo	3519-105
Autocoat BT LV 351 Accelerated Reducer	3519-202
Autocoat BT LV 351 Reducer Fast	3519-203
Autocoat BT LV 351 Reducer Medium	3519-204
Autocoat BT LV 351 Reducer Slow	3519-205
Autocoat BT LV 351 Reducer Extra Slow	3519-206
Autocoat BT LV 351 Air Dry Additive	3519-301
Autocoat BT 800 Matting Paste 475	8099-701

Basic Raw Materials:

LV 351 Topcoat MM/RM:	acrylic/ polyester resins
LV 351 Hardener Medium:	poly-isocyanate resins
LV 351 Hardener Hi-Flo:	poly-isocyanate resins
LV 351 Reducer Fast/ Medium/ Slow/Extra Slow:	solvents / additives
LV 351 Accelerated Reducer:	solvents / additives

Suitable Substrates:

- Existing finishes included finishes with a thermoplastic behavior.
- Polyester laminates and GRP (plywood).
- Autocoat BT LV 350 Filler Beige/Light Gray / Dark Gray 3506-001
- Autocoat BT LV 350 Filler Varicolor 3506-002
- Autocoat BT LV 850 Washprimer CF 8504-001
- Autocoat BT LV 250 Primer EP Beige/ Gray 2505-001 / EP Varicolor 2505-005
- Autocoat BT LV 350 Primer EP 3505-002
- Autocoat BT LV 251 Primer UHS Beige 2515-001
- Autocoat BT LV 254 Primer AS
- Autocoat BT LV 850 Sealer 8506-001
- Autocoat BT WB 450 Primer EP 4505-001
- Autocoat BT WB 550 Primer 5506-001

Surface Preparation:

Degrease with LV 350 Antistatic Silicone Remover 3511-001. Dry sand with P360-P400 grit (3M Gold).

LV 351 Topcoat MM/RM 3519-001

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Mixing Ratio by Volume:**Standard:**

100 parts of Autocoat BT LV 351 Topcoat MM/RM
40 parts of Autocoat BT LV 351 Hardener Medium
30 parts of Autocoat BT LV 351 Reducer Fast / Medium / Slow

Accelerated:

100 parts of Autocoat BT LV 351 Topcoat MM/RM
40 parts of Autocoat BT LV 351 Hardener Medium
30 parts of Autocoat BT LV 351 Accelerated Reducer

Air Dry:

100 parts of Autocoat BT LV 351 Topcoat MM/RM
5 parts of Autocoat BT LV 351 Air Dry Additive
40 parts of Autocoat BT LV 351 Hardener Medium/ Hi Flo
30 parts of Autocoat BT LV 351 Reducers

Design work:

100 parts of Autocoat BT LV 351 Topcoat MM/RM
5 parts of Autocoat BT LV 351 Air Dry Additive
40 parts of Autocoat BT LV 351 Hardener Hi Flo
30 parts of Autocoat BT LV 351 Reducer Medium

Improved flow:

100 parts of Autocoat BT LV 351 Topcoat MM/RM
40 parts of Autocoat BT LV 351 Hardener Hi-Flo
30 parts of Autocoat BT LV 351 Reducer Slow

Higher temperatures:

> 25°C for dark / organic pigmented colors
> 35°C for white / inorganic pigmented colors

100 parts of Autocoat BT LV 351 Topcoat MM/RM
40 parts of Autocoat BT LV 351 Hardener Medium / Hardener Hi-Flo
30 parts of Autocoat BT LV 351 Reducer Extra Slow

Spraying Viscosity:

16-20 s DIN Cup 4 at 20°C.

For optimum application ensure the paint temperature is between 18°C and 25°C (excluding mixture for higher temperatures).

LV 351 Topcoat MM/RM 3519-001

FOR PROFESSIONAL USE ONLY

Potlife:

Standard:	1½ – 2 hours at 20°C ¹
Accelerated:	30 – 45 minutes at 20°C
Air Dry:	20 minutes at 20°C (using LV 351 Accelerated Reducer)
Design:	20 – 45 minutes at 20°C

Note:

1. If temperature exceeds 30°C, potlife of the standard mixture will decrease to approximately 1 hr.

Spray gun fluid tip and working pressure:

Spray Gun:	Fluid Tip:	Working Pressure:
Gravity feed HR:	1.4-1.6 mm	1.7-2.2 bar
Suction feed HR:	1.8-2.0 mm	1.7-2.2 bar
Pressure feed:	0.85-1.0 mm	3-5 bar (atomization pressure) ± 1bar material pressure material flow 350 cc/min

Application Process:

Apply a thin continuous single coat, followed by a full coat. Flash-off time 5-10 minutes at 20°C between coats.

Film Thickness:

Per coat: 20 -30 µm
By using the recommended application (2 coats): 50-60 µm

Cover rate:

Ready for Use mixture at 1 µm dry film thickness: 534 m²/l.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

Use Sikkens Solvent.

LV 351 Topcoat MM/RM 3519-001

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Drying times:

Standard	20°C	40°C	60°C°
Dust dry	1½ hours	15 min	10 min
Dry to handle	6-8 hours	1-1½ hours	30 min
Accelerated			
Dust dry	30-45 min	10 min	5 min
Dry to handle	2-3 hours	45 min	15 min.
Air dry			
Dust dry	30 min	5-10 min	< 5 min
Dry to handle	2 hours	20 min	10 min
Design			
Tape after	2-3 hours		15 min
Higher temperature			
Dust dry		35 min	25 min
Dry to handle		50 min	40-45 min

Recoatable with:

- Autocoat BT LV 351 Topcoat MM/RM 3519-001
- Autocoat BT WB 551 Basecoat RM 5518-001
- Autocoat BT LV 853 Clear 8531-001

Notes:

1. A second LV 351 Topcoat color can be applied on the first LV 351 Topcoat color after the following drying times. When tapes are being applied it is recommended to use the Design mixture (see design application):

	20°C	60°C
- Minimum time to recoat	1½-2 hours	20-25 minutes
- Maximum time to recoat	48 hours	6 hours

2. LV 853 Clear can be applied on LV 351 Topcoat after the following drying times:

	20°C	60°C
- Minimum time to recoat	1 hour	
- Maximum time to recoat	48 hours	16 hours

Note: When these drying times are exceeded, abrade LV 351 Topcoat with Scotch Brite Type S Ultra Fine (Grey) or apply a single coat of LV 850 Sealer 8506-001 in case of the second LV 351 Topcoat color.

LV 351 Topcoat MM/RM 3519-001

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Additional Product Information:

In case of striping or lettering with Autobase Plus / Autocoat BT WB 551 Basecoat RM (see TIS 9.1.109), it is optional to apply a layer of LV 850 Sealer to ensure good tape removal.

VOC:

2004/42/II B(d)(420)420

The EU VOC limit for this product (product category: IIB. D) in ready to use form is max 420 g/ltr. The VOC content of this product in ready to use form is max. 420 g/ltr.

Packaging:

LV 351 Topcoat MM: 3.75L in 3.75-liter can (some toners available in 25ltr and/or 200 ltr)

LV 351 Hardeners: 5 ltr in 5 ltr can

LV 351 Reducers: 5 ltr in 5 ltr plastic can, 25 ltr (Reducer Medium)

Shelflife:

LV 351 Topcoat MM/RM 3519-001: 2 years

LV 351 Hardener Medium 3519-104: 1 year

LV 351 Hardener Hi-Flo 3519-105: 1 year

LV 351 Reducer Fast 3519-203: 1 year

LV 351 Reducer Medium 3519-204: 1 year

LV 351 Reducer Slow 3519-205: 1 year

LV 351 Reducer Extra Slow 3519-206: 1 year

LV 351 Accelerated Reducer 3519-202: 1 year

LV 351 Air Dry Additive 3519-301: 6 months

800 Matting Paste 475 8099-701: 4 years

Product storage:

Product shelf-life is determined when products are stored unopened at 20°C

Avoid extreme temperature fluctuation.

Minimum storage temperature: 5°C

Maximum storage temperature: 35°C

LV 351 Topcoat MM/RM 3519-001

FOR PROFESSIONAL USE ONLY

HEALTH & SAFETY DATA regarding Autocoat BT LV 351 Topcoat MM/RM 3519-001 and additives:

For professional use only. (See **Material Safety Data Sheet**).
See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

Akzo Nobel Coatings LTD

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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