







Technical data sheet

NOVAKRYL 5000 2.1

Acrylic clearcoat

| PROPERTIES | | | | | |
|--|---|--|--------------------------|-------------------------|--------------------------|
| NOVAKRYL 5000 is a two component high solid clearcoat designed for use on multi-panel and overall refinishing. Clearcoat provides easy applications, non-sag properties, high gloss and long term durability. It is designed to meet the most stringent VOC regulations in both the U.S. and Canada. | | | | | |
| RELATED PRODUCTS | | | | | |
| HARDENER 5000 | | Hardener for NOVAKRYL 5000 (64°- 86 F / 18°- 30°C) | | | |
| SUBSTRATES | | | | | |
| Compatible with the majority of solvent and waterborne basecoats available on the market. | | | | | |
| MIXING RATIO | | | | | |
|  | NOVAKRYL 5000 HARDENER 5000 | Volume ratio | Weight ratio | | |
| | | 2 | 100 | | |
| | | 1 | 55 | | |
| APPLICATION CONDITIONS | | | | | |
| It is recommended to apply the clearcoat at a temperature above 68°F / 15°C and a humidity of no more than 80 %. Under such conditions, the cured coating can be used after no less than 12 hours. | | | | | |
| APPLICATION | | | | | |
|  | CAUTION: Instructions of the equipment manufacturer must be followed. | Conventional gravity fed spray gun | Tip size 1.3 – 1.4 mm | Pressure 45 – 55 psi | Distance 6 – 8 inches |
| | | Low-pressure gravity fed spray gun | 1.3 mm | 28 psi | 3 – 6 inches |
|  | Number of coats | 2 – 3 | | | |
| | Dry film build per coat | 1.0 – 1.2 mils | | | |
| | Final recommended film build | 2.0 – 2.5 mils | | | |
|  | Pot life at 68°F / 20° C | 1 hour | | | |

| | | |
|---|--|--|
|  | Flash off between coats at 68°F / 20°C | 5 – 10 min |
| CURING TIMES | | |
| | 68°F / 20°C | 140°F / 60°C |
| Dust-free | 25 min | 5 min |
| Tack-free | 3 hours | 10 min |
| Operating hardness | 12 hours | 30 min |
| Ending hardness | 7 days | 30 min + 3 days at 68°F / 20°C |
| CAUTION: The curing times apply to the temperatures of the individual elements. | | |
| IR DRYING | | |
|  | Distance Time depending on the type and power of the lamp | Follow the recommendations of the equipment manufacturer 10 – 25 min |
| CAUTION: Start IR heating no sooner than 10 mins after applying the last layer. | | |
| EQUIPMENT CLEANING | | |
| Acrylic thinner or NC solvent. | | |
| REGULATORY DATA | | |
| Volume Ratio | 2:1 | |
| Applicable Use Category | Clear Coatings | |
| VOC Actual (g/l) | 135 | |
| VOC Actual (lbs/gal) | 1.13 | |
| VOC Regulatory (g/l) Less water less exempt | 249 | |
| VOC Regulatory (lbs/gal) Less water less exempt | 2.07 | |
| Density (g/l) | 1050 | |
| Density (lbs/gal) | 9.0 | |
| Volatiles wt. % | 55.5 | |
| Water wt. % | 0.0 | |
| Exempt wt. % | 44.5 | |
| Water vol. % | 0,0 | |
| Exempt vol. % | 42.1 | |
| Solids vol. % | 41.5 | |

STORAGE CONDITIONS

Store in a cool dry room, away from sources of fire and heat.

Avoid direct exposure to sunlight.

SHELF LIFE

| | |
|---------------|--------------------------|
| NOVAKRYL 5000 | 24 months at 68°F / 20°C |
|---------------|--------------------------|

| | |
|---------------|--------------------------|
| HARDENER 5000 | 12 months at 68°F / 20°C |
|---------------|--------------------------|

SAFETY

See Safety Data Sheet.

OTHER INFORMATION

The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.