

TECHNICAL DATA SHEET

supersedes previous issue dated 09/04/03

TL 336
CLEAR HIGH-GLOSS ACRYLIC POLYURETHANE TOPCOAT

Area of use:	Flat parts, turned parts.		
Method of use:	Spray gun, curtain coater.		
Mixing procedure:	by weight (kg)		
Part A	TL 336	100	
Part B (hardener)	TH 790	50	
Thinner	DT 424	10-40	

Technical characteristics:

Solids content (%):	51 ± 1		
Specific gravity (kg/l):	0.956 ± 0.030		
Viscosity (DIN 4 at 20°C):	Part A:	75" ± 4"	
	A + B:	20" ± 3"	

Substrate preparation

Preferably with polyester basecoat.

General characteristics

Pot-life at 20°C:	5 hours		
Recommended application weight (g/m ²):	Min. 80 - Max. 180		
Drying time (100 g/m ² at 20°C):	Dust free	15 minutes	
	Touch dry	8 hours	
	Stackable	48 hours	
Forced drying:	Not recommended.		
Shelf-life:	If the product is properly stored, shelf-life is unlimited. After long periods of storage, always check homogeneity and stir well before use to eliminate any possible sediment.		

TL 336 is a colourless, light fast, high-gloss acrylic topcoat with excellent flow and transparency. It is slower drying than polyurethane systems, but ensures excellent yellowing resistance. It is much less sensitive to application conditions than polyurethane gloss topcoats, so it is less susceptible to problems of pinholes and pinheads. It must be applied in a sufficient quantity to wet the substrate well.

Buffing is possible 5 days after application.

Special instructions

In case light coats are applied, use thinner DT 441. Like all acrylic products blended with TH 790 hardener, it must be applied at a temperature of no lower than 18°C. At lower temperatures drying may not be uniform and the film is liable to lose elasticity and become brittle.