







Technical data sheet
NOVAKRYL 5000 2.1
Acrylic clearcoat

PROPERTIES					
NOVAKRYL 5000 2.1 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 FAST		Fast hardener for clearcoat (55° - 68°F / 13° - 20°C)			
HARDENER 5000 STANDARD		Standard hardener for clearcoat (65° - 77°F / 18° - 25°C)			
HARDENER 5000 SLOW		Slow hardener for clearcoat (75° - 95°F / 24° - 35°C)			
SUBSTRATES					
Compatible with the majority of solvent and waterborne basecoats available on the market.					
MIXING RATIO					
	NOVAKRYL 5000 2.1 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		
	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	10 - 15 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 Coating	
VOC Actual (g/l)	160	
VOC Actual (lbs/gal)	1.35	
VOC Regulatory (g/l) Less water less exempt	249	
VOC Regulatory (lbs/gal) Less water less exempt	2.07	
Density (g/l)	1140	
Density (lbs/gal)	9.5	
Volatiles wt. %	57.2	
Water wt. %	0.0	
Exempt wt. %	44.5	
Water vol. %	0,0	
Exempt vol. %	37.0	
Solids vol. %	43.5	

STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
NOVAKRYL 5000 2.1	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.	