



# Technical Data Sheet

## Automotive Art Motocryl 50-Line



### General Information:

Automotive Art Motocryl 50 Line is a single stage 2K paint system that offers superior durability and excellent coverage. The two-component system features a brilliant high gloss finish directly from the gun, and no clear coat is required. Furthermore, the system can be converted to meet Low VOC rules with the addition of one toner.

### Substrates:

Can be applied over:

- Properly prepared and degreased OEM substrates
- AART Primers, Sealers, clearcoats

### Mixing Ratio:



#### National Rule

#### 2:1 +10%

100% by Vol. Automotive Art Motocryl 50 Line

50% by Vol. Automotive Art NR Hardeners

10% by Vol. Automotive Art NR Reducers

#### Part#

50 Line Toners

30-52, 30-62, 30-72, 30-82

35-10, 35-20, 35-30

#### Low VOC

#### 2:1 +10%

100% by Vol. Automotive Art Motocryl 50 Line

50% by Vol. Automotive Art LV Hardeners

10% by Vol. Automotive Art LV Reducers

#### Part#

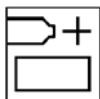
50 Line Toners

30-66, 30-76, 30-86

35-50, 35-55, 35-60

**Pot Life:** 2 hours at 20°C. (68°F)

### Additives:



20 - 45 Flex additive (Add 25% by vol. before adding hardener)

20 - 10 Accelerator (Add up to 5% to RTS mixture)

20 - 55 Matting Agent (Please refer to AART 20-55 TDS for gloss degree chart)

50-LV Low VOC Converter (40% by vol before adding reducer)

### Air Pressure and Spraygun Setup:

	<u>Air Pressure</u>	<u>Nozzle Size</u>
<b>HVLP:</b>	21-29 psi (1.4-2.0 bar)	1.3-1.4 mm
<b>Conventional:</b>	2.5 bar (35 psi)	1.3-1.5 mm

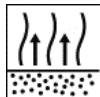
Note: For best overall result, refer to spray gun manufacturer's recommendations.

### Application:



<b>Apply:</b>	2 full coats or until full coverage is achieved
<b>Coat Thickness:</b>	3 -3.5 mil (80 - 90 µm)

### Drying Times:



**Between Coats:** 8 - 10 minutes at 20°C (68°F)



<u>Tack-Free</u>	<u>Assembly</u>	<u>Polish</u>	<u>Recoat</u>
1 hour	4 hours	8 hours	12 hours



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### Selection Guide Charts:

#### Hardeners

Description	Nat Rule Part #	Low VOC Part #	55°F-70°F (12°C-21°C)	70°F-85°F (21°C-30°C)	85°F-95°F (30°C-35°C)	+95°F (+35°C)
Extreme-Temp/Extra Slow	30-52	N/A				
High Temp/Slow	30-62	30-66				
Medium Temp/Normal	30-72	30-76				
Low Temp/ Fast	30-82	30-86				

#### Reducers

Description	Nat Rule Part #	Low VOC Part #	55°F-70°F (12°C-21°C)	70°F-85°F (21°C-30°C)	+ 85°F (+30°C)
High Temp/Slow	35-10	35-50			
Medium Temp/Normal	35-20	35-55			
Low Temp/ Fast	35-30	35-60			

### Surface Preparation:



- Prepare all surfaces following recommended procedures and follow with Automotive Art Universal Cleaner 20-95 or 20-70 Anti-static cleaner
- Apply over AART primers, AART primer sealer or cured clearcoats.
- Dry sand with 600/800 grit or wet sand with 600 – 800 grit before applying basecoat

### Packing & Shelf Life:

**Sizes:** 3.5L, 1L

**Shelf life:** Under normal storage conditions minimum four years (unopened tins).

### Notes:

- Can be applied by brush using 30-62 slow hardener.

### Technical Data:

RTS Combinations:	50 Line Toners
Volume Ratio:	2:1 + 10%
Specific Gravity:	0.978 to 1.53 kg/l
Flash Point:	>31°C, (>89°F)
Solids Vol %:	Varies. Approx. 55%
Solids Wt. %:	Varies
Coverage (Varies based on color):	7-9 m²/l @ 50 µm approx.
Viscosity (RFU):	21-24s DIN Cup 4
Gloss:	High Gloss
Color:	Various
V.O.C. Actual:	481-632 g/l, (4.0-5.3 lbs/gal)
V.O.C. Regulatory RTS (less water, less exempts):	481-632 g/l, (4.0-5.3 lbs/gal)
V.O.C. Ready to Spray:	517-638 g/l, (4.2-5.3 lbs/gal)
Applicable Use Category:	Single Stage Coating

See Material Safety Data Sheet and Labels for additional Safety Information and handing instructions.