



Technical data sheet
NOVAKRYL 590

Acrylic clearcoat

Two-component clearcoat with increased scratch resistance (SR)

PROPERTIES						
NOVAKRYL 590 – an acrylic clearcoat that has a high solids content and is highly scratch resistant (SR). High hardness, UV resistance and weather resistance guarantee high durability, while the gloss and depth ensure an excellent appearance of the coated surface. The recommended coating thickness is obtained by applying one and a half layer. The good flowability and quick drying time assure easy repair and short time of processing in the painting cabin. It is available in versions with the slow, standard or fast hardener; the selection of specific hardener depends on the application conditions. Due to its properties, Novakryl 590 is a clearcoat that enables easy reproduction of the factory paint coating structure. It has good dry spray absorption, which makes it perfect for coating of large surfaces.						
RELATED PRODUCTS						
H 5120	Hardener Standard, Fast and Slow.					
THIN 850	Acrylic thinner Standard, Fast and Slow					
PLUS 770	Elasticity increasing agent			LT-04-01		
PLUS 750	Acrylic accelerating agent			LT-04-02		
PLUS 760	Antisilicone additive			LT-04-04		
THIN 890	Fade out Thinner.			LT-06-05		
SUBSTRATES						
Compatible with the majority of solvent and waterborne basecoats available on the market.						
MIXING RATIO						
	NOVAKRYL 590 H 5120 THIN 850	W/o thinner		With thinner		
		Volume ratio	Weight ratio	Volume ratio	Weight ratio	
		2	100	2	100	
		1	50	1	50	
		0	0	10%	9	
Apply the thinner in the amount calculated for the clearcoat.						
VISCOSITY						
	DIN 4/20°C	W/o thinner		With thinner		
		17 – 19 s		15 – 17 s		
CONTENT OF VOLATILE ORGANIC COMPOUNDS						





VOC II/B/e limit*	840 g/l
Actual VOC content	545 g/l

* For ready to use mixture acc. to EU Directive 2004/42/CE

APPLICATION CONDITIONS

It is recommended to apply the clearcoat at a temperature above 15°C and a humidity of no more than 80 %.
Under such conditions, the cured coating can be used after no less than 14 hours.


APPLICATION

	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.3 – 1.4 mm	3 – 4 bar	15 – 20 cm
<p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>	Low-pressure gravity fed spray gun	1.2 – 1.3 mm	2 bar	10 – 15 cm
	Number of layers	W/o thinner		With thinner
		1.5		2 – 3
	Single dry layer thickness	30 – 35 µm		25 – 30 µm
	The yield of the ready to use mixture for the given range of dry layer thickness	8.0 m ² /l at 50 µm		
	Mixture life at 20°C	H 5120 Slow, Standard		H 5120 Fast
		2 h		30 min
	Flash off between layers at 20°C	5 – 10 min		

CURING TIMES

	H 5120 Slow		H 5120 Standard		H 5120 Fast	
	20°C	60°C	20°C	60°C	20°C	60°C
Dust-free	30 min	6 min	25 min	5 min	20 min	5 min
Tack-free	4 h	15 min	3 h	10 min	1.2 h	10 min
Operating hardness	14 h	45 min	14 h	45 min	12 h	35 min
Ending hardness	7 days	45 min + 3 days/20°C	7 days	45 min + 3 days/20°C	5 days	35 min + 3 days/20°C

CAUTION: The curing times apply to the temperatures of the individual elements.
Drying the coat with a fast hardener at an increased temperature can deteriorate the gloss and makes it necessary to polish the coat.
The fast hardener should not be used with the PLUS 750 acrylic accelerating agent.

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.			
THIN 850 ACRYLIC THINNER			
Surface	15 – 20°C	20 – 25°C	25 – 35°C
Small 1-2 elements, spot repair	H 5120 Fast THIN 850 Fast	H 5120 Standard THIN 850 Fast	H 5120 Standard THIN 850 Standard
Medium 3-5 elements	H 5120 Fast THIN 850 Fast	H 5120 Standard THIN 850 Standard	H 5120 Standard THIN 850 Slow
Large more than 5 elements	H 5120 Fast THIN 850 Standard	H 5120 Standard THIN 850 Slow	H 5120 Slow THIN 850 Slow
EQUIPMENT CLEANING			
THIN 850 acrylic thinner or NC solvent.			
STORAGE CONDITIONS			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			
SHELF LIFE			
NOVAKRYL 590	24 months/20°C		
H 5120 Standard, Fast	18 months/20°C		
H 5120 Fast	12 months/20°C		
THIN 850	24 months/20°C		
SAFETY			
See Safety Data Sheet.			
OTHER INFORMATION			
Registration number: 000024104. 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.			

ADDITIONAL INFORMATION

WEIGHT QUANTITY OF COMPONENTS:

Version without thinner; 2+1

CAUTION! In order to obtain a paint coating with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	NOVAKRYL 590	H 5120
0.10 l	67 g	34 g
0.15 l	100 g	51 g
0.20 l	134 g	68 g
0.25 l	167 g	84 g
0.30 l	201 g	101 g
0.40 l	268 g	135 g
0.50 l	335 g	169 g
0.75 l	502 g	253 g
1.00 l	669 g	337 g

WEIGHT QUANTITY OF COMPONENTS:

Version with thinner; 2+1+10%

CAUTION! In order to obtain a paint coating with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	NOVAKRYL 590	H 5120	THIN 850
0.10 l	63 g	32 g	6 g
0.15 l	94 g	47 g	8 g
0.20 l	126 g	63 g	11 g
0.25 l	157 g	79 g	14 g
0.30 l	188 g	95 g	17 g
0.40 l	251 g	127 g	22 g
0.50 l	314 g	158 g	28 g
0.75 l	471 g	237 g	42 g
1.00 l	628 g	316 g	56 g