



X2 UV Marine Clear

Clear Low VOC NPG[®]/Isophthalic Gel Coat

Technical Data Sheet

X2 CLEAR is a general purpose clear gel coat. This product meets MACT Standard, EPA 40 CFR Part 63 requirements of the National Emission Standards for Hazardous Air Pollutants: Reinforced Plastic Composite Production, maximum of 44% HAP for clear gel coat and National Emission Standards for Hazardous Air Pollutants for Boat Manufacturing, maximum of 48% for clear gel coat.

FEATURES	BENEFITS
• HAP content is a maximum of 39.5%	• Lower emissions in the shop
• High performance polymer	• Improve gloss retention, chemical and crack resistance
• Unique additive package	• Excellent color and film clarity
• Excellent spray and leveling characteristics	• Minimizes surface defects

LIQUID PROPERTIES	RESULTS	TEST METHOD
Viscosity, Brookfield Model LV #4 Spindle @ 6 rpm, 77°F (25°C), cps	11000 – 15500	CRSTP-301
Thixotropic index	5.0 – 6.5	CRSTP-301
100 grams gel coat @ 77°F (25°C), catalyzed with 2.0% L-50A by volume Gel Time, min:sec	18:00 – 22:00	CRSTP-340
HAPs content, lbs/gal	≤ 3.6	CRSTP-329
HAPs (Styrene), %	≤ 39.5	CRSTP-329
Non-Volatile Matter, %	57.5 – 59.0	CRSTP-329
Weight per gallon @ 77°F (25°C), lbs/gal	8.6 – 9.0	CRSTP-308
Specific gravity @ 77°F (25°C)	1.03 – 1.07	CRSTP-308
* Gel time and reactivity will vary due to the type and concentration of a free radical initiator (peroxide), shop temperature and humidity		

TYPICAL PERFORMANCE PROPERTIES	RESULTS	TEST METHOD
Film Cure time @ 77°F (25°C), catalyzed with 2.0% L-50A by volume, min:sec	≤ 45:00	CRSTP-346
Sag resistance @ 77°F (25°C), mil of a wet film thickness	None @ 20	CRSTP-315
Material coverage (assuming no loss) @ 20 mils of a wet film thickness, ft ² /gal	80	Calculated

Application: X2 Clear is formulated for spraying as supplied. It is strongly recommended that the material be mixed before use. Optimum application temperature is 65°F - 90°F (18°C - 32°C). Apply in several thin, overlapping passes rather than a single heavier coat. The suggested wet film thickness is 15 - 18 mils (0.38 – 0.46 mm). The thicker films are subject to pre-release and cracking.

Storage and Handling: X2 Clear should be stored in closed, opaque containers at temperatures not exceeding 77°F (25°C). Do not keep gel coats near catalyst storage areas. To avoid decomposition keep away from direct sunlight and excess heat. Refer to the Material Safety Data Sheet for further details on safety and storage.

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All specifications and properties specified above are approximate. Specifications and properties of material delivered may vary slightly from those given above. Lilly Ram reserves the right to update sales specifications information without prior notice. Lilly Ram makes no representations of fact regarding the material except those specified above. No person has any authority to bind Lilly Ram to any representation except those specified above. Final determination of the suitability of the material for the use contemplated is the sole responsibility of the Buyer.

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