

CLEAR COAT VOC/P

CLB-03.016

CHARACTERISTICS:

Ultra high solid clear coat with very good flow and high thixotropic properties. Characterized by UV, chemical, weathering and scratch resistance. Suitable for applications in spray booths. Designed to use on solvent- and waterborne base coats with a spray gun.

APPLICATION:

Measure out the A+B mixture by volume: 2 parts of clear coat (A) and 1 part of hardener (B), then mix thoroughly. Apply with a spray gun with a nozzle diameter of 1.2 mm in 2 normal coats with 7-10-minute break for the solvents to evaporate before applying another coat. Additional thinner is not required to use for this product. However, the system may be adjusted with up to 10% vol. on component A, of out hinder without having negative influences on the desired results.

TECHNICAL DATA:

VOC 2004/42/IIIB(d)(420) max. 420 g/l

Clear coat CLB-03.016:

Shelf life: 18 months Density (20°C): 0.98 – 0.99 g/cm³ Colour: colourless/slightly yellow

Hardener standard CDL-04.028/ fast CDL-04.042/ very fast CDL-04.039/ slow CDL-04.037/ very slow CDL-04.054:

Shelf life: 12 months Density (20°C): 1.00 – 1.05 g/cm³ Colour: colourless/slightly yellow




NOTE: Possible light coloration of the hardener doesn't affect the shade of the finishing coat.

Thinner standard CDL-07.002/ fast CDL-07.017/ slow CDL-07.015:

Shelf life: 24 months Density (20°C): 0.80 – 0.90 g/cm³ Colour: colourless

Top Gloss Additive (gloss stabilizer) CDL-07.024:




Shelf life: 24 months Density (20°C): 0.85 – 0.87 g/cm³ Colour: colourless

MIXING RATIO			
		by volume	by weight
	Clear coat (A)	2	100
	Hardener (B)	1	51 (standard) 52 (fast, very fast) 53 (slow, very slow)
	Thinner (C) or Top Gloss Additive (C)	0 - 10% vol. on component A 5 - 8% vol. on component A	0 - 9% wt. on component A 4,4 - 7 % wt. on component A
SPRAY VISCOSITY			
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C		18 - 22 s 19 - 23 s 42 - 50 s
APPLICATION			
	Spray gun gravity feed	nozzle	pressure
		1.2 mm	operating pressure as recommended by the spray gun manufacturer

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	Application process	coats number	flash-off time		dry film thickness
			between coats	before baking	
		2	7 - 10 min	10 min	50 - 60 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		11 - 12 m ² /l			
Pot life at 20°C		40 min with hardener standard CDL-04.028 40 min with hardener fast CDL-04.042 30 min with hardener very fast CDL-04.039 50 min with hardener slow CDL-04.037 60 min with hardener very slow CDL-04.054			
DRYING TIMES					
	Object temperature	60°C	20°C	Full hardness at 20°C	
		Dry to polish			
	Hardener type	standard CDL-04.028	30 min	9 - 10 h	7 days
		fast CDL-04.042	20 min	6 - 8 h	
		very fast CDL-04.039	15 min	4 - 6 h	
		slow CDL-04.037	40 min	11 - 12 h	
very slow CDL-04.054		45 min	15 - 16 h		
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down					
	IR drying	Short and medium wave: 12 - 15 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.			

REMARKS:

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product in a temperature below 18°C. Low application temperature changes the characteristics of the coating finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

STORAGE AND TRANSPORTATION CONDITIONS:

Protect from freeze, heat, sunlight and moisture. Store tightly closed in a dry, cool place.
Recommended storage temperature: +10 to +30°C.