

# CLEAR COAT VOC OPAQUE

## CLB-03.031

### CHARACTERISTICS:

Opaque 2-pack acrylic medium solid clear coat, designed for car refinish and industrial coating. Characterized by high chemical, mechanical and weathering resistance as well as high hardness. Easy to use. Provides high-quality matt coating with very low gloss of 5-10 GU units and resistance to scratches and UV. The gloss level depends on coating thickness and the lower the thickness, the lower the gloss level. This clear coat is suitable for application in spray booths or areas adapted for painting. Designed for use on solvent- and waterborne base coats.

### 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 on dry and dust free surface with a spray gun with a nozzle diameter of 1.3 mm in 2 normal coats with a 5-minute break for the solvents to evaporate before applying another coat.

### TECHNICAL DATA:

VOC 2004/42/IIB(e)(840) max. 840 g/l

Clear coat CLB-03.031:

Shelf life: 9 months

Density (20°C): 0.98 – 1.00 g/cm<sup>3</sup>

Colour: milk-white, opaque

Hardener standard CDL-04.043/ fast CDL-04.044:


Shelf life: 9 months

Density (20°C): 0.96 – 0.97 g/cm<sup>3</sup>


Colour: colourless/slightly yellow

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



### MIXING RATIO

	Clear coat (A) Hardener (B)	by volume	by weight
		2	100
		1	48.5

### SPRAY VISCOSITY

	DIN cup 4mm at 20°C	18 - 22 s
	Ford cup 4mm at 20°C	18 - 22 s
	ISO cup 4mm at 20°C	37 - 46 s

### APPLICATION



	Spray gun gravity feed	nozzle	pressure		
		1.3 mm	operating pressure as recommended by the spray gun manufacturer		
	Application process	coats number	flash-off time		dry film thickness
		2	between coats	before baking	
		5 min	10 min	50 - 60 µm	
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		7.5 m <sup>2</sup> /l			
Pot life at 20°C		2.5 h with hardener standard CDL-04.043 2 h with hardener fast CDL-04.044			

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Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186

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## CLB-03.031

DRYING TIMES				
	Object temperature	60°C	20°C	Full hardness at 20°C
	Hardener type			
		standard CDL-04.043	30 min	3 h
	fast CDL-04.044	15 min	2.5 h	
	IR drying	Short and medium wave: 10 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.

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