

# 1:1 CLEAR COAT VOC/S

## CLB-03.035

### CHARACTERISTICS:

Ultra high solid clear coat suitable for quick repairs. Distinguished by very good flow properties, high gloss, quick drying time at 20°C and excellent UV resistance (non-yellowing). Characterized by high hardness, scratch, chemical and weathering resistance. Its main advantage is very fast drying at ambient temperature (up to 2h at 20°C) and high initial hardness. It is not necessary to apply a forced drying for this clear coat because higher temperature has no significant impact on its curing process. Especially recommended for use on solventborne base coats.

### APPLICATION RECOMMENDATIONS:

1. It is absolutely critical to adhere to the recommended thickness of the dry finish coating. Due to very good application properties, it is possible to apply the product too thick (even 100 µm for dry coating) – there is a risk of solvents entrapment, thus wrinkling the coating soon after putting the car to use is possible;
2. Application must be conducted at recommended humidity of 40-80%. Too high humidity may cause rapid drying and formation of rigid film on coating's surface, preventing the solvent release. The entrapped solvents may influence negatively on base coat (e.g. bubbles, loss of adhesion).
3. After obtaining dust-free drying step, it is crucial to remove masking tapes - if you remove tapes too late, the applied clear coat may detach from base coat and old coating.

**NOTICE:** when applying on waterborne base coat, it is **absolutely crucial** to adhere to the following conditions:

4. Add to the waterborne base coat an appropriate amount of the hardener (activator), one that is used for three-coat systems, in accordance with the recommendation of the manufacturer of a specific waterborne system.
5. The waterborne base coat must be 100% dry (even trace levels of water in the coating may cause defects of the dry finish coating, such as loss of adhesion or bubbles appearing under the base coat - defects may appear even 2 months after completing the repair).

### APPLICATION:

Measure out the A+B mixture by volume in a ratio of 1:1 and then mix thoroughly. Apply with a spray gun with a nozzle diameter of 1.2 mm in 2 normal coats with a 3-7-minute (in dependence on air humidity) break for the solvents to evaporate.

### Attention:

**The clear coat has to be applied at a humidity of 40-80%. Application at a humidity below 40% extends the drying time. Application at a humidity above 80% may cause serious coating defects.** Allow the product to reach the recommended application temperature of 18-22°C naturally (avoid rapid heating/cooling). It is not recommended to apply the product at temperature below 18°C.

### TECHNICAL DATA:

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

#### Clear coat CLB-03.035:

Shelf life: 12 months                      Density (20°C): 1.01 – 1.03 g/cm<sup>3</sup>                      Colour: colourless/slightly yellow

#### Hardener CDL-04.046:

Shelf life: 12 months                      Density (20°C): 1.02 – 1.04 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.

#### Thinner standard CDL-07.002:

Shelf life: 24 months                      Density (20°C): 0.88 – 0.90 g/cm<sup>3</sup>                      Colour: colourless

#### Top Gloss Additive (gloss stabilizer) CDL-07.024:

Shelf life: 24 months                      Density (20°C): 0.85 – 0.87 g/cm<sup>3</sup>                      Colour: colourless

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MIXING RATIO						
	Clear coat (A) Hardener (B) Thinner (C) or Top Gloss Additive (C)	by volume		by weight		
		1 1 0 - 8% vol. on component A 5 - 8% vol. on component A		100 101 0 - 7.2% wt. on component A 4.4 - 7% wt. on component A		
SPRAY VISCOSITY						
	DIN cup 4mm at 20°C Ford cup 4 mm at 20°C ISO cup 4 mm at 20°C	14 - 16 s 15 - 17 s 27 - 31 s				
APPLICATION						
	Spray gun gravity feed	nozzle		pressure		
		1.2 mm		operating pressure as recommended by the spray gun manufacturer		
	Application process	coats number	flash-off time	dry film thickness		
		2	3 - 7 min (in dependence on air humidity)	50 - 60 µm		
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 80%				
Theoretical coverage		12 - 13 m <sup>2</sup> /l				
Pot life at 20°C		up to 30 min				
DRYING TIMES						
	Object temperature	20°C			Full hardness at 20°C	60°C
		Dust-free drying	Dry to touch	Dry to polish		
	Hardener type	CDL-04.046	20 - 25 min	45 - 55 min	90 - 120 min	5 h

### 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.