

CLEAR COAT VOC/J

CLB-03.051

CHARACTERISTICS:

VOC/J is an ultra high solid 2-pack acrylic clear coat with fast curing characteristic. Intuitive Painting Technology provides safe and easy application. No additional thinner required. OEM-structure or mirror-like effect is possible to achieve. VOC/J clear coat keeps the proper balance between hardness and elasticity. This product is made of the highest raw materials. Resistant to chemicals, UV light and weather conditions. Designed for both 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 with a spray gun with a nozzle diameter of 1.3 mm in 1.5 coats (½ thin closed coat and 1 full wet coat) with a 3-5-minute break for the solvents to evaporate before applying another coat.

TECHNICAL DATA:

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





Clear coat CLB-03.051:

Shelf life: 12 months Density (20°C): 0.99 – 1.01 g/cm³ Colour: colourless/slightly yellow

Hardener CDL-04.067:

Shelf life: 12 months Density (20°C): 0.99 – 1.01 g/cm³ 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	1	100 50	
SPRAY VISCOSITY					
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C	17 - 21 s 20 - 23 s 43 - 49 s			
APPLICATION					
	Spray gun gravity feed	nozzle		pressure	
		1.3 mm		operating pressure as recommended by the spray gun manufacturer	
	Application process	coats number 1.5 (½ thin closed coat + 1 full wet coat)	flash-off time		dry film thickness 50 - 60 µm
			between coats	before baking	
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		9.5 - 11.5 m ² /l			
Pot life at 20°C		30 - 40 min			

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Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186

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DRYING TIMES			
	Object temperature	20°C	60°C
	Dry to touch	2 - 3 h	15 min
	Dry to polish	5.5 - 7.5 h	20 min
	Full hardness	7 days	20 min + 5 days/20°C
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down			
	IR drying	8 - 15 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.	

NOTES:

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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