

CLEAR COAT HS/F ANTI-SCRATCH

CLB-03.052

CHARACTERISTICS:

HS/F Anti-scratch is a fast drying 2-pack acrylic clear coat with high solids content. Due to fluorocarbon modified composition, this product has enhanced scratch-resistant and water-repellent properties. Very good substrate wetting results in perfect levelling without additional thinner. Long pot life enables safe and easy painting. HS/F Anti-scratch is resistant against chemicals, UV light and weather conditions. It may be applied over 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 2 normal coats with a 5-7-minute break for the solvents to evaporate before applying another coat.

TECHNICAL DATA:

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

Clear coat CLB-03.052:


Shelf life: 12 months Density (20°C): 0.97 – 0.98 g/cm³ Colour: colourless/slightly yellow

Hardener CDL-04.068:


Shelf life: 12 months Density (20°C): 0.98 – 1.00 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	100
		1	51

SPRAY VISCOSITY

		
	DIN cup 4mm at 20°C	15 - 17 s
	Ford cup 4mm at 20°C	16 - 19 s
	ISO cup 4mm at 20°C	30 - 35 s

APPLICATION



	Spray gun gravity feed	nozzle	pressure		
		1.3 mm	operating pressure as recommended by the gun manufacturer		
	Application process	coats number	flash-off time		dry film thickness
			between coats	before baking	
		2	5 - 7 min	10 min	50 - 55 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		8 - 9 m ² /l			
Pot life at 20°C		60 min			

Chemical Alliance Polska sp. z o.o.

ul. Prosta 23, Łozienica, 72-100 Goleniów, PL, tel. +48 91 41 65 440, fax +48 91 41 65 487
 NIP 781 16 87 419 REGON 6341159570, Kapitał Zakładowy 2.000.000,00 PLN
 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 - 6 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.	

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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