

# CLEAR COAT HS/P ANTI-SCRATCH

## CLB-03.057

### CHARACTERISTICS:

HS/P Anti-scratch is a high solid, 2-pack acrylic clear coat with scratch-resistant properties. Characterized by long pot life and easy application without additional thinner. The resultant coating is smooth, distinguished by high gloss and very good chemical, mechanical and weathering resistance as well as UV light resistance. HS/P Anti-scratch clear coat is designed for 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-03.057:

Shelf life: 12 months      Density (20°C): 0.98 – 0.99 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

#### Hardener CDL-04.070/ fast CDL-04.073/ slow CDL-04.084:

Shelf life: 12 months      Density (20°C): 0.98 – 1.01 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

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



MIXING RATIO					
	Clear coat (A) Hardener (B)	by volume	by weight		
		2 1	100 50.5		
SPRAY VISCOSITY					
	DIN cup 4mm at 20°C	14 - 16 s			
	Ford cup 4mm at 20°C	14 - 16 s			
	ISO cup 4mm at 20°C	24 - 27 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
			between coats	before baking	
		2	5 - 7 min	10 min	50 - 55 µm
<b>Recommended process conditions</b>		temperature 18 - 22°C, relative air humidity 40 - 60%			
<b>Theoretical coverage</b>		8.5 - 9.5 m <sup>2</sup> /l			
<b>Pot life at 20°C</b>		90 - 110 min with hardener CDL-04.070, slow CDL-04.084 40 min with hardener fast CDL-04.073			

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Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186

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DRYING TIMES								
	Hardener type	Object temperature	20°C			60°C		
			Dry to touch	Dry to polish	Full hardness	Dry to touch	Dry to polish	Full hardness
	CDL-04.070		3 - 4 h	6 - 8 h	7 days	25 min	30 min	30 min + 5 days/20°C
	fast CDL-04.073		1 - 2 h	5 - 5.5 h	7 days	15 min	20 min	20 min + 5 days/20°C
	slow CDL-04.084		4 - 5 h	7 - 9 h	7 days	30 min	35 min	35 min + 5 days/20°C
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down								
	<b>IR drying</b>		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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