

CLEAR COAT VOC LIGHT OPAQUE

CLB-03.032

CHARACTERISTICS:

Satin 2-pack acrylic medium solid clear coat, designed for car refinish and industrial coatings. Characterized by high chemical, mechanical and weathering resistance as well as a high hardness. Easy to use. Provides high-quality coating with satin finish of 25-30 GU units, resistant to scratches and UV. The gloss level depends on coating thickness and the lower the thickness, the lower the gloss level. Suitable for applications 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/IIIB(e)(840) max. 840 g/l

Clear coat CLB-03.032:

Shelf life: 9 months

Density (20°C): 0.98 – 1.00 g/cm³

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/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 48.5	
SPRAY VISCOSITY					
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C	18 - 20 s 18 - 21 s 31 - 35 s			
APPLICATION					
	Spray gun gravity feed	nozzle 1.3 mm		pressure operating pressure as recommended by the spray gun manufacturer	
	Application	coats number 2	flash-off time		dry film thickness 45 - 55 µm
			between coats 5 min	before baking 10 min	
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		7.5 m ² /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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DRYING TIMES				
	Object temperature	60°C	20°C	Full hardness at 20°C
	Hardener type			
	standard CDL-04.043	30 min	3 h	5 - 7 days
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.