

CLEAR COAT VOC/R

CLB-03.049

CHARACTERISTICS:

Very fast curing 2-pack acrylic clear coat characterized by rapid early hardness. It is ready for polishing only after 15 minutes of forced drying at 60°C and cooling down. Very good flow and levelling properties. High gloss and final hardness. Outstanding durability due to chemical, UV and weather resistance. Well balanced pot life enables safe application. Designed for use on solvent- and waterborne base coats. Very high solids and VOC conform product.

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 5-7-minute break for the solvents to evaporate before applying another coat.

TECHNICAL DATA:

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

Clear coat CLB-03.049:

Shelf life: 12 months

Density (20°C): 1.00 – 1.01 g/cm³

Colour: slightly yellow

Hardener CDL-04.058:


Shelf life: 12 months

Density (20°C): 1.00 – 1.01 g/cm³


Colour: colourless/slightly yellow

NOTE: Possible light colouration of the hardener doesn't affect the shade of the finish coat.



MIXING RATIO

	Clear coat (A) Hardener (B)	by volume	by weight
		2	100
		1	50

SPRAY VISCOSITY



		
	DIN cup 4mm at 20°C	16 - 18 s
	Ford cup 4mm at 20°C	17 - 19 s
	ISO cup 4mm at 20°C	34 - 39 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	
		1.5 (½ thin closed coat + 1 full wet coat)	5 - 7 min	10 min	50 - 60 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		10 - 12 m ² /l			
Pot life at 20°C		50 min			

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DRYING TIMES			
	Object temperature	20°C	60°C
	Dry to touch	1 - 1.5 h	10 min
	Dry to polish	3.5 - 4 h	15 min
	Full hardness	4 days	15 min + 3 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 at a temperature below 18°C. Low application temperature changes the coating's properties and may impair the visual effect. 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 freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage and transportation is: +10 to +30°C. Avoid extreme temperature fluctuation.

Note: The storage and transportation temperature must be not lower than +5°C. Acclimatize the product to room temperature naturally.