

## 4.2 VOC CLEAR COAT 4:1 CLB-03.062

### CHARACTERISTICS:

Medium solid two-component polyurethane clear coat. Product is easy and safe to apply. Optimum flow provides exceptional gloss and DOI. The resultant coating has good mechanical, chemical and weathering resistance. Clear coat is suitable for application over solvent and water-borne basecoats.

### APPLICATION:

Measure out the A+B mixture by volume: 4 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 - 3 normal coats with a 5 - 7 minute break for the solvents to evaporate before applying another coat. Allow 10 minute flash-off after last coat prior to force drying.

### TECHNICAL DATA:





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

#### Clear Coat CLB-03.062:

Shelf life: 12 months      Density (20°C): 0.96 - 0.98 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

#### Hardener Medium CDL-04.075/ Fast CDL-04.082/ Slow CDL-04.081:

Shelf life: 12 months      Density (20°C): 1.01 - 1.03 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

MIXING RATIO					
	-	by volume		by weight	
	Clear coat (A)	4		100	
	Hardener (B)	1		26.3	
SPRAYING VISCOSITY					
	DIN cup 4 mm at 20°C	13 - 16 s			
APPLICATION					
	Gravity feed spray gun	nozzle		pressure	
		1.3 mm		operating pressure according to spray gun manufacturer's recommendations	
	Application	number of layers	flash-off time between coats	flash-off time before baking	dry film thickness per full wet coat
		2 - 3	5 - 7 min	10 min	20 - 25 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		16 m <sup>2</sup> /l (with a dry film thickness 25 µm)			
Pot life at 20°C		4 h			

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NIP 781 16 87 419, REGON 634159570, Kapitał Zakładowy 2.000.000,00 PLN

Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186, Certyfikat ISO 9001/ ISO 14001/ PN-N 18001

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### CLB-03.062

DRYING TIMES			
	<b>Object temperature</b>	<b>20°C</b>	<b>60°C</b>
	<b>Drying time</b>	9 - 10 h	30 min
	NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down		
	<b>IR drying</b>	Short and medium wave: 10 min Follow IR lamp manufacturer's recommendations. 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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