

# CLEAR COAT MS/B

## CLB-03.066

### CHARACTERISTICS:

Medium solid anti-scratch two-package clear coat. Characterized by marvelous gloss and high initial hardness. The resultant coating has good chemical, mechanical and UV light resistance. Suitable for application in spray booths or areas adapted for painting. Can be applied over solvent- and waterborne base coats.

### APPLICATION RECOMMENDATIONS:

The appropriate flash-off time should be maintained between the coats in case of changing weather conditions or air flow velocity in the old type spray booth.

### 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 - 3 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-03.066:

Shelf life: 12 months      Density (20°C): 0.95 – 0.97 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

#### Hardener CDL-04.077:

Shelf life: 12 months      Density (20°C): 0.93 – 0.95 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

MIXING RATIO					
	-	by volume		by weight	
	Clear coat (A)	2		100	
	Hardener (B)	1		48	
SPRAYING VISCOSITY					
	DIN cup 4 mm at 20°C	15 - 17 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		dry film thickness
			between coats	before baking	
		2 - 3	5 - 7 min	10 min	35 - 60 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical efficiency		12.5 m <sup>2</sup> /l (at a layer thickness 20 µm)			
Pot life at 20°C		3 h			

### Chemical Alliance Polska Sp. z o.o.



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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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DRYING TIMES			
	<b>Object temperature</b>	<b>20°C</b>	<b>60°C</b>
	<b>Dry to polish</b>	6 - 7 h	25 min
	<b>Full hardness</b>	5 days	25 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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