

CLEAR COAT VOC/SE

CLB-03.079

CHARACTERISTICS

Two-component, very high solid clear coat. It provides an easy and comfortable application, good levelling, brilliant gloss and fast drying properties. It can be easily polished only after 15 minutes at 60 °C or 2.5-3 hours at 20°C. Ideal for different kind of applications: spot repairs, single panel repairs and for full car body respray. Can be applied over 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 or 1.5 coats with a 4 - 6 minute break for the solvents to evaporate before applying another coat.

TECHNICAL DATA

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

Clear coat CLB-03.079

Shelf life: 12 months

Density (20°C): 0.99 – 1.0 g/cm³

Colour: colourless/slightly yellow


Hardener CDL-04.088

Shelf life: 12 months


Density (20°C): 1.02 – 1.03 g/cm³

Colour: colourless



MIXING RATIO

		by volume	by weight
		Clear coat (A)	2
	Hardener (B)	1	51.4

SPRAYING VISCOSITY

		
	DIN cup 4 mm at 20°C	16 - 18 s
	Ford cup 4 mm at 20°C	18 - 20 s
	ISO cup 4 mm at 20°C	36 - 38 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	
		1.5 - 2	4 - 6 min	10 min	50 - 60 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical efficiency		10 - 12 m ² /l			
Pot life at 20°C		90 min			

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DRYING TIMES			
	Object temperature	20°C	60°C
	Dry to touch	1.5 h	10 min
	Dry to polish	2.5 - 3 h	15 min
	Full hardness	5 days	15 min + 5 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 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.