

CLEAR COAT VOC/X MIBK FREE

CLB-03.083

CHARACTERISTICS

Ultra-fast VOC compliant 2-pack acrylic clear coat ideal for all types of repair where high throughput and premium quality are required. It offers an excellent levelling, quick flash-off time and extreme drying, only 5 min/60°C. Provides a safe polishing directly after cooling down to room temperature. Distinguished by high gloss and superior gloss retention. Designed for use on solvent- and waterborne basecoats.

NOTE

Clear coat VOC/X MIBK FREE (CLB-03.083) is a new version of clear coat VOC/X (CLB-03.081) which does not contain MIBK solvent (methyl isobutyl ketone) classified by European Union as possibly carcinogenic to humans. Technical specification and quality of the product remain unchanged.

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 3-4 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 VOC/X MIBK FREE CLB-03.083:

Shelf life: 12 months Density (20°C): 0.98 – 1.0 g/cm³ Colour: colourless/slightly yellow



CLEAR COAT VOC/X MIBK FREE HARDENER CDL-04.094:

Shelf life: 12 months Density (20°C): 1.04 – 1.06 g/cm³ Colour: colourless/slightly yellow

MIXING RATIO					
			by volume	by weight	
	Clear coat (A)		2	100	
	Hardener (B)		1	53	
SPRAYING VISCOSITY					
	DIN cup 4 mm at 20°C		15 - 17 s		
	Ford cup 4 mm at 20°C		16 - 18 s		
	ISO cup 4 mm at 20°C		30 - 32 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	3 - 4 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		60 min			

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DRYING TIMES					
	Object temperature	20°C	40°C	50°C	60°C
	Dry to touch	60 min	5 min	5 min	4 min
	Dry to polish	2 h	20 min	15 min	5 min
	Full hardness	4 days	20 min + 4 days/20°C	15 min + 4 days/20°C	5 min + 4 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 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.