

4.2 VOC CLEAR COAT 4:1

CLB-03.062

v.05-11.2022

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/IIIB(e)(840) max. 840 g/l


Clear Coat CLB-03.062:

Shelf life: 12 months Density (20°C): 0.96 - 0.98 g/cm³ 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/cm³ 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
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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 minutes	10 minutes	20-25 µm
Recommended process conditions		temperature		hardener	
		15-18°C		fast CDL-04.082	
		18-25°C		medium CDL-04.075	
		25-32°C		slow CDL-04.081	
		relative air humidity 40 - 60%			
Theoretical coverage		16 m²/l (with a dry film thickness 25 µm)			
Pot life at 20°C		4 hours			



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

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DRYING TIMES					
	<div>Object temperature</div> <div>Hardener type</div>	60°C	20°C		Full hardness at 20°C
		Dry to polish	Dry to assembly	Dry to polish	
	fast CDL-04.082	25 minutes	4-5 hours	8-9 hours	5-7 days
	medium CDL-04.075	30 minutes	6-7 hours	9-10 hours	
	slow CDL-04.081	30 minutes	8-9 hours	10-11 hours	
NOTE: prior to polishing the clear coat dried at 60°C, wait up to 1 hour for cooling down					
	IR drying	Short and medium wave: 10 minutes 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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