

# CLEAR COAT VOC SUPREME

## CLB-03.091

### CHARACTERISTICS

Highest quality fast drying, ultra-high solid clear coat. Designed for painting overall vehicles with short curing time. Recommended for use on solvent- and waterborne basecoats. Product features:

- very slow increase in viscosity after addition of hardener (pot life - 90 minutes),
- longer flash off time in comparison to other fast drying clear coats, what provides safe full car painting,
- short drying time (5 minutes at 60°C or 3 hours at 20°C) and easy application,
- crystal gloss and appearance,
- very high hardness.

### 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 8-10 minute break for the solvents to evaporate before applying another coat.

### TECHNICAL DATA

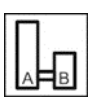
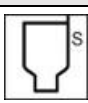








VOC 2004/42/IIIB(d)(420) max. 420 g/l

**CLEAR COAT VOC SUPREME CLB-03.091**

Shelf file: 12 months      Density (20°C): 0.98 – 1.0 g/cm<sup>3</sup>      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/cm<sup>3</sup>      Colour: colourless/slightly yellow

MIXING RATIO									
		by volume	by weight						
	Clear coat (A)	2	100						
	Hardener (B)	1	53						
SPRAYING VISCOSITY									
	DIN / FORD / ISO cup 4 mm at 20°C	15 - 18 s / 16 - 19 s / 30 - 33 s							
APPLICATION									
	Gravity feed spray gun	nozzle	1.3 mm						
		pressure	according to spray gun manufacturer's recommendations						
	Application	number of layers	1.5						
		film thickness wet / dry	90 - 100 µm / 50 - 60 µm						
		flash-off time between coats	8 - 10 min						
		flash-off time before baking	10 min						
		note	<table border="1" style="display: inline-table; vertical-align: middle;"> <tr> <td>1</td> <td>~65 µm</td> <td></td> <td></td> </tr> <tr> <td>0.5</td> <td>~30 µm</td> <td></td> <td></td> </tr> </table> <p>Apply ½ thin closed coat and 1 full wet coat layers with recommended total wet thickness ~100 µm. Excessive thickness layers may cause runs, longer evaporation and drying times, lower hardness, or other paint defects.</p>	1	~65 µm			0.5	~30 µm
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0.5	~30 µm								

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NIP 7811687419, BDO 000012588, Kapitał Zakładowy 2.000.000,00 PLN

Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186, Certyfikat ISO 9001/ ISO 14001/ ISO 45001

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<b>Recommended process conditions</b>	temperature 18 - 22°C, relative air humidity 40 - 60%
<b>Theoretical efficiency</b>	10 - 12 m <sup>2</sup> /l
<b>Pot life at 20°C</b>	90 min

DRYING TIMES					
	Object temperature	20°C	40°C	50°C	60°C
	<b>Dry to touch</b>	80 min	5 min	5 min	4 min
	<b>Dry to polish</b>	3h	20 min	15 min	5 min
	<b>Full hardness</b>	5 days	20 min + 4 days/20°C	15 min + 4 days/20°C	5 min + 4 days/20°C
	<b>NOTE:</b> Prior to polishing the clear coat dried at 60°C, wait up to 1h 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 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.

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