

CLEAR COAT VOC/X

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.

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 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-03.083:

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

HARDENER STANDARD CDL-04.094/SLOW CDL-04.106:

Shelf life: 12 months Density (20°C): 1.04 – 1.07 g/cm³ Colour: colourless/slightly yellow

MIXING RATIO

		by volume	by weight	
		Clear coat (A)	2	100
		Hardener (B)	1	53

SPRAYING VISCOSITY

 S	DIN / FORD / ISO cup 4 mm at 20°C	15 - 17 s / 16 - 18 s / 30 - 32 s
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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		
		hardener type	processing temperature	
			18 - 25°C	25 - 35°C
		standard CDL-04.094	3 - 4 min	-
		slow CDL-04.106	6 - 7 min	3 - 4 min
		flash-off time before baking	10 minutes	
		note	 ~65 µm  ~30 µm	 
			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.	

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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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Recommended process conditions	temperature 18 - 35°C, relative air humidity 40 - 60%
Theoretical efficiency	10 - 12 m ² /l
Pot life at 20°C	60 min

DRYING TIMES						
	Hardener type	Object temperature	20°C	40°C	50°C	60°C
			Dry to touch			
	STANDARD CDL-04.094 / SLOW CDL-04.106		60 min / 80 min	5 min	5 min	4 min
			Dry to polish			
			2h	20 min	15 min	5 min
			Full hardness			
NOTE: Prior to polishing the clear coat dried at elevated temperature, wait up to 1h for cooling down.			4 days	20 min + 4 days/20°C	15 min + 4 days/20°C	5 min + 4 days/20°C
	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.

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