

CLEAR COAT VOC/RX

CLB-03.099

CHARACTERISTICS

Ultra-fast, VOC compliant 2K acrylic clear coat engineered for high-speed refinishing. Developed for maximum productivity, it delivers exceptional levelling, short flash-off time and extreme air-drying performance – ready for polishing in just 60 minutes at 20°C or 15 minutes at 40°C. Perfectly suited for spot repairs as well as full panel applications. Recommended for use on solvent- and waterborne basecoats. Product features:

- ultra-fast air drying – polishing after 60 minutes at 20°C,
- outstanding levelling and gloss development,
- high throughput – optimized for fast repair processes,
- easy and reliable application.

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 5 - 6 minutes 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-03.099

Shelf life: 12 months

Density (20°C): 0.98 – 1.0 g/cm³

Colour: colourless/slightly yellow

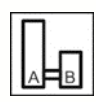
HARDENER H-235 CDL-04.108

Shelf life: 12 months


Density (20°C): 1.02 – 1.04 g/cm³

Colour: colourless/slightly yellow









MIXING RATIO

	by volume		by weight
	Clear coat (A)	2	100
	Hardener (B)	1	52

SPRAYING VISCOSITY

	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	5 - 6 min						
		flash-off time before baking	10 min						
		note	<table border="1" data-bbox="1029 1691 1460 1758"> <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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Recommended process conditions	temperature 18 - 22°C, relative air humidity 40 - 60%
Theoretical efficiency	10 - 12 m ² /l
Pot life at 20°C	40 min

DRYING TIMES					
	Object temperature	20°C	40°C	50°C	60°C
	Dry to touch	30 min	5 min	5 min	4 min
	Dry to polish	60 min	15 min	10 min	5 min
	Full hardness	4 days	15 min + 4 days/20°C	10 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 30 minutes for cooling down.				

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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