

TECHNICAL DATA SHEET

Item number: 0101-001-XXXX

Product name: 2K HS CLEAR COATING

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Description: Two-component clear coating with high amount of solids and enhanced scratch resistance (SR – Scratch Resistance) – that provides superb look of the surface. It is a solution of high quality acrylic resin and isocyanic resin. The coating provides a tough, durable finish that is resistant to scratches, weather conditions and UV radiation.

RECOMMENDED USE

As a top coat in the automotive industry.

TECHNICAL PROPERTIES

• Density, (approx) kg/dm ³	0,99
• Recommended film thickness per one coat, dry/wet, µm.	30/65
• Dry time (20 °C): 1 degree (tack-free), h	1
3 degree (dry-to-touch),h	3
• Dry time (40 °C): 1 degree (tack-free), min	10
3 degree (dry-to-touch),h	1
• Theoretical coverage at film thickness 30 µm dm ³ /m ²	0,06
• Non-volatile ingredients (approx), % by volume/mixture	48
• VOC (cat. B/5) permitted, g/l	840
• VOC in a ready-to-use product, g/l	520
• Recommended number of coats	2-3

GLOSS: high gloss

COLOR: clear

PRODUCT APPLICATION

Stir the contents after opening the cans.

PREPARATION OF MIXTURE – precisely mix part I with part II

in the following ratio: by volume

- part I 2
- part II 1

part II - item number: 0104-001-0000

After careful mixing and diluting to spraying viscosity – spray with a conventional spray gun. After 10 minutes (in 20°C) the product is ready-to-use. Pot life - 4h

Application tools

Single coat – conventional sprayer – after thinning: viscosity DINØ4 – 25 sec

- ⤴ tip size 1,2 – 1,4 mm
- ⤴ spraying pressure 2,5 – 3,5 atm
- ⤴ spraying distance from the surface 20 – 25 cm
- ⤴ it is recommended to apply 2-3 coats
- ⤴ time for solvent evaporation between coats: 30 minutes
- ⤴ there is a possibility to redry the coating in a higher temperature after 30 minutes from application of the last coat (time required to achieve proper flow rate and initial solvent evaporation)

Solvent: item number 8002

Recommended amount of thinner for mixture (part I + II) – 10-20% by volume.

Solvent for hardware cleaning: 8002

APPLICATION

Surfaces

The coating can be applied on a surface that was primed and the primer is partially dry. Apply 2-3 individual coats allowing 5-10 minutes between coats (depending from temperature and coat thickness). After 10 minutes from application of last coat the surface may be cured in raised temperature.

Cleaning and degreasing: Surface to be painted must be clean, degreased and dry.

Painting and curing conditions

- surface temperature higher than 10°C
- good ventilation

Additional information

- ⤴ Depending from use and type of surface a thicker coat than recommended may be applied. Conventional spraying typically requires one-component thickness of 25-35µm. Change in coat thickness influences the coverage, dry coat thickness, dry and recoat times.
- ⤴ VOC content in ALMA-COLOR products complies to Minister of Economy Regulation from 16.02.2007 and UE Directive 2004/42/CE from 24.04.2004.

SHELF LIFE: 12 months from the production date in original unsealed container in temperature 5-35°C. 6 months for part II.

WARNING! This product is designed for professional use in the given industry. Detailed information regarding product safety can be found in the MSDS.