

## :: 2K Clear VOC HS / SR

2K clear coat

### CHARACTERISTICS

Multi purpose clear coat for industrial use

- High scratch resistant
- Good flow
- UV resistant (non-yellowing)
- High hardness
- Good chemical, mechanical and weathering resistance

### APPLICATION

2K Clear VOC HS / SR was designed for use on solvent- and waterborne base coat.

### PRODUCT DATA

#### MATERIAL DATA:

#### Clear coat:

Density at +20°C: 0,96 g/cm<sup>3</sup>

Colour: clear

#### Hardener:

Density at +20°C: 1,00 g/cm<sup>3</sup>

Color: clear / slightly yellow

**Note:** Possible light coloration of the hardener doesn't affect the shade of the finishing coat.

**V.O.C. content:** 2004 / 42 / IIB (e)(840) < 840

**Efficiency:** approx. 9-10 m<sup>2</sup>/l at 50 µm

## **HANDLING**

### **Surface:**

The surface must be clean, dry and grease free.

**Mixing ratio:** 2:1

### **Mixing ratio by volume:**

Clear (A) 100 vol.

Hardener (B) 50 vol.

### **Mixing ratio by weight:**

Clear (A) 96g

Hardener (B) 50g fast, standard and slow.

It is strongly recommended to work within the complete system.

Drying and adhesion problems can not be excluded with use of thinning and hardening material of external systems.

### **Pot life at 20°C:**

Hardener fast: 1.5 hours at 20°C

Hardener standard: 2 hours

Hardener slow: 2 hours at 20°C

**Spray Viscosity:** Ford cup 4mm: 15 - 17 sec. at 20°C

**Gun Application:** Gravity spray gun

**Nozzle diameter:** 1,3 mm

**Air pressure (bar):** Air pressure as recommended by the spray gun manufacturer.

**Application:**

2 normal coats

**Flash off time between the applications at +20°C:**

Hardener fast or standard: 7 minutes

Hardener slow: minutes: 10 minutes

**Total thickness of layer (dried):** 50 – 55 µm

**Drying at 60°C**

Hardener fast: 20 minutes

Hardener standard: 30 minutes

Hardener slow: 40 minutes

**Dry through at 20°C**

Hardener fast: 4 - 5 hours

Hardener standard: 6 - 7 hours

Hardener slow: 8 - 9 hours

**Polishing at 20°C:**

Hardener fast: 8 - 9 hours

Hardener standard: 10 - 11 hours

Hardener slow: 11 - 12 hours

**Total hardness at 20°C:**

Hardener fast: 5 - 7 days

Hardener standard: 5 - 7 days

Hardener slow: 5 - 7 days

**Hardening time infrared short and medium wave:**

Hardener fast: 8 minutes  
Hardener standard: 10 minutes  
Hardener slow: 12 minutes

The exact hardening times depend on the layer thickness.

In case of air drying, the minimum temperature must be +15°C.  
Forced drying is recommended.

**Storage:**

Keep under cover in a cool and well ventilated place, avoid direct sunlight.  
Temperatures between +5°C and +30°C are recommended.

**Shelf life:**

At least 12 months from date of manufacturing.

**SAFETY ISSUES**

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgement in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

Directions for handling and waste disposal are



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in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry.

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