

CS 2K Clear VOC 420

2K clear coat

:: CHARACTERISTIC

The CS 2K Clear VOC 420 is a two component clear coat with a high solid content which conforms to VOC. The clear coat has a VOC content below 420 g/l and is state of the art and the best technology. Different hardeners enable the 2K Clear VOC 420 to be used both for gloss paintings and for spot repairs. The clear coat dries and hardens rapidly, has a brilliant gloss and excellent flow properties. It can be polished easily and is highly scratch and UV resistant.

:: APPLICATION

The clear coat is suitable for application on small parts as well as on complete paintwork like full vehicle fronts.

:: PRODUCT DATA

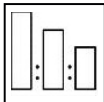
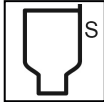



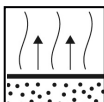

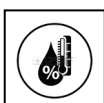
MATERIAL DATA



Colour clear coat:	Transparent
V.O.C.:	2004/42/IIB(d)(420) < 420 g/l
Shelf life:	18 month in closed original container at 20°C
Density clear coat at 20°C:	0.98 - 0.99 g/cm ³
Density hardener at 20°C:	1.00 - 1.05 g/cm ³
Dry film thickness:	50 - 55 µm
Efficiency:	10 – 11 m ² /l

:: HANDLING

For application on solvent- or water-based basecoats and uni-topcoats.

It is strongly recommended to work with the complete system. Drying and adhesion problems cannot be excluded with use of thinning and hardening materials of external systems.

MIXING RATIO		
	2K Clear VOC 420 2K Hardener Thinner High Gloss Additive	by volume
		2 1 0 - 10% vol. on component A 5 - 8% vol. on component A
	2K Clear VOC 420 2K Hardener standard 2K Hardener fast, very fast 2K Hardener slow Thinner High Gloss Additive	by weight
		100 g 51 g 52 g 53 g 0 - 9% wt. on component A 4 - 7% wt. on component A
SPRAYING VISCOSITY		
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C	18 - 22 seconds 19 - 23 seconds 42 - 50 seconds
APPLICATION		
	Spray gun gravity feed	Nozzle size / pressure
		Nozzle size: 1,2mm Air pressure: Please pay attention to operating pressure recommendations of the manufacturer.
	Application	2 spraying operations
		2 coats
	Pot life at 20°C	35 min with hardener standard 30 min with hardener fast 20 min with hardener very fast 50 min with hardener slow
	Flash off	7 - 10 minutes between coats 10 minutes before baking
	Dry coat thickness	50 - 55 µm
	Process conditions	Temperature 18 - 22°C Relative air humidity 40 - 60%

PROCESSING			
	Object temperature	20°C	60°C
	Hardener standard	10 h	30 min
	Hardener fast	8 h	20 - 25 min
	Hardener very fast	6 h	10 - 15 min
	Hardener slow	12 h	45 min
	Full hardness	7 days	
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1h for cooling down.			
	IR Drying	12 - 15 min. Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying	

:: STORAGE AND TRANSPORTATION CONDITIONS

Protect from freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage and transportation temperature range is: +10 to +30°C. Avoid extreme temperature fluctuation.

Note: The storage and transportation temperature must be not lower than +5°C. Acclimatize the product to room temperature naturally.

:: 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 coating's properties and may impair the visual effect. Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.



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