

2K Carbo Clear Plus

2K clear coat

:: CHARACTERISTIC

This VOC-conform clear coat is a special clear coat for Carbon parts. It is characterized by a rapid and very good hardness.

The well balanced pot life enables a safe application. The 2K Carbo Clear Plus has a brilliant gloss and flow. It can be polished easily, has an excellent scratch resistance and an outstanding durability due to the very high UV-Protection, chemical- and weather resistance.

:: APPLICATION

This high solid, VOC-conform Carbon Clear Coat is suitable for all paint works on Carbon. Whether small parts or complete vehicle parts - with this special Clear Coat you cover the full spectrum of Carbon coating.

:: PRODUCT DATA

MATERIAL DATA

Colour clear coat:	Transparent to slightly yellow
V.O.C.:	2004/42/IIIB(d)(420) < 420 g/l
Shelf life:	12 month in closed original container at 20°C
Density clear coat at 20°C:	1.00 - 1.01 g/cm ³
Density hardener at 20°C:	1.00 - 1.01 g/cm ³
Dry film thickness:	50 - 60 µm
Efficiency:	10 - 12 m ² /l



:: HANDLING

For application on solvent-based or water-based paints. 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.

Clear coat has to be reworked 2 hours after application at the latest.



MIXING RATIO		
	2K Carbo Clear Plus 2K Carbo Clear Plus Hardener	by volume
		2 1
	2K Carbo Clear Plus 2K Carbo Clear Plus Hardener	by weight
		100 g 50 g
SPRAYING VISCOSITY		
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C	16 - 18 seconds 17 - 19 seconds 34 - 39 seconds
APPLICATION		
	Spray gun gravity feed	Nozzle size / pressure Nozzle size: 1,3mm Air pressure: Please pay attention to operating pressure recommendations of the manufacturer.
	Application	1,5 spraying operations 1/2 thin closed coat 1 full wet coat
	Pot life at 20°C	50 min
	Flash off	5 - 7 minutes between coats 10 minutes before baking
	Dry coat thickness	50 - 60 µm
	Process conditions	Temperature 18 - 22°C Relative air humidity 40 - 60%

PROCESSING			
	Object temperature	20°C	60°C
	Dry to touch	1 - 1.5 h	10 min
	Dry to polish	3.5 - 4 h	15 min
	Full hardness	4 days	15 min + 3 days at 20°C
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1h for cooling down.			
	IR Drying	8 - 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.

2004/42/IIB (d)(420) < 420: The EU limit value for this product (product category: IB.d) in ready to use form is max. 420 g/litre of VOC.

:: 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.

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