

2K Clear VOC Speed Plus

2K clear coat

:: CHARACTERISTIC

The very fast curing 2K Clear VOC Speed Plus clear coat is characterized by very rapid hardness. After only 15 minutes drying time and cooling down the clear coat can be polished. Very good flow, high gloss and fast drying.

A VOC conform product with high solids, perfect for solvent- and waterborne basecoat systems.

:: APPLICATION

This VOC-conform 2K clear coat is perfect for application on small parts and for complete paintwork like full vehicle fronts.

:: PRODUCT DATA

MATERIAL DATA

Colour clear coat:	Transparent
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 Clear VOC Speed Plus 2K Hardener VOC Speed Plus	by volume
		2 1
	2K Clear VOC Speed Plus 2K Hardener VOC Speed Plus	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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