

## :: 2K Clear VOC Speed Plus

2K clear coat

### CHARACTERISTICS

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

### PRODUCT DATA

Specific weight Clear Coat: 1,00 g/cm<sup>3</sup>

Specific weight hardener: 0,99 g/cm<sup>3</sup>

V.O.C.: < 420 g/l for ready to use product

Shelf life: 12 months - in closed original packaging

Colour: Colourless

Drying thickness: 50 – 60 µm

Theoretical efficiency: 8-9 m<sup>2</sup>/l at 60 µm

Pot life at 20°C: 50 min.

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## 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.

### **Mixture ratio A/B:**

2 : 1 by volume

100 : 50 by weight

**Processing viscosity:** 16-18 seconds DIN 4mm at 20°C

**Application:** 1.2 mm nozzle, 2.1 – 2.2 bar pressure , Spray gun gravity feed e.g. Sata Jet RP or DeVilbiss GTI T2. Please pay attention to handling recommendations of the manufacturer.

### **Application process:**

Apply in: 1.5 coats. ½ thin closed coat + 1 full wet coat.

Flash off time: 5 – 7 minutes between coats, 10 minutes before baking

Process conditions: temperature > 15°C, relative air humidity up to 75%

### **Drying time:**

Dry to touch: 20°C 1 – 1.5 h, 60°C 10 minutes

Dry to polish: 20°C 3.5 – 4 h, 60°C 15 minutes

Full hardness: 20°C 4 days, 60°C 3 days

Infrared drying: 8 - 15 minutes

2004/42/IB (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.



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## 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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