

CLEAR COAT HS ANTI SCRATCH

CLB-03.014

v.08-07-2017

CHARACTERISTICS:

High solid clear coat with very good flow properties and increased scratch resistance. Characterized by high hardness, UV resistance (non-yellowing) as well as chemical and weathering resistance. Suitable for application in spray booths or areas adapted for painting. Designed for use on solvent- and waterborne base coats.

APPLICATION:

Measure out the A+B mixture by volume: 2 parts of clear coat (A) and 1 part of hardener (B), then mix thoroughly. Apply with a spray gun with a nozzle diameter of 1.3 mm in 2 normal coats with a 5-7-minute break for the solvents to evaporate before applying another coat. To improve gloss properties, it is recommended to use Top Gloss Additive of up to 7% vol. on component A.

TECHNICAL DATA:

VOC 2004/42/IIB(e)(840) max. 840g/l

Clear coat CLB-03.014:

Shelf life: 18 months

Density (20°C): 0.97 – 0.99 g/cm³

Colour: colourless

Hardener standard CDL-04.019/ fast CDL-04.032/ very fast CDL-04.063/ slow CDL-04.034/ very slow CDL-04.062/ universal CDL-04.059:

Shelf life: 12 months

Density (20°C): 0.97 – 0.99 g/cm³

Colour: colourless/slightly yellow

NOTE: Possible light colouration of the hardener doesn't affect the shade of the finishing coat.

Top Gloss Additive (gloss stabilizer) CDL-07.024:

Shelf life: 24 months

Density (20°C): 0.85 – 0.87 g/cm³

Colour: colourless

MIXING RATIO

	Clear coat (A) Hardener (B) Top Gloss Additive (C)	by volume	by weight
		2	100
		1	50
	0 - 7% vol. on component A		0 - 6.1% wt. on component A

SPRAY VISCOSITY

		
	DIN cup 4mm at 20°C	16 - 18 s
	Ford cup 4mm at 20°C	17 - 19 s
	ISO cup 4mm at 20°C	31 - 36 s

APPLICATION

	Spray gun gravity feed	nozzle	pressure		
		1.3 mm	operating pressure as recommended by the spray gun manufacturer		
	Application process	coats number	flash-off time		dry film thickness
			between coats	before baking	
		2	5 - 7 min	10 min	45 - 50 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical coverage		9 - 10 m ² /l			

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Pot life at 20°C	up to 2 h
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DRYING TIMES					
	Object temperature Hardener type	60°C	20°C		Full hardness at 20°C
		Dry to polish	Dry to assembly	Dry to polish	
	standard CDL-04.019	30 min	6 - 7 h	10 - 11 h	5 - 7 days
	fast CDL-04.032	20 min	4 - 5 h	8 - 9 h	
	very fast CDL-04.063	15 min	3.5 - 4.5 h	7.5 - 8.5 h	
	slow CDL-04.034	40 min	8 - 9 h	11 - 12 h	
	very slow CDL-04.062	50 min	10 - 11 h	12 - 14 h	
	universal CDL-04.059	30 min	6 - 7 h	10 - 11 h	
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down					
	IR drying	Short and medium wave: 10 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.			

REMARKS:

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product in a temperature below 18°C. Low application temperature changes the characteristics of the coating finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

STORAGE AND TRANSPORTATION CONDITIONS:

Protect from freeze, heat, sunlight and moisture. Store tightly closed in a dry, cool place.
Recommended storage temperature: +10 to +30°C.