

TECHNICAL DATA SHEET

Date of issue: 02/08/2019

Last updating: n°



Name:	CLEAR HS SR AIR	Category:	Special finishes B/e
Definition:	air drying HS acrylic clear	V.O.C. limit:	840 g/l
Code:	61.1.X99/3	V.O.C. ready to use:	490g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Two-pack topcoat, based on hydroxylated acrylic resin and aliphatic isocyanates with high solids content and excellent hydrocarbon resistance. The inclusion of nanotechnology products has given particular scratch and weathering resistance. It can be easily applied for both touching up and for total painting and can be polished after 90 minutes of drying at room temperature (25°C).

GENERAL USES

Car refinishing and coachwork.

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle.

This means that presence of grease and oils on the surfaces is absolutely not allowed.

- Ferrous surfaces. Remove all traces of oil, humidity and rust carefully, by SA2 sandblasting or very careful mechanical abrasion followed by degreasing using aqueous solutions of surfactants or thinners.
- Galvanized sheet. Accurate sanding with scotch brite coarse grain followed by degreasing using thinners.
- Aluminium. Mechanical sanding procedure followed by degreasing using thinners.

Apply an acrylic primer like standard BASIC 2 (69.4.70133 or 69.4.70266) or quick air drying primer BASIC AIR (69.0.70134), followed by the base coat 47.5 series.

PREPARATION OF THE PRODUCT

	Code	Name	By weight	By volume
Component A	61.1.X99/3	Clear HS SR AIR	100 parts	100 parts
Component B	01.H3	Acryrex std acrylic hardener	50 parts	50 parts
OR	01.H100	Acryrex UHS extra fast hardener	40 parts	40 parts

Carefully mix until a uniform aspect and consistency are obtained. If necessary, dilute maximum at 5-10% with our acrylic thinners 07.055. If infrared lamps are available, it is possible to use hardener 01.H100, obtaining hardening in 15 minutes.

APPLICATION

Spray gun: nozzles of 1.2-1.5 mm diameter and 3-5 atm pressure.

Roller or brush: Only for small surfaces¹

TECHNICAL DATA

PRODUCT TYPE: Two pack product

APPEARANCE (ASTM D 523): Gloss (>95)

¹ You may need Antifoam additive 03.009 in order to avoid bubble formation while using these tools.

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COLOURS:	Transparent																					
SPECIFIC WEIGHT (ISO 2811):	(A+B) 0.99 ± 0.02 kg/lit.																					
SUPPLY VISCOSITY(DIN 53211) :	55" ± 4" Ford 4 at 25° C (component A only)																					
SOLID ON VOLUME:	A + B 52% (± 1%)																					
SOLIDS CONTENT:	A + B 52% (± 1%)																					
DRYING AT 20°C	<table><tbody><tr><td>- Dust dry:</td><td>15 - 25 minutes</td></tr><tr><td>- Touch dry:</td><td>40 - 45 minutes</td></tr><tr><td>- Polishable:</td><td>1 ½ hour (at 25°C)</td></tr><tr><td>- Total hardening:</td><td>12 hours</td></tr><tr><td>- Forced drying:</td><td>30 minutes at 60°C or 15 minutes at infrared at 80°C</td></tr><tr><td>- Maximum chemical resistance:</td><td>After 7 days</td></tr></tbody></table>	- Dust dry:	15 - 25 minutes	- Touch dry:	40 - 45 minutes	- Polishable:	1 ½ hour (at 25°C)	- Total hardening:	12 hours	- Forced drying:	30 minutes at 60°C or 15 minutes at infrared at 80°C	- Maximum chemical resistance:	After 7 days									
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RECOMMENDED COATS:	One coat and a half - two coats																					
THICKNESS ²:	50-70 µm																					
THEORETIC YIELD ³:	10-12 m²/kg																					
POT-LIFE AT 20° C:	45 minutes. At higher temperatures, pot-life decreases.																					
ADHESION (ASTM D 3359):	B= 5 on surfaces treated like above reported.																					
YELLOWING (ASTM D 4587):	ΔE<5 after 3000 hours																					
CHEM. RESIST .⁴ (UNI EN ISO 12720):	<table><tbody><tr><td>Cyclohexanone</td><td>vote 1</td><td>7 day</td></tr><tr><td>Solvento 100</td><td>vote 5</td><td>7 days</td></tr><tr><td>Ethanol</td><td>vote 4</td><td>7 days</td></tr><tr><td>Synthetic oil</td><td>vote 5</td><td>7 days</td></tr><tr><td>Idraulic oil</td><td>vote 5</td><td>7 days</td></tr><tr><td>Transmission oil SAE 30</td><td>vote 5</td><td>7 days</td></tr><tr><td>Unleaded gasoline</td><td>vote 5</td><td>7 days</td></tr></tbody></table>	Cyclohexanone	vote 1	7 day	Solvento 100	vote 5	7 days	Ethanol	vote 4	7 days	Synthetic oil	vote 5	7 days	Idraulic oil	vote 5	7 days	Transmission oil SAE 30	vote 5	7 days	Unleaded gasoline	vote 5	7 days
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REPAINTING:	Wet on wet with itself. After the complete hardening of the film, it is better a light sanding before over-coating.																					
STORAGE STABILITY:	One year for A component, 6 months for B component stored in closed packs, in a cool, dry place, away from any sources of heat.																					

² Considering a dry film.

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

⁴ The quality of chemical resistance goes from a value of 5 (means optimum) to 1 (means not good). For further information please contact Siro's technical service.