

TECHNICAL DATA SHEET

Date of issue: 25/06/14
Last updating:n°2 14/04/2015



Name:	CLEAR HS MATT	Category:	Special finishes B/e
Definition:	Acrylic matt clearcoat MS	V.O.C. limit:	840 g/l
Code:	61.4.X30	V.O.C. ready to use:	680g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Two-pack poly-acrylic topcoat, based on acryl-polyester resins and isocyanic adduct to mix before use. The use of nontechnological raw materials has improved scratch resistance and weathering resistance.

GENERAL USES

Car refinishing. commercial vehicles. General top coat for high level finishings.

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 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners .
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Sometimes is useful apply a coat of epoxy primer 29.3.
- Galvanized sheet. Delicate sanding followed by degreasing using thinners. Sometimes is useful apply a coat of epoxy primer 29.3.

Apply a coat of primer as our acrylic primer 69.4.70133, 69.4.70266 or the epoxy one, 29.3.70121. When the air drying of the primer is complete, proceed with the application of the base coat (our 47W3 or our 47.3). Then after 10-15 minutes proceed with the application of the transparent.

PREPARATION OF THE PRODUCT

	Code	name	By weight	By volume
Component A	61.4.X30	Matt MS scratch resistant	100	100
Component B	01.H2	Acryrex H2	20	20

Carefully mix until an uniform aspect and consistency are obtained. Dilute with 20% of 07.093 thinner to obtain a viscosity of 18-20" Ford 4. When temperature exceed 25°C 07.094, slow thinner, is suggested together with slow hardner 01.H2L. If temperature is inferior to 15-10°C, rapid hardner 01.H2 R is suggested. For big surfaces (cars, doors etc.) we suggest to use slow thinner 07.094 and slow hardner 01.H2L in a way to obtain more homogeneous result.

APPLICATION

Spray gun: nozzles of 1,4-1,6 mm. diameter and 3-5 atm. pressure.

To avoid formation of undesired stripes we suggest to apply the product with a crossed coat. This means you have to apply a coat spraying with the airgun from left side to right side (considering the surface to be sprayed) and vice versa, then, after 3-5 minutes, you have to apply a second coat in a perpendicular way to the previous one, in other words spraying with the gun from top to bottom and vice versa.

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PRODUCT TYPE: Two pack product

APPEARANCE (ASTM D 523): Matt (12±4 gloss).

COLOURS: Transparent

SPECIFIC WEIGHT (ISO 2811): 0.95 ± 0.05 kg/l

SUPPLY VISCOSITY(DIN 53211): 36" ± 3" Ford 4
:

SOLID ON VOLUME: A + B 35% (± 2%)

SOLIDS CONTENT: A + B 35% (± 1%).

DRYING AT 20°C	- Dust dry:	20-30'	- Touch dry:2 hours
	- Total hardening :	14-18 hours	- Forced drying ¹ :

- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One crossed coat and half

THICKNESS²: 40-50 µm

THEORETIC YIELD³: 10-12 m²/kg

POT-LIFE AT 20°C: 2 hours at temperature of 20°C. At higher temperatures, pot-life decreases.

ADHESION (ASTM D 3359): B= 5 on surfaces treated like above reported.

YELLOWING (ASTM D 4587): ΔE<4 after 1000 hours

CHEM. RESIST . (number of double steps with a cotton bowl soaked with the reagent):

Solvento 100	50 double steps	ok
Aceton	10 double steps	ok
Ethanol	50 double steps	ok
Cyclohexanone	50 double steps	ok
Bref degreaser	50 double steps	ok
Unleaded gasoline	50 double steps	ok
bleach	50 double steps	ok

REPAINTING: Wet on wet with itself maximum within 30'. Over 30' is better to wait for the complete hardening of the film. then proceed with a light scratching and

¹Baking the product can produce the popping effect, to avoid this is better a flash-off time of 30'-60' before put the paint to dry in the oven

² Considering a dry film.

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

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	overcoat.
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.