

DESCRIPTION

2K UHS clear based on acrylic copolymer, to be used in clear over base system.

PROPERTIES

Excellent flow and coverage • Easy to apply • Very good overspray absorption • Mar and scratch resistant • Excellent polishability • Can be used for spot, panel repair and overall repair • UHS content • Excellent weathering resistance • Outstanding finish and resistance to yellowing • Increases productivity in air dry, low bake or IR drying.

PRODUCTS

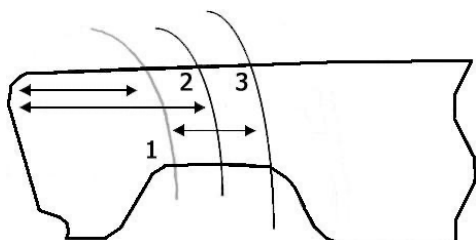
 VT018-VT019	2:1 UHS HARDENER	
		SLOW C2K036- C2K039
		STANDARD C2K034- C2K037
		FAST C2K035-C2K038

 DLP01 - DLP02	 DLP07 - DLP08	 EFC401
SLOW THINNER	MEDIUM THINNER	Ready-to-spray, fade-out (blending) edge compound, designed to allow invisible spot repairs where full panel refinishing is not desirable.

1		Suitable Substrates: • All current existing finishes, provided they are previously degreased and sanded. • Two-coat metallic, mica/pearl and solid colour finishing, suitable for car refinishing, spot repairs and complete repairing. • Thoroughly degreased and sanded polyester laminates.
2		Prior to application of 100•90 CLEAR, existing paintwork should first be abraded (e.g. ONETECH2 P800 or ASD3) and degreased with SG-AECO . ATTENTION: It is absolutely necessary to sand the OEM clear thoroughly. Superficial sanding can result in adhesion problems.
3		SG-AECO. Waterborne anti-silicone degreaser/cleaner. Use to clean surfaces to be refinished. Removes silicone, grease and wax residues from surfaces as well as some mould release agents from plastic surfaces. When cleaning plastic surfaces, the cleaner produces an anti-static effect and thus reduces dust settling. 2004/42/IIb(all)(200)65: The EU limit value for this product (product category: IIb.a II) in ready to use form is max 200 g/litre of VOC. The VOC content of this product is 65 g/L.
4		As with other paint systems, optimum spray application is achieved if the RFU clear is allowed to reach room temperature (20-25°C) before use. This is particularly important for UHS systems. It is strongly recommended that RFU cold clear is warmed at a temperature greater than 20°C before application. Cold, RFU paint, temperatures can lead to more difficult application and overspray absorption. In order to remain VOC compliant do not add extra thinner to adjust the spraying viscosity.

5		It is important to follow the recommended application procedure. Failure to do so can lead to excessive film thickness and slower drying.			
6		It is particularly important to ensure the basecoat is thoroughly dry before applying the clearcoat. ATTENTION: see TDS basecoat supplier for use of hand held or freestanding air blower.			
7		AMBIENT TEMPERATURE ABOVE 30 °C			
		100	Volume/weight parts	100•90 UHS	CLEAR
		50	Volume/weight parts	200•90	SLOW HARDENER
		0-3	Volume/weight parts	AP	
8		AMBIENT TEMPERATURE BELOW 30 °C			
		100	Volume/weight parts	100•90 UHS	CLEAR
		50	Volume/weight parts	200•90	STANDARD FAST
		0-3	Volume/weight parts	AP-R NA	
9		AMBIENT TEMPERATURE BELOW 20 °C/ ONE PANEL APPLICATION			
		100	Volume/weight parts	100•90 UHS	CLEAR
		50	Volume/weight parts	200•90	FAST/STANDARD
		0-3	Volume/weight parts	AP-R NA	
10		Activate accurately, and by weight whenever possible. Use mixed product as quickly as possible. Activated material should not be returned to original can of non-activated material. Use CATALFER HARDENERS and THINNERS only.			
11		The choice of CATALFER THINNERS should be made according to application temperature, air movement and size of job.			
12		Mix in a suitable mixing cup. Stir well and strain before use, do not shake. Make sure that hardener and thinner are mixed in well. UHS or high viscosity products can take a little longer to mix in, so a good practice is to stir hardener in first, then add thinner before stirring again.			
13		POT-LIFE	30-40 min. @ 20 °C. (STANDARD)		
14		CONVENTIONAL	1.3 mm @ 2.0-2.2 bar air inlet.		
15		HVLP	1.3 @ 0.7-0.9 bar air inlet.		
16		½ + 1 coat	- Apply 1 light, wet, coat followed by 1 full coat with 5 min. flash between coats. Wait till the first coat layer is slightly tacky before recoating. - DO NOT apply more clearcoat than indicated. - In case of application up to 2 panels or more, the first coat should be applied to all repair panels before the second coat is applied. 5 min. flash-off, BEFORE bake times (depends on spray booth)		
17			The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and circumstances.		

18		DRYING	SLOW	30 min. @ 60 °C. Use with ambient temperatures above 30 °C.		
			STANDARD	20-25 min. @ 60 °C.		
			FAST	10-15 min. @ 60 °C. 20 min. @ 40 °C. 4 hours @ 23 °C.		
				Air dry information: Dust free after 15 min. @ 23°C. Leave spraybooth on "spray mode" until this is achieved. Ensure parts are well dust free before removing from spraybooth. Dry for handling: after 60 min. All drying times depend on temperature, thickness and humidity. Polishing: after 90-120 min.		
			Bake times are quoted for metal or "oven temperature". Additional time should be allowed in the bake schedule to allow metal or oven to reach recommended temperature. Check that the spraybooth is operating effectively. If necessary make an oven check to be sure that metal temperature is reached, especially on low down repair areas.			
Flash-off and drying times depend on the applied thickness, air speed, air volume, size and shape of the panels, application method and circumstances.						
19		IMPORTANT: In case of drying at temperatures lower than those indicated, the painted substrate must not be exposed to severe conditions in the first days after the painting. Until the film has reached the complete cross-linking, strong humidity condensation, like dew and frost and contact with aggressive agents like smog, detergents, salt on the roads, must be avoided.				
20		SHORT-WAVE		5-10 min. flash-off (before bake times).		
				Flash-off: 4 min. (10-45 °C). Drying: 10 min. (15-60 °C). Depending on colour and equipment.		
21		POLISHING	60 mins after cooling			
22	REPAIR AND RECOATING		2-3H after cooling.			
			Essential before recoating to ensure good adhesion.			
23		WET	DARK P800-1000			
24		DRY	HELAN MHS SPONGE PAPER P800-1200	1S EF, MF or UF	2S EFF or MF+ 2S.CD EF or MF	
25			ONETECH 2 P800+ ONETECH 4 INT ASD 3 or 4.			



SUBSTRATE PREPARATION

1. Clean adjacent panels or blend areas with soap and water, followed by the appropriate degreasing with **SG-AECO**.
2. Scuff sand with **ASD 4** well beyond the area where the clear coat blend will end. The surface must be fully mat. Do not use NON-WOVEN abrasives.
3. Re-degrease the entire area with **SG-AECO**.
4. Mask the adjacent panel(s) with masking paper. Only expose the repair area.

BLEND APPLICATION

1	Apply the first coat of clear beyond the basecoat repair area.
2	Apply the second coat of clear beyond the first coat.
3	Using a second spray-gun, with EFC4 only, apply, in light coats, the fade-out compound necessary to melt the overspray edge. DO NOT apply heavily. DO NOT apply on the non-sanded surface. DO NOT add EFC4 to 100•90. Use EFC4 as a blending thinner.
4	After the repair area has thoroughly cured, lightly compound with a foam pad to remove overspray, dirt or enhance the gloss. Take care not to polish through the blend. Always lead the polishing machine from the repair to the OEM finish and check the surface temperature (Do not allow to get hot).

VOC R.F.U. (g/L)	2004/42/IIIB(d) (420) 420: The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC.
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	Close hardener can tightly immediately after use, as these products will react with humid air and water and lose their hardening effect. It is strongly recommended to use appropriate personal protection equipment during application.
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