

2K Clearcoat 288 HS

Clearcoat

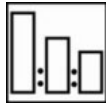
11/01/2019

L1.05.28 APAC

DESCRIPTION

High quality premium 2K PU clearcoat, which delivers outstanding gloss finish. A two component clearcoat system, which provides excellent flow, and smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

Mixing ratio



2 2K Clearcoat 288HS
 1 2K Hardener 728 (any)
 +10% Multi Thinner 810 (any)

Equipment



Spray gun set-up:
 1.2-1.4 mm

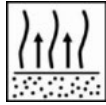
Application pressure:
 1.7-2.2 bar at the air inlet
 HVLP max 0.7 bar at the air cap

Application



2 x 1 coat
 Spray 2 wet coats, allowing the first coat to become touch dry prior to the application of the second coat.

Flash-off



Between coats
 5-10 minutes at 20°C

Drying time



	20°C	60°C
Hardener 728 B	2 hours	25 minutes
Hardener 728 C	5 hours	30 minutes
Hardener 728 CC	7 hours	35 minutes

Protection



Use suitable respiratory protection
 Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

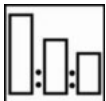
Product	Lesonal 2K Clearcoat 288HS	
	Hardener	Lesonal 2K Hardener 728 B Lesonal 2K Hardener 728 C Lesonal 2K Hardener 728 CC
	Thinner	Lesonal Multi Thinner Fast 810-B Lesonal Multi Thinner 810-C Lesonal Multi Thinner HT 810-CC

Basic raw materials	2K Clearcoat 288HS ; Acrylic Polyurethane Resins 728 Hardener (any) ; Polyisocyanate Resins Multi Thinner 810 (any) ; A blend of organic solvents
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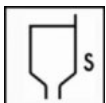
METHOD OF USE

Suitable substrates	Lesonal Basecoat SB MM 120 Lesonal Basecoat WB GT MM
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Mixing	2	2K Clearcoat 268 HS
	1	2K Hardener 728 (any)
	+10%	Multi Thinner 810 (any)



Viscosity	13-16 seconds DIN Cup 4 at 20°C
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Spray gun set-up / application pressure Spray gun Fluid tip-set-up Application pressure
 Gravity feed 1.2-1.4 mm 1.7-2.2 bar at the spray gun air inlet
 HVLP max 0.7 bar at the air cap



APPLICATION TECHNIQUE

Application process & blending Spray 2 wet coats, allowing the first coat to become touch dry prior to the application of the second coat. Generally, the flash-off time is about 5-10 minutes. Allow 10-15 minutes flash off before baking at 60°C.



Pot-life 2K Hardener 728 B 2.5 hours at 20°C
 2K Hardener 728 C 3 hours at 20°C
 2K Hardener 728 CC < 3 hours at 20°C

Drying times

Optimal Gloss Option:



	Hardener 728-B	Hardener 728-C	Hardener 728-CC
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20°C	Dust dry	15 mins	20 mins	40 mins
	Dry to handle	2 hrs	5 hrs	7 hrs
60°C	Dust dry	5 mins	5 mins	8 mins
	Dry to handle	25 mins	30 mins	35 mins

Drying time

Allow 5 minutes flash off prior to infra-red curing
 Half Power IR: 4 minutes
 Full Power IR: 6 minutes
 The panel must not reach a temperature above 100°C while curing.
 For additional infra-red drying information; see TDS S9.01.01



Film thickness By using the recommended application: 50-60 µm

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Theoretical coverage By using the recommended application, the theoretical material usage is 7 m²/lt ready to spray mixture.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

VOC The theoretical VOC is 538 g/lt ready to spray mixture.

Product storage Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.02.01

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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