

2K HS Premium Clear 420

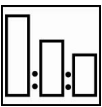



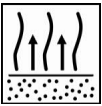


Clearcoats

28/02/2020

L1.05.08 UK & Ireland

DESCRIPTION

A complete 2 component clear system, which complies with the 420 g/l VOC limit in the EU legislation. The clearcoat is suitable for use on all types of repairs, in most application conditions. It combines easy application with good drying properties, brilliant gloss and it meets the highest demands of major motorcar manufacturers concerning scratch and car wash resistance.

Mixing ratio		5 3 1	2K HS Premium Clear 420 HS Hardener 420 Reducer Clear 420 / Accelerator	
Mixing stick		P		
Equipment		Spray gun set up: 1.2-1.4 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap	
Application		2 x 1 coat		
Flash-off		Between coats 0-5 minutes at 20°C	Before curing 3-5 minutes at 20°C	
Drying		Accelerator Reducer Clear 420	20°C 3 hours 4 hours	60°C 15 minutes 25 minutes
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator		

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product 2K HS Premium Clear 420

Hardener HS Hardener 420

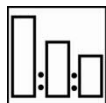
Thinner Reducer Clear 420
Accelerator

Chemical Basis	2K HS Premium Clear 420 HS Hardener 420	Acrylic resins Polyisocyanate resins
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METHOD OF USE

Substrates Sanded OE Finishes
Basecoat WB GT

Mixing ratio



5 2K HS Premium Clear 420
3 HS Hardener 420
1 Reducer Clear 420 / Accelerator

Mixing stick P


Spraying viscosity 15 -17 sec. DIN Cup 4 at 20°C

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Potlife	Accelerator	30 minutes at 20°C		
	Reducer Clear 420	45 – 60 minutes at 20°C		
Spray gun set up 	Sanding			
	Spray gun:	Fluid opening:	Spraying pressure:	
	HVLP Gravity	1.2-1.4 mm	0.7 bar (at air cap)	
	LVLP/HR Gravity	1.2-1.4 mm	1.7-2.2 bar (at air inlet)	
		Refer to user manual spray gun used		

APPLICATION TECHNIQUE

Application



Apply a first light closed coat.
After 0-5 minutes flash off apply a flowing second coat.
Allow 3-5 minutes flash off before bake.

Note: Spraying without additional flash off is possible in case of larger repairs

Layer thickness 45 – 60 microns

Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



		20°C	50°C	60°C
Accelerator	Dust dry	30 min	10 min	5 min
	Dry to handle	3 hrs	20 min	15 min
Reducer Clear 420	Dust dry	1.5 hrs	20 min	15 min
	Dry to handle	4 hrs	30 min	25 min

Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60°C object temperature, followed by a cool down of the object to ambient temperature.

Material usage Ready for use mixture at 1 µm layer thickness : 519 m²/liter

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

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Product storage	Avoid extreme temperature fluctuation and high humidity levels
Shelf life	2 years at 20°C
VOC	2004/42/IIIB(d)(420)420 The EU limit value for this product (product category : IIB.d) in ready to use form is max. 420 g/l VOC. The VOC content of this product in ready to use form is max. 420 g/litre.

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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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