

2K Ultra Air Clear







Clearcoats

27/03/2023

L1.05.29 UK & Ireland

DESCRIPTION

Two-pack, VOC compliant, ambient drying clearcoat showing excellent properties like an oven cured clearcoat. 2K Ultra Air Clear offers optimum application properties and easy blending. Fast ambient drying at a wide range of temperature or 5 min at 60°C, outstanding polishability.

Mixing ratio		100 100	2K Ultra Air Clear 2K Ultra Air Clear Hardener (Fast / Standard)		
Equipment		Spray gun set up: 1.2-1.3mm	Application pressure: 2.0-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap		
Application		2 x 1 coat	One-stop application ½ + 1 coat		
Flash-off		Between coats 0-3 minutes at 20°C	Before curing 0-3 minutes at 20°C		
Drying		Hardener Standard Hardener Fast	20°C 40-60 min 35-55 min	40°C 30-55 min X	60°C 5 min 5 min
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 Ultra Air Clear

Hardener 2K Ultra Air Clear Hardener Fast / Standard

Chemical Basis	2K Ultra Air Clear	Polyaspartic resins
	2K Ultra Air Clear Hardener Fast / Standard	Poly-isocyanate resins

METHOD OF USE

Substrates Basecoat WB GT + 5% Hardener WB* (+5-10% Activator WB**)
 *Addition of Hardener is mandatory
 (In case of three stage colors / precoat it is mandatory to add the advised amount of hardener to each of the coats.)

Note: If a pre-coat as described below is applied before applying the Basecoat WB GT it is not mandatory to add the 5% Hardener WB in the Basecoat WB GT colour

Pre-coat MM02/ MM04 (60:40) + 5% Hardener WB** (+5-10% Activator WB**)

** As with all mixed Basecoat WB GT formula's a larger amount of Activator WB can be added for application at high temperatures and/or at low humidity (please refer to the TDS of Basecoat WB GT (L1.09.02)

Mixing ratio



14-20°C

100	2K Ultra Air Clear
100	2K Ultra Air Hardener Fast

20-30°C

100	2K Ultra Air Clear
100	2K Ultra Air Hardener Fast / Standard

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Spraying viscosity 12-16 sec DIN Cup 4 at 20°C

Potlife 2K Ultra Air Clear + Hardener Fast : 45 minutes at 20°C
2K Ultra Air Clear + Hardener Std : 35 minutes at 20°C

Spray gun set up



Spray gun:
Gravity feed

Fluid opening:
1.2-1.3 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Apply two single coats, allowing to flash off for 0 to 3 minutes between coats or:

One-stop application: ½ + 1 coat
Apply a light closed coat followed by a full coat without any flash off time.

Layer thickness 45 – 60 microns

Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



		20°C	40°C	60°C
2K Ultra Air Clear 2K Ultra Air Clear Hardener Standard	Dust dry	20-30 min	15-35 min	x
	Dry to handle	40-60 min	30-55 min	5 min
2K Ultra Air Clear 2K Ultra Air Clear Hardener Fast	Dust dry	15-25 min	x	x
	Dry to handle	35-55 min	x	5 min



Allow 5 minutes flash off prior to infra-red curing
The panel temperature should not exceed 100°C
For additional information, see TDS L9.01.01

Note that next to temperature, drying speed is dependent on the humidity levels.
In general drying will be faster at a higher humidity level.

Increasing temperatures might lower the humidity and deter drying speed. Drying at humidity levels under 30% should be avoided as TDS drying times cannot be guaranteed.

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Material usage	Ready for use mixture at 1 µm layer thickness :	494 m²/liter
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The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

Polishability



Dust and minor damage can be polished out 15 minutes after the indicated-drying times.

Note: For an optimal result, polish within 3 hours after curing

Recoatability	Recoatable with itself within 48 hours, after 48 hours sanding is mandatory
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Product storage	Avoid extreme temperature fluctuation and high humidity levels
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Shelf life	Product shelflife : 1 year at 20°C After opening the can, product shelflife is limited to 1 month at 20°C
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VOC	2004/42/IIB(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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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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