



PROFESSIONAL QUALITY

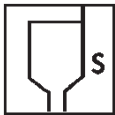
Automotive Clearcoat



2K HF CLEARCOAT



2:1



Visc.
15-18 Secs



Description:

Two-pack clearcoat formulated for the **METALUX 2** basecoat system. It has been designed as both a touch up and respray clearcoat, where "invisible" repairs to the OEM factory finish is desired.

Products and Additives:

METALUX 2 2K HF Clearcoat, 8751
METALUX 2 2K Hardener Fast, 8750 / Medium, 8767 / Slow, 9072 / Express, 9335
METALUX 2 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784
METALUX 2 Soft Flex Additive, 8795

Basic Raw Materials:

METALUX 2 2K HF Clearcoat: acrylic resin
METALUX 2 2K Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K HF Clearcoat has been designed to be applied over **METALUX 2** Basecoats.

Mixing Ratio:

100 parts by volume of **METALUX 2** 2K HF Clearcoat
50 parts by volume **METALUX 2** 2K Hardener of your choice
Thin 10-20% with **METALUX 2** 2K Thinner to 15-18 secs Ford 4 @ 25°C
- **METALUX 2** Accelerator. Add 2% to 5%. Next add hardener and thinner as specified
- Plastic Parts Softflex Additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic). Next add hardener and thinner as specified.

Pot Life:

When mixed 4 hours @ 25°C

Process:

Apply three single wet coats with 5-10 minutes flash off between coats.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	3 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	3 - 4 bar

Film Build:

20 - 25 micron per coats for HF Clear.

Cleaning of Equipment:

Use lacquer thinners

Drying Time:

Dust free	30 min @ 25°C
Hard Dry	24 hours @ 25°C
Recoatable	after full cure (± 7 days @ 25°C)
Force dry	45 min @ 60°C metal

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.