

2K HS Fast Clear 420

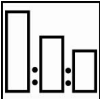



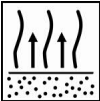


Clearcoats

28/02/2020

L1.05.09 UK & Ireland

DESCRIPTION

A complete 2 component clear system for use on all types of repairs, in most application conditions. It gives high quality results with a brilliant gloss level at an economical price. Two coat application maximizes paint shop efficiency.

| | | | | |
|--------------|---|--|--|----------------------------------|
| Mixing ratio |  | 5 3 1 | 2K HS Fast 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 2 hrs 45 min 3 hours | 60°C 15 minutes 20 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 Fast Clear 420

Hardener HS Hardener 420

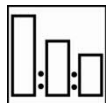
Thinner Reducer Clear 420
Accelerator

Chemical Basis 2K HS Fast Clear 420 HS Hardener 420 Acrylic resins Polyisocyanate resins

METHOD OF USE

Substrates Sanded OE Finishes
Basecoat WB GT

Mixing ratio



5 2K HS Fast 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 | 30 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 | 25 min | 10 min | 5 min |
| | Dry to handle | 2 hrs 45 min | 20 min | 15 min |
| Reducer Clear 420 | Dust dry | 1 hr | 15 min | 10 min |
| | Dry to handle | 3 hrs | 25 min | 20 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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