Technical Data Sheet

PREMIUM FLOW CLEARCOAT

Acrylic urethane VHS clearcoat

PROPERTIES

- A product developed and dedicated to classic car restoration
- Crystal gloss and depth
- High final hardness
- Long pot life for coating whole car bodies
- Very high UV resistance
- Very high solids content

RELATED PRODUCTS

CLEARCOAT HARDENER	Hardener for acrylic and acrylic urethane clearcoats
THINNER	Thinner for acrylic and polyurethane products

DESCRIPTION

The highest quality VHS class acrylic-urethane clearcoat, with a very high gloss and hardness, designed for refinishing of classic motor vehicles. PREMIUM FLOW CLEARCOAT is a clearcoat with enhanced flowability for the maximum durability of colour and high gloss in two-layer applications. The long pot life facilitates easy coating of whole car bodies, even in spray booths where the ambient air flow is limited. It is excellent for multiple recoating, coloured SPECTRAL 2K (acrylic) + clearcoat PREMIUM-level coating, complete with sanding and wet on wet applications.

SUBSTRATES	
Base layers SPECTRAL BASE 2.0	Add 10% of CLEARCOAT HARDENER per volume to the BASE 2.0 pigment mixture. Mix the pigments thoroughly with the hardener and then dilute with SOLV 885, as per the specified mixing ratio. The mixture of the pigments, the hardener and the thinner must be prepared directly before the basecoat application. Apply on a thoroughly dry, dust-free basecoat surface. For removal of dust from the base colour surfaces, tack rags are recommended. Lightly sand with P800 or P1000 grit paper, if required. P800 ÷ P1000.
Base layers SPECTRAL WAVE 2.0	Apply on a thoroughly dry, dust-free basecoat surface. For removal of dust from the base colour surfaces, tack rags are recommended. Lightly sand with P800 or P1000 grit paper, if required. P800 ÷ P1000.
SPECTRAL 2K Coating PREMIUM (*)	*Option 1:* Cure the SPECTRAL 2K topcoat well (for 14 h/20°C or 45 min/60°C) and sand with P800 ÷ P1000 paper. Thoroughly blow off all dust and degrease with the SILICONE REMOVER. *Option 2:* Dust-free surface to be achieved in a minimum of 45 min/20°C after application of the last layer of SPECTRAL 2K.
PREMIUM FLOW CLEARCOAT Coating PREMIUM (*)	*Option 1:* Cure the PREMIUM FLOW CLEARCOAT well (for a minimum of 12 h/20°C or 30 min/60°C) and sand with P800 ÷ P1000 paper. Thoroughly blow off all dust and degrease with the SILICONE REMOVER. *Option 2:* Dust-free surface to be achieved in a minimum of 45 min/20°C after application of the last layer of the PREMIUM FLOW CLEARCOAT.
(*) See the PREMIUM-level coating specification in a separate reference	
The PREMIUM FLOW CLEARCOAT is compatible with most commercial thinner and water-borne basecoats.	

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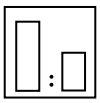
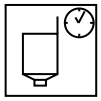
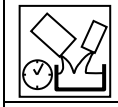
MIXING RATIO			
		Volume ratio	Weight ratio [g]
	PREMIUM FLOW CLEARCOAT	3	100
	CLEARCOAT HARDENER	1	35
To achieve a coating with the appropriate parameters, it is very important to precisely measure the components.			

SPRAY VISCOSITY		
	DIN 4/20°C	17 ÷ 19 s

APPLICATION CONDITIONS
It is recommended to apply the clearcoat at a temperature above 15°C and a humidity of no more than 80%.

APPLICATION		
 Follow the recommendations from the spray gun manufacturer.	Spray nozzle	Spray tool input pressure
	1.2 ÷ 1.4 mm	1.7 ÷ 2.2 bar
 The actual yield depends on the surface shape, roughness and application parameters.	Number of layers	2
	Single full dry layer thickness	30 ÷ 35 µm
	Ready for use mixture yield for 50 µm thick dry film.	10.6 m^2/l
	Mixture life at 20°C	45 min
	Flash-off time between layers	15 ÷ 20 min
	Flash-off after the last layer	30 min. minimum
	Use of proper PPE is recommended!	

CURING TIMES		
Temperature	20°C	60°C
Dust-free	40 min	N/A
Tack-free	4 h	10 min
Handling hardness	12 h	30 min
Polishable hardness	12 h + 48 h	30 min + 36 h/20°C
Total hardness	7 ÷10 days	30 min + 3 ÷ 5 days/20°C
The curing time is specified for the body workpiece temperature and not the air temperature! The curing times apply to a 40 ÷ 60 µm thick total dry coat.		

IR DRYING	
	30 min In 2 layers.
A short-wave IR lamp is recommended. Follow the recommendations of the equipment manufacturer. The bottom layers must be completely cured. Use the radiator no sooner than 40 min. after applying the last layer.	

VOC CONTENT	
VOC II/B/d limit* Actual VOC	420 g/l 418 g/l
* For a ready for use mixture acc. to EU Directive 2004/42/CE.	

EQUIPMENT CLEANING
THINNER acrylic and polyurethane thinner or NC solvent.

STORAGE CONDITIONS
Make sure that all coat component containers are sealed tight. Store in a dry and cool room, away from sources of fire and heat.

SHELF LIFE	
PREMIUM FLOW CLEARCOAT	24 months/20°C
CLEARCOAT HARDENER	18 months/20°C

SAFETY
See the Safety Data Sheet.
OTHER INFORMATION
The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained here meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials. We cannot be held liable for defects if the final results are affected by factors beyond our control. This TDS supersedes all its previous issues. Registration number: 000024104

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RFU	PREMIUM FLOW CLEARCOAT	CLEARCOAT HARDENER
0.10 L	73 g	26 g
0.15 L	110 g	39 g
0.20 L	147 g	52 g
0.25 L	183 g	65 g
0.30 L	220 g	78 g
0.40 L	293 g	104 g
0.50 L	366 g	130 g
0.75 L	550 g	195 g
1.00 L	733 g	260 g
2.00 L	1466 g	520 g