

CLEAR COAT ULTRA FAST PRO45112



V.1-03.2024

CHARACTERISTICS

Ultra-fast, VOC compliant 2-pack acrylic clear coat of next generation, enriched with biobased components. Ideal for both, spot repairs and for painting the entire side of the vehicle. It offers an excellent levelling, quick flash-off time and extreme drying, only 90 minutes at 20°C or 15 minutes at 40°C. Designed for use on solvent- and waterborne basecoats. Product features:

- easy and quick application,
- very good levelling,
- high throughput,
- extremely fast drying for polishing – 90 minutes at 20°C.

APPLICATION

Measure out the A+B mixture by volume: 2 parts of clear coat (A) and 1 part of hardener (B), then mix thoroughly. Apply with a spray gun with a nozzle diameter of 1.3 mm in 1.5 coats (½ thin closed coat and 1 full wet coat) with a 5-6 minute break for the solvents to evaporate before applying another coat.

TECHNICAL DATA

VOC 2004/42/IIIB(d)(420) max. 420 g/l

CLEAR COAT VOC/V CLB-03.089

Shelf life: 12 months Density (20°C): 0.98 – 1.0 g/cm³ Colour: colourless / slightly yellow

HARDENER CLEAR COAT VOC/V CDL-04.100

Shelf life: 12 months Density (20°C): 1.01 – 1.03 g/cm³ Colour: colourless / slightly yellow

MIXING RATIO									
		by volume	by weight						
	Clear coat (A)	2	100						
	Hardener (B)	1	51						
SPRAYING VISCOSITY									
	DIN / FORD / ISO cup 4 mm at 20°C	15 - 17 s / 16 - 18 s / 30 - 32 s							
APPLICATION									
	Gravity feed spray gun	nozzle	1.3 mm						
		pressure	according to spray gun manufacturer's recommendations						
	Application	number of layers	1.5						
		film thickness wet / dry	90 - 100 µm / 50 - 60 µm						
		flash-off time between coats	5 - 6 min						
		flash-off time before baking	10 min						
		note	<table border="1"> <tr> <td>1</td> <td>~65 µm</td> <td></td> <td></td> </tr> <tr> <td>0.5</td> <td>~30 µm</td> <td></td> <td></td> </tr> </table> <p>Apply ½ thin closed coat and 1 full wet coat layers with recommended total wet thickness ~100 µm. Excessive thickness layers may cause runs, longer</p>	1	~65 µm			0.5	~30 µm
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0.5	~30 µm								

Billakkspecialisten AS

Hovedkontor: Per Kroghs vei 4A, 1065 Oslo - Tlf. 22 69 38 80 - www.billakkspecialisten.no

Avdelinger: Bergen, Bodø, Hamar, Stavanger, Tromsø, Trondheim

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		evaporation and drying times, lower hardness, or other paint defects.
Recommended process conditions	temperature 18 - 22°C, relative air humidity 40 - 60%	
Theoretical efficiency	10 - 12 m ² /l	
Pot life at 20°C	50 min	

DRYING TIMES					
	Object temperature	20°C	40°C	50°C	60°C
	Dry to touch	45 min	5 min	5 min	4 min
	Dry to polish	90 min	15 min	10 min	5 min
	Full hardness	4 days	15 min + 4 days/20°C	10 min + 4 days/20°C	5 min + 4 days/20°C
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 30 minutes for cooling down.					
	IR drying	8 - 12 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.			

REMARKS

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product at a temperature below 18°C. Low application temperature changes the characteristics of the coating finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

STORAGE AND TRANSPORTATION CONDITIONS

Protect from freeze, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage temperature: +10 to +30°C.

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