

CLEAR COAT HIGH GLOSS PRO45113



v.3-05.2025

CHARACTERISTICS

Two-component, very high solid clear coat. It provides an easy and comfortable application, good levelling, brilliant gloss and fast drying properties. It can be easily polished only after 15 minutes at 60°C or 2.5-3 hours at 20°C. Ideal for different kind of applications: spot repairs, single panel repairs and for full car body respray. Can be applied over solvent- and waterborne base coats. Product features:

- fast drying,
- suitable for spot, panel and overall repairs,
- very high final hardness after curing at both, room and elevated temperature,
- high gloss and perfect levelling,
- the best in class quality and price ratio.

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 2 or 1.5 coats with a 4 - 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 CLB-03.079

Shelf life: 12 months

Density (20°C): 0.99 – 1.0 g/cm³

Colour: colourless/slightly yellow

HARDENER STANDARD CDL-04.088

Shelf life: 12 months

Density (20°C): 1.02 – 1.03 g/cm³

Colour: colourless/slightly yellow

HARDENER SLOW CDL-04.102

Shelf life: 12 months

Density (20°C): 1.05 – 1.07 g/cm³

Colour: colourless/slightly yellow

MIXING RATIO

		by volume	by weight
	Clear coat (A)	2	100
	Hardener (B)	1	51.4 g standard CDL-04.088 53.0 slow CDL-04.102

SPRAYING VISCOSITY

	DIN cup 4 mm at 20°C	16 - 18 s
	Ford cup 4 mm at 20°C	18 - 20 s
	ISO cup 4 mm at 20°C	36 - 38 s

APPLICATION

		nozzle	pressure		
	Gravity feed spray gun	1.3 mm	operating pressure according to spray gun manufacturer's recommendations		
	Application	number of layers	flash-off time		dry film thickness
			between coats	before baking	
		1.5 - 2	4 - 6 min	10 min	50 - 60 µm
Recommended process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical efficiency		10 - 12 m ² /l			
Pot life at 20°C		90 min			

Billakkspesialisten AS

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

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

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DRYING TIMES							
	Object temperature Hardener type	20°C			60°C		
		Dry to touch	Dry to polish	Full hardness	Dry to touch	Dry to polish	Full hardness
	STANDARD CDL-04.088	1.5h	2.5 - 3h	5 days	10 min	15 min	15 min + 5 days/20°C
	SLOW CDL-04.102	2h	3 - 4h	5 days	15 min	20 min	20 min + 5 days/20°C
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1h for cooling down							
	IR drying	8 - 15 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 in 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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