



Premium VOC 2K Clear Coat

CHARACTERISTIC

High solid UHS clear. Good flow and thixotropic properties. UV resistant. Suitable for applications in spray booths. Clear coat was designed for use on solvent- and waterborne base coat.


APPLICATION

Mixing ratio: 2:1 by volume. Mix thoroughly. Apply with a spray gun with nozzle diameter 1,2 mm in 2 normal coats with 7 - 10 min. flash off between the coats. Additional thinner is not required to use for this products. However, the system may be adjusted with up to 10 % vol. the component A, of out hinder without having negative influences on the desired results.

NOTE

Drying at the ambient temperature extends a curing time.

RELATED PRODUCTS

XC3016/1	Premium VOC 2K Clear Coat	
XC3016/5	Premium VOC 2K Clear Coat	
XCH3028/0.5, 2.5	Standard UHS hardener	
XCH3042/0.5, 2.5	Fast UHS hardener	
	UHS Hardener VERY FAST, SLOW, VERY SLOW	
XM0002/1	Acryl thinner	
XM0002/5	Acryl thinner	
XM0004/1	Accelerator Additive	
XM0024/1	Gloss Additive	

**SURFACE PREPARATION**

Before applying the clearcoat clean surface with antistatic sticky cloth

MIXING RATIO

	Clear coat XC3016 Hardener XCH3028 Thinner XM0002 or Gloss Additive XM0024	by volume	by weight
		2 1 0 - 10% vol. on component A 5 - 8% vol. on component A	100 51-52 0 - 9% wt. on component A 4,4 - 7% wt. on component A

SPRAY VISCOSITY

	DIN cup 4mm at 20°C	18 - 22 s
	Ford cup 4mm at 20°C	19 - 23 s
	ISO cup 4mm at 20°C	42 - 50 s


SPRAYGUN SETTING

	Spray gun gravity feed	nozzle	pressure
		1,2 mm	as recommended by the manufacturer of the spray gun

APPLICATION

	Application process	coats number 2	flash off time		dry film thickness 50 - 60 μm
			between coats 7 - 10 min	before baking 10 min	
Process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical efficiency		11 - 12 m ² /l			
Pot life at 20°C		- 40 min. Standard hardener XCH3028 - 40 min. Fast hardener XCH3042			



DRYING TIMES				
		20°C		60°C
	Dry	Standard hardener	9-10 hours	30 min
		Fast Hardener	6-8 hours	20 min
	Full hardness	7 days		
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down				
IR drying		8 – 15 min. Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.		
OVERSPRAYING				
Recoated after sanding a mild abrasive P1500.				
TECHNICAL DATA				
Product	Packing	Density (20°C)	Colour	Shelf-life
Clear coat XC3016	1L, 5L	0,98-0,99 g/cm ³	colourless	18 months
Hardener XCH3028	0.5L 2.5L	1,00-1,05 g/cm ³	colourless	12 months
Hardener XCH3042	0.5L 2.5L	1,00-1,05 g/cm ³	colourless	12 months
Thinner XM0002	1L, 5L	0.80 – 0.90 g/cm ³	colourless	24 months
Gloss Additive XM0024	1L	0.85 – 0.87 g/cm ³	colourless	24 months



MIXING RATIO BY WEIGHT				
The required volume of the mixture, ready to use	Weight for weight in grams	Density	The cumulative weight in grams	Density
	XC3016	980 g/l	XCH3028	1025 g/l
0,1l	65,33 g		99,50 g	
0,2l	130,67 g		199,00 g	
0,3l	196,00 g		298,50 g	
0,4l	261,33 g		398,00 g	
0,5l	326,67 g		497,50 g	
0,6l	392,00 g		597,00 g	
0,75l	490,00 g		746,25 g	
0,9l	588,00 g		895,50 g	
1l	653,33 g		995,00 g	
1,5l	980,00 g		1492,50 g	
2l	1306,67 g		1990,00 g	
2,5l	1633,33 g		2487,50 g	

VOC INFORMATION

VOC limit 2004/42/IIIB(d): 420 g/l
 VOC content (in a ready-to-use product): <420 g/l

HEALTH AND SAFETY

Trixxal products are intended only for professional use. They may not be used for any purpose other than that for which they are intended.

When using them, follow the appropriate personal protective equipment, especially respiratory protection, eye and skin protection.

The information referred in data list are based on chemical research and it is on users to use this product in an appropriate manner.

Information on the composition, health and safety, see the Safety Data Sheet, which is available at www.trixxal.com

**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 coating's properties and may impair the visual effect. 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 freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage and transportation is: +10 to +30°C. Avoid extreme temperature fluctuation.

Note: The storage and transportation temperature must be not lower than +5°C. Acclimatize the product to room temperature naturally.

PRODUCER

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