



## HS Anti Scratch 2K Clear Coat

### CHARACTERISTIC

High solid clear coat, characterized by high scratch resistant, good flow, UV resistant (non-yellowing). High hardness, good chemical, mechanical and weathering resistance. Suitable for applications in spray booths and areas adapted for painting. 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 a nozzle diameter of 1.3 mm in 2 normal coats with a 5-7-minute break for the solvents to evaporate before applying another coat. To improve gloss properties, it is recommended to use Gloss Additive of up to 7% vol. on component A.

### NOTE

Drying at the ambient temperature extends a curing time.

### RELATED PRODUCTS





XC5014/1	HS Anti Scratch 2K Clear Coat	
XC5014/5	HS Anti Scratch 2K Clear Coat	
XCH5019/0.5, 2.5	Standard HS hardener	
XCH5032/0.5, 2.5	Fast HS hardener	
	Hardener VERY FAST, SLOW, VERY SLOW	
XM0024/1	Gloss Additive	
XM0004/1	Accelerator Additive	

### SURFACE PREPARATION




Before applying the clearcoat clean surface with antistatic sticky cloth



MIXING RATIO					
	Clear coat XC5014 Hardener XCH5019 Gloss Additive XM0024	by volume		by weight	
		2		100	
		1		50	
		0 - 7% vol. on component A		0 - 6.1% wt. on component A	
SPRAY VISCOSITY					
	DIN cup 4mm at 20°C Ford cup 4mm at 20°C ISO cup 4mm at 20°C	16 - 18 s 17 - 19 s 31 - 36 s			
SPRAYGUN SETTING					
	Spray gun gravity feed	nozzle		pressure	
		1,3 mm		As recommended by the manufacturer of the spray gun	
APPLICATION					
	Application process	coats number	flash off time		dry film thickness
			between coats	before baking	
		2	5 - 7 min	10 min	45 - 50 µm
Process conditions		temperature 18 - 22°C, relative air humidity 40 - 60%			
Theoretical efficiency		9 – 10 m²/l			
Pot life at 20°C		2 hours			



DRYING TIMES				
		20°C		60°C
	Dry to touch	Standard hardener	6-7 hours	30 min
		Fast Hardener	4-5 hours	20 min
	Dry to polish	Standard hardener	10-11 hours	
		Fast Hardener	8-9 hours	
	Full hardness	Standard hardener	5-7 days	
		Fast Hardener	5-7 days	
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down				
IR drying		10 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 XC5014	1L, 5L	0,97-0,99 g/cm³	Colourless	18 months
Hardener XCH5019	0.5L 2.5L	0,97-0,99 g/cm³	Colourless	12 months
Hardener XCH5032	0.5L 2.5L	0,97-0,99 g/cm³	Colourless	12 months
Gloss Additive XM0024	1L	0.85 – 0.87 g/cm³	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
	<b>XC5014</b>	980 g/l	<b>XCH5019</b>	980 g/l
0,1l	65,33 g		98,00	
0,2l	130,67 g		196,00 g	
0,3l	196,00 g		294,00 g	
0,4l	261,33 g		392,00 g	
0,5l	326,67 g		490,00 g	
0,6l	392,00 g		588,00 g	
0,75l	490,00 g		735,00 g	
0,9l	588,00 g		882,00 g	
1l	653,33 g		980,00 g	
1,5l	980,00 g		1470,00 g	
2l	1306,67 g		1960,00 g	
2,5l	1633,33 g		2450,00 g	

**VOC INFORMATION**

VOC limit: 2004/42/IIB(e): 840 g/l

VOC content (in a ready-to-use product): <840 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](http://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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