



Hi-Tech VOC 2K Clear Coat

CHARACTERISTIC

Very fast curing 2-pack acrylic clear coat characterized by rapid early hardness. It is ready for polishing only after 15 minutes of forced drying at 60°C and cooling down. Very good flow and levelling properties. High gloss and final hardness. Outstanding durability due to chemical, UV and weather resistance. Well balanced pot life enables safe application. Designed for use on solvent- and waterborne base coats. Very high solids and VOC conform product.

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 5-7-minute break for the solvents to evaporate before applying another coat.

RELATED PRODUCTS

XC1049/1	Hi-Tech VOC 2K Clear Coat	
XCH1058/0.5	Hardener for Hi-Tech VOC 2K Clear Coat	
XC1049/5	Hi-Tech VOC 2K Clear Coat	
XM0024/1	Gloss Additive	

SURFACE PREPARATION





Before applying the clearcoat clean surface with antistatic sticky cloth


MIXING RATIO


	Clear coat XC1049 Hardener XCH1058	by volume	by weight
		2 1	100 50



SPRAY VISCOSITY		
	DIN cup 4mm at 20°C	16 - 18 seconds
	Ford cup 4mm at 20°C	17 - 19 seconds
	ISO cup 4mm at 20°C	34 - 39 seconds

SPRAYGUN SETTING			
	Spray gun gravity feed	nozzle	pressure
		1,3 mm	operating pressure as recommended by the spray gun manufacturer

APPLICATION					
	Application process	coats number	flash off time		dry film thickness
			between coats	before baking	
		1,5 (½ thin closed coat + 1 full wet coat)	5 - 7 min.	10 min.	50-60 µm
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	60°C
	Dry to touch	1 - 1,5 h	10 min.
	Dry to polish	3,5 - 4 h	15 min.
	Full hardness	4 days	15 min + 3 days/20°C

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.
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OVERSPRAYING
Recoated after sanding a mild abrasive P1500.



TECHNICAL DATA				
Product	Packing	Density (20°C)	Colour	Shelf-life
Clear coat XC1049	1L	1,00 g/cm ³	colourless	12 months
Hardener XCH1058	0.5L	1,00 g/cm ³	colourless	12 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
	XC1049	1000 g/l	XCH1058	1000 g/l
0,1l	66,67 g		100,00 g	
0,2l	133,33 g		200,00 g	
0,3l	200,00 g		300,00 g	
0,4l	266,67 g		400,00 g	
0,5l	333,33 g		500,00 g	
0,6l	400,00 g		600,00 g	
0,75l	500,00 g		750,00 g	
0,9l	600,00 g		900,00 g	
1l	666,67 g		1000,00 g	
1,5l	1000,00 g		1500,00 g	
2l	1333,33 g		2000,00 g	
2,5l	1666,67 g		2500,00 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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