

Technical Data Sheet

Date: 01-October-2025
Product Code: FL2020

ULTIMATE 2K HS CLEARCOAT

ULTIMATE 2K HS Clearcoat is a high solids, compliant clear specially formulated to allow easy application, good vertical holdup while also giving good flow properties.

ULTIMATE 2K HS Clearcoat is an express clear and when cured, gives good depth of gloss to the final finish.

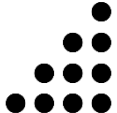
Preparation

Surfaces must be clean, dry and free from dust, grease, oil or millscale etc. Carry out test spray before application.

Can be applied to solvent and waterborne basecoats.

Application

	Health and safety “For professional use only” Important: When using any new product, consult the “Health and Safety” data sheet. Always read the risks and precautions stated on the product label.	
	Mix Ratio 2 : 1 + 5% 2 part FL2020 ULTIMATE 2K HS Clearcoat, 1 part FL2050 ULTIMATE 2K HS Hardener, and 5% FL2021/2 Final Systems 2K Thinner	
	Spray Viscosity 14 – 16 seconds DIN4 at 20°C 18 - 20 seconds BS 4 at 20°C	Spray Pressure 30 – 35 PSI (2 – 2.5 bar)

	Spray Gun Fluid Tip HVLP Gravity feed fluid tip 1.2 – 1.5 HTE/RP Spray gun fluid tip 1.2 – 1.3																
	Film Thickness 40 – 50 microns																
	No. of coats 2 First Coat: ½ coat closed Second Coat: full coat Pot Life Approx. 2 ½ hours at 20°C depending on hardener speed																
	Drying Times at 20°C Flash Off (Between Coats) Flash Off (Before Baking) Dust Free Tack Free Hard Dry	30 seconds to 2 minutes 5 minutes 10 minutes 1 hour 3 ½ hours <table border="1" data-bbox="408 1106 1378 1417"> <thead> <tr> <th>Hardener</th><th>Bake Time (60°C)</th><th>IR Drying Time</th></tr> </thead> <tbody> <tr> <td>Standard</td><td>20 minutes</td><td>15 minutes</td></tr> <tr> <td>Fast</td><td>15 minutes</td><td>10 minutes</td></tr> <tr> <td>Extra Fast</td><td>9 minutes</td><td>7 minutes</td></tr> <tr> <td>Super Rapid</td><td>6 minutes</td><td>4 minutes</td></tr> </tbody> </table> Gloss level will vary depending on speed used. For best results Fast hardener will give good dry time and gloss level. Bear in mind, booth temperature and the time taken to get to temperature.	Hardener	Bake Time (60°C)	IR Drying Time	Standard	20 minutes	15 minutes	Fast	15 minutes	10 minutes	Extra Fast	9 minutes	7 minutes	Super Rapid	6 minutes	4 minutes
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Technical Information

36 month shelf life when correctly stored in closed original container. Always replace and firmly close lid immediately after use.

Flash Point	31°C
Composition	Acrylic Resins
Colour	Water White
VOC (EC)	51.2% (weight)
Vapour Pressure at 20°C	5.4 mmHg
Vapour Density at 20°C	3.9



Final Systems is a
trade name of FLP

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Refer to relevant Health & Safety or Material Safety Data Sheets.

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