

TECHNICAL DATA SHEET







ULTIMATE 2K HS Scratch Resistant Clearcoat

Date: 08-Feb-2023

DESCRIPTION

ULTIMATE 2K HS CLEARCOAT is an compliant clear – it is a high solids clearcoat specially formulated to allow easy application, good vertical hold up while also giving good flow properties. The clearcoat when cured, gives good depth of gloss to the final finish. **ULTIMATE 2K HS CLEARCOAT** is an express clear.

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| Composition: | Acrylic Resins |
| Colour: | Water white |
| Shelf life: | 36 months in unopened container |
| Pack size: | 1 Litre/5 Litre |
| Pre-treatment: | FL2020 ULTIMATE 2K HS CLEARCOAT can be applied to solvent and waterborne basecoats. |

|  | 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. | | | | | | | | | | | | | | | | | |
|---|---|---|--|----------|-------------------|----------------|----------|------------|------------|------|------------|------------|------------|-----------|-----------|-------------|-----------|-----------|
|  | Mixing Ratio 2 : 1 5% | | | | | | | | | | | | | | | | | |
| | 2 FL2020 ULTIMATE 2K HS CLEARCOAT | 1 FL2050 ULTIMATE 2K HS HARDENER | 5% FL2021/2 Final Systems 2K Thinners | | | | | | | | | | | | | | | |
|  | Spraying Viscosity 18 to 20 seconds BS 4 cup at 20°C – 14 to 16 seconds DIN4 cup 20°C Pot life – 2 ½ hours at 20°C dependent on speed | | | | | | | | | | | | | | | | | |
|  | HTE/RP spray gun fluid tip 1.2 – 1.3 HVLP gravity feed fluid tip 1.2 – 1.5 Recommended Spray Pressure 2 – 2.5 bar | | | | | | | | | | | | | | | | | |
|  | Number of coats 2 First coat: ½ coat closed Second coat: full coat At 20°C 3 to 5 minutes flash off between coats – 5 minutes flash off before bake or IR curing. Film thickness 40 – 50 micron. | | | | | | | | | | | | | | | | | |
|  | Air Dry at 20°C dust free 10 minutes, tack free 1 hour, hard dry 3½ hours (fast) <table><tr><th>Hardener</th><th>Bake Time (60 °C)</th><th>IR Drying Time</th></tr><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></table> <p>Gloss will vary depending on speed used. For best results fast hardener will give good dry time and gloss level. Bare in mind booth temperature and the time taken to get to temperature.</p> | | | 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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