

TECHNICAL DATA SHEET







ULTIMATE 2K HS DTM Clearcoat

Date: 22-May-2024

DESCRIPTION

ULTIMATE 2K HS DTM CLEARCOAT is a 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 Direct To Metal (DTM) clearcoat when cured, gives good depth of gloss to the final finish.

- Composition:** Acrylic Resins
Colour: Water white
Shelf life: 36 months in unopened container
Pack size: 1 Litre/5 Litre
Pre-treatment: FL8050 **ULTIMATE 2K HS DTM CLEARCOAT** can be applied direct to metal.

	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 10% 2 FL8050 ULTIMATE DTM 2K HS CLEARCOAT	1 FL2050 ULTIMATE 2K HS HARDENER	10% 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 border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr style="background-color: #333; color: white;"> <th style="width: 33%;">Hardener</th> <th style="width: 33%;">Bake Time (60 °C)</th> <th style="width: 33%;">IR Drying Time</th> </tr> </thead> <tbody> <tr> <td>STANDARD</td> <td style="text-align: center;">30 minutes</td> <td style="text-align: center;">16 minutes</td> </tr> <tr> <td>FAST</td> <td style="text-align: center;">20 minutes</td> <td style="text-align: center;">12 minutes</td> </tr> </tbody> </table>			Hardener	Bake Time (60 °C)	IR Drying Time	STANDARD	30 minutes	16 minutes	FAST	20 minutes	12 minutes	
Hardener	Bake Time (60 °C)	IR Drying Time										
STANDARD	30 minutes	16 minutes										
FAST	20 minutes	12 minutes										
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. Times may vary based on the environment. Accelerators should not be used with DTM products. ULTIMATE 2K HS Super Rapid Hardener or ULTIMATE 2K HS Extra Fast Hardener should not be used under any circumstances with ULTIMATE 2K HS DTM Clearcoat.												

The technical data contained herein is based on our present knowledge and we experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.