

CLEAR COATS



PARAMETERS	122	133	155	177	166	180	189
GENERAL							
Addition of thinner %	10%	-	-	-	0 - 5%	-	-
VOC content	563 g/l	588 g/l	570 g/l	500 g/l	420 g/l	420 g/l	415 g/l
Number of coats	2	1 - 3	1 - 2	1 - 2	1,5	1,5 - 2	1,5 - 2
Thickness per coat	40 - 50 μ m	40 - 50 μ m	40 - 50 μ m	40 - 50 μ m	50 - 60 μ m	40 - 60 μ m	50 - 60 μ m
Spraying viscosity 4 mm DIN	18 - 20 s	15 - 17 s	16 - 18 s	18 - 20 s	19 - 22 s	17 - 19 s	15 - 16 s
Spreading rate	6 - 8 m ² /l	6 - 8 m ² /l	6 - 8 m ² /l	6 - 8 m ² /l	10 - 12 m ² /l	9 - 10 m ² /l	7,5 - 8,5 m ² /l
Application with Gravity Spray gun Pressure/Nozzle	2 - 2,5 bar/ 1,4 mm	2 - 2,5 bar/ 1,2 - 1,4 mm	2 - 2,5 bar/ 1,4 mm	2 - 2,5 bar/ 1,2 - 1,3 mm	2 - 2,5 bar/ 1,2 - 1,3 mm	2 - 2,5 bar/ 1,2-1,3 mm	2 - 2,5 bar/ 1,2 - 1,3 mm
Application with HVLP Pressure/Nozzle	2 - 2,2 bar/ 1,2 - 1,3 mm	2 - 2,2 bar/ 1,2 - 1,4 mm	2 - 2,2 bar/ 1,2 - 1,4 mm	2 - 2,2 bar/ 1,2 - 1,3 mm	2 - 2,2 bar/ 1,2 - 1,3 mm	2 - 2,2 bar/ 1,2 - 1,3 mm	2 - 2,5 bar/ 1,2 - 1,3 mm
DRYING							
Pot life at 20 °C	4 - 6 h	4 - 6 h	4 - 6 h	3 - 4 h	1 - 2,5 hour	1 - 1,5 hour	30 min
Flash-off time between coatings	5 - 10 min	5 - 10 min	5 - 10 min	5 - 10 min	1 - 3 min	3 - 5 min	5 - 10 min
Dust Free	20C: 30 min	20C: 20 - 30 min	20C: 30 min	20C: 25 - 30 min	20C: 25 - 35 min	20C: 15 - 20 min	20C: 10 - 15 min
Set to touch	20C: 12 h 60C: 30 min	20C: 12 h 60C: 20 - 30 min	20C: 6 h 60C: 30 min	20C: 6 - 8 h 60C: 30 min IR Drying: 8 - 15 min	20C: 12 h 60C: 30 min IR Drying: 8 - 15 min	20C: 1 - 2 h 60C: 15 min IR Drying: 8 - 15 min	20C: 35 min IR Drying: 5 min
Ready to assemble	20C: 24 h 60C: 2 h	20C: 24 h 60C: 1-2 h	20C: 24 h 60C: 2 h	20C: 24 h 60C: 1 h	20C: 24 h 60C: 2 h	20C: 6 h 60C: 15 min	20C: 40 min 60C: 10 min

Based on the distinctive features of each clear coat, you can choose the one that suits you in every specific situation