

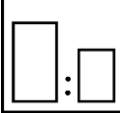
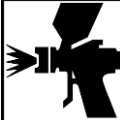

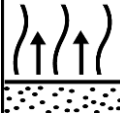
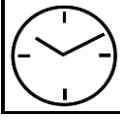

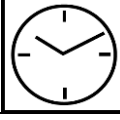


Technical Data Sheet

MS Clear Coat 91 2:1
Art.nbr.: 9110

Clear Coats
Version: **EN-TDS-9110-6**
Revision: April 2015
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APPLICATION SHEET

	<p>2 MS Clear Coat 91 1 MS Hardener 81 Add, if necessary, 0-10% 2K PU Thinner PLUS</p>								
	<p>Spray nozzle: 1.3 – 1.5 mm Pressure: 2.0 – 2.2 bar at the air inlet</p>								
	<p>2 spray coats</p>								
	<p>5 – 10 minutes</p>								
	<table border="0"> <tr> <td>MS Clear Coat 91 2:1</td> <td>60 °C</td> </tr> <tr> <td>MS Hardener 81 STD</td> <td>30 minutes</td> </tr> <tr> <td>MS Hardener 81 Fast</td> <td>15 – 25 minutes</td> </tr> <tr> <td>MS Hardener 81 Slow</td> <td>30 – 40 minutes</td> </tr> </table>	MS Clear Coat 91 2:1	60 °C	MS Hardener 81 STD	30 minutes	MS Hardener 81 Fast	15 – 25 minutes	MS Hardener 81 Slow	30 – 40 minutes
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Application viscosity	Application- and object temperature								
16 – 17 seconds (DIN CUP 4 mm / 20 °C)	15 °C – 30 °C								
	<p>Potlife 4 hours at 20 °C</p>								
	<p>Use suitable respiratory protection</p>								
	<p>For full technical information, please read the complete Technical Data Sheet</p>								

Technical Data Sheet

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FULL TECHNICAL INFORMATION



- Very easy to use Clear, can not go wrong!
- Composed to meet the highest standards with MS
- Excellent clearness
- High durable and economic Clear

FIELD OF APPLICATION

For application as a economic clear coat over KRISTAL AquaGreen WB and other Metallic Basecoat Series. Suitable for passenger cars.

KRISTAL MS Clear Coat 91 2:1, is a economic, non-yellowing high-gloss finishing finish, very easy to use. Air-drying and force-drying.

PRODUCT AND AUXILIARY PRODUCTS

MS Clear Coat 91 2:1

Hardener	MS Hardener 81 STD MS Hardener 81 Fast MS Hardener 81 Slow	Drying time 30 minutes at 60 °C (object temp.) Drying time 15-25 minutes at 60 °C (object temp.) Drying time 30-40 minutes at 60 °C (object temp.)
Product to add	2K PU Thinners PLUS	A thinner with which the right viscosity can be achieved
Article numbers	MS Clear Coat 91 2:1 MS Hardener 81 STD MS Hardener 81 Fast MS Hardener 81 Slow 2K PU Thinner STD PLUS 2K PU Thinner Fast PLUS 2K PU Thinner Slow PLUS	9110 8110 8111 8112 3110+ 3111+ 3112+

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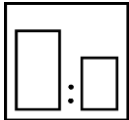
CHEMICAL BASIS

KRISTAL MS Clear Coat 91 Clear acrylic finish based on hydroxy-acrylic resins
KRISTAL MS Hardener 81 Isocyanate resin

SUBSTRATES

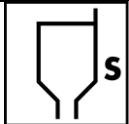
KRISTAL AquaGreen WB
Metallic basecoat / waterbase basecoat
Sanded and degreased old layers

MIXING



- 2 KRISTAL MS Clear Coat 91 2:1
 - 1 KRISTAL MS Hardener 81
- Add, if necessary, 0 - 10% KRISTAL 2K PU Thinner PLUS

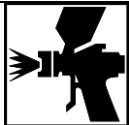
APPLICATION VISCOSITY



Application viscosity
16 - 17 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature
15°C - 30°C

EQUIPMENT SET-UP



Spray nozzle:
1.3 - 1.5 mm

Pressure:
2.0 - 2.2 bar at the air inlet

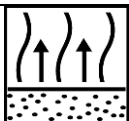
SPRAY COATS / LAYER THICKNESS



2 spray coats

Coat thickness 50 - 60 µm

FLASH-OFF



Maintain a flash-off of 5 - 10 minutes between the layers

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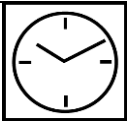
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SPRAY COATS / LAYER THICKNESS



Maintain a flash-off of 5 - 10 minutes between the layers

POTLIFE



4 hours at 20 °C

DRYING

Allow for a minimum of 5 minutes flash off time at 20 °C before moving the car into a pre-heated drying oven (booth) at 60 °C. All drying times relate to standard application and **object temperature**.



MS Clear Coat 91	MS Clear Coat 91	MS Clear Coat 91
MS Hardener 81 STD	MS Hardener 81 Fast	MS Hardener 81 Slow

20 °C	Dust dry	1 hour 15 mins	1 hour	1 hour 30 mins
	Dry to handle*	8 hours	7 hours	9 hours
60 °C	Dust dry	---	---	---
	Dry to handle*	30 minutes	25-30 minutes	35-40 minutes

* Following the drying cycle at 60 °C object temperature, allow the clear coat to cool down fully to ambient temperature.

ECONOMY

10 m² per liter ready to spray clear coat (60 µm)

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

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PHYSICAL PROPERTIES

Density : 0,98 kg/l
Flashpoint : 24 °C
Vol.% solids : 44,9%

VOLATILE ORGANIC COMPOUND

This product contains a maximum of 540 g/l. VOC

STORAGE LIFE

Under normal storage conditions for up to two years in unopened tins.

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 8 °C or higher than 30 °C.

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