

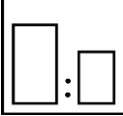


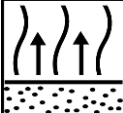






Technical Data Sheet

HS Clear Coat 92 2:1 PLUS
Art.nbr.: 9210+

Clear Coats
Version: **EN-TDS-9210-7**
Revision: April 2015
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FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

	2 HS Clear Coat 92 PLUS 1 HS Hardener 82 PLUS / HS Hardener 50° LT PLUS Add, if necessary, 0-10% 2K PU Thinner PLUS								
	Spray nozzle: 1.2 - 1.4 mm Pressure: 2.0 - 2.2 bar at the air inlet								
	2 spray coats								
	5 - 10 minutes between the layers								
	<table><tr><td>HS Clear Coat 92 2:1 PLUS</td><td>60 °C</td></tr><tr><td>HS Hardener 82 STD PLUS</td><td>30 minutes</td></tr><tr><td>HS Hardener 82 Fast PLUS</td><td>15 - 25 minutes</td></tr><tr><td>HS Hardener 82 Slow PLUS</td><td>30 - 40 minutes</td></tr></table>	HS Clear Coat 92 2:1 PLUS	60 °C	HS Hardener 82 STD PLUS	30 minutes	HS Hardener 82 Fast PLUS	15 - 25 minutes	HS Hardener 82 Slow PLUS	30 - 40 minutes
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HS Hardener 50° LT STD PLUS	30 minutes								
HS Hardener 50° LT Fast PLUS	15 - 25 minutes								
	Application viscosity 17 - 19 seconds (DIN CUP 4 mm / 20 °C)	Application- and object temperature 18 °C - 30 °C							
	Potlife 4 hours at 20 °C								
	Use suitable respiratory protection								
	For full technical information, please read the complete Technical Data Sheet								

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FULL TECHNICAL INFORMATION



- Very easy to use Clear, can not go wrong!
- VOC Compliant
- Excellent clearness
- Curing with 50° Celsius

FIELD OF APPLICATION

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

KRISTAL HS Clear Coat 92 2:1 PLUS, is a non-yellowing high-gloss finishing finish, very easy to use. Air-drying and force-drying.

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PRODUCT AND AUXILIARY PRODUCTS

HS Clear Coat 92 2:1 PLUS

Hardener	HS Hardener 82 STD PLUS	Drying time 30 minutes at 60 °C (object temp.)
	HS Hardener 82 Fast PLUS	Drying time 15-25 minutes at 60 °C (object temp.)
	HS Hardener 82 Slow PLUS	Drying time 30-40 minutes at 60 °C (object temp.)
	HS Hardener 50 ° LT STD PLUS	Drying time 30 minutes at <u>50 °C (object temp.)</u>
	HS Hardener 50 ° LT Fast PLUS	Drying time 15-25 minutes at <u>50 °C (object temp.)</u>
Product to add	2K PU Thinners PLUS	A thinner with which the right viscosity can be achieved
	2K Drying Booster	Drying accelerator for Clear Coats and Surfacer
Article numbers	HS Clear Coat 92 2:1 PLUS	9210+
	HS Hardener 82 STD PLUS	8210+
	HS Hardener 82 Fast PLUS	8211+
	HS Hardener 82 Slow PLUS	8212+
	HS Hardener 82 Extra Fast PLUS	8214+
	HS Hardener 50 ° LT STD PLUS	8215+
	HS Hardener 50 ° LT Fast PLUS	8217+
	2K PU Thinner STD PLUS	3110+
	2K PU Thinner Fast PLUS	3111+
	2K PU Thinner Slow PLUS	3112+
	2K Speed Additive PLUS	3117+
2K Drying Booster	3121	

CHEMICAL BASIS

KRISTAL HS Clear Coat 92 PLUS	Hydroxy-acrylic resins
KRISTAL HS Hardener 82 PLUS	Isocyanate resin
KRISTAL HS Hardener 50 ° LT PLUS	Isocyanate resin

SUBSTRATES

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

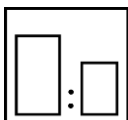
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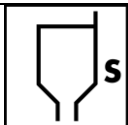
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MIXING



- 2 KRISTAL HS Clear Coat 92 2:1 PLUS
 - 1 KRISTAL HS Hardener 82 PLUS / HS Hardener 50° LT PLUS
- Add, if necessary, 0 - 10% KRISTAL 2K PU Thinner PLUS

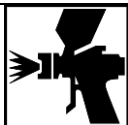
APPLICATION VISCOSITY



Application viscosity
17 - 19 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature
18°C - 30°C

EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.3 mm

Pressure:
2.0 - 2.2 bar at the air inlet

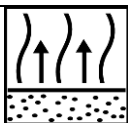
SPRAY COATS / LAYER THICKNESS



2 spray coats

Coat thickness 50 - 70 µm

FLASH-OFF



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

POTLIFE



4 hours at 20°C

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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**.



HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS
HS Hardener 82 STD PLUS	HS Hardener 82 Fast PLUS	HS Hardener 82 Slow PLUS

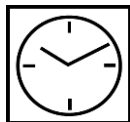
20°C	Dust dry	1 hour 30 mins	1 hour	2 hours
	Dry to handle*	8 hours	7 hours	9 hours

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.

DRYING · 50°C

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 50°C. All drying times relate to standard application and **object temperature**.



HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS
HS Hardener 50° LT STD PLUS	HS Hardener 50° LT Fast PLUS

20°C	Dust dry	1 hour 15 mins	1 hour
	Dry to handle*	8 hours	7 hours

50°C	Dust dry	---	---
	Dry to handle*	30 minutes	25-30 minutes

* Following the drying cycle at 50°C object temperature, allow the clear coat to cool down fully to ambient temperature.

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ECONOMY

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

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 0,97 kg/l
Flashpoint : 23 °C
Vol.% solids : 54%

VOLATILE ORGANIC COMPOUND

VOC CODE: **2004/42/IIB(d)(420)(420)**

Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready to use product IIB(d). Topcoat – All types. EU limit values: 420 g/l. (2007)
This product contains a maximum of 420 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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