

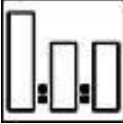
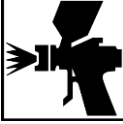

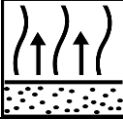
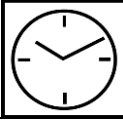
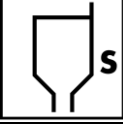
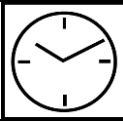


Technical Data Sheet

KRISTAL Universal TimeClear 3.0
Art.nbr.: 9455-3

Clear Coats
Version: **EN-TDS-9455_3-5**
Revision: March 2018
Page: 1 of 6

FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

	<p>4 Universal TimeClear 3.0 1 Universal TimeHardener 3.0 1 Universal TimeAdd 3.0 <i>Maintain the following on your mixing cup: 4:1 + 20%</i></p>
	<p>Spray nozzle: 1.2 - 1.3 mm Pressure: 2.0 bar at the air inlet Recommondation: DeVILBISS TE20 1.3 SATAjet 5000 B RP 1.2</p>
	<p>2 spray coats Layer thickness 50-60 µm</p>
	<p>3 - 5 minutes between the layers</p>
	<p>See overview on page 4</p>
	<p>Application viscosity 15 - 16 seconds (DIN CUP 4 mm / 20°C) Application- and object temperature 18°C - 25°C</p>
	<p>Potlife 80 minutes 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



- Fully cures with only 20°C
- Dust-dry after 10 – 15 minutes
- No heating of the spray booth
- Applicable for 1 panel up to a whole car overspray
- Excellent clearness
- Dry to assemble after 2,5 hours at 20°C
- Based on Automechanika Innovation Award winning technology

FIELD OF APPLICATION

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

KRISTAL Universal TimeClear 3.0, is an easy-to-use chemical resistant, non-yellowing, finishing clear finish.
Air-drying and force-drying.

PRODUCT AND AUXILIARY PRODUCTS

	KRISTAL Universal TimeClear 3.0	
Hardener	KRISTAL Universal TimeHardener 3.0	
Product to add	KRISTAL Universal TimeAdd 3.0	
Article numbers	KRISTAL Universal TimeClear 3.0	9455-3
	KRISTAL Universal TimeHardener 3.0	8455-3
	KRISTAL Universal TimeAdd STD 3.0	3455-3

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KRISTAL Universal TimeClear 3.0
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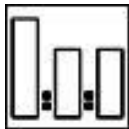
CHEMICAL BASIS

KRISTAL Universal TimeClear 3.0 Hydroxy-acrylic resins
KRISTAL Universal TimeHardener 3.0 Isocyanate resin

SUBSTRATES

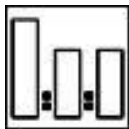
KRISTAL AquaGreen WB
Metallic basecoat / waterbase basecoat
Sanded and degreased old layers

MIXING



- 4 Universal TimeClear 3.0
 - 1 Universal TimeHardener 3.0
 - 1 Universal TimeAdd 3.0
- Maintain the following on your mixing cup: 4:1 + 20%*

MIXING



- 4 Universal TimeClear 3.0 (A)
- 1 Universal TimeHardener 3.0 (B)
- 1 Universal TimeAdd 3.0 (C)

100 ML	
A	64,5 gr
B	17,3 gr
C	14,6 gr

200 ML	
A	128,9 gr
B	34,5 gr
C	29,2 gr

300 ML	
A	193,4 gr
B	51,8 gr
C	43,8 gr

400 ML	
A	257,9 gr
B	69,1 gr
C	58,3 gr

500 ML	
A	322,3 gr
B	86,3 gr
C	72,9 gr

600 ML	
A	386,8 gr
B	103,6 gr
C	87,5 gr

700 ML	
A	451,3 gr
B	120,9 gr
C	102,1 gr

800 ML	
A	515,7 gr
B	138,1 gr
C	116,7 gr

Technical Data Sheet

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DRYING

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



Universal TimeClear 3.0
Universal TimeHardener 3.0
Universal TimeAdd STD 3.0

20°C	Dust dry	13 – 15 minutes
	Dry to polish / Dry to assemble	140 – 160 minutes
	Fully cured	Approx. 16 hours

40°C	Dust dry	---
	Handable	10 minutes

All curing times are subject to and can differ due to: layer thickness, humidity and air velocity.

INFRARED DRYING



D The curing times as listed are based on short wave (6 kilowatt).

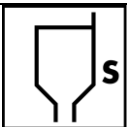
IMPORTANT! The object temperature during infrared curing may not exceed 100°C.

PRODUCT	U (min)	A (cm)	L (min)	H (min)
KRISTAL Universal TimeClear 3.0	5-8	50-70	4	8

U = Flash-off time
 L = Number of minutes half power

A = Distance infrared unit to object
 H = Number of minutes full power

APPLICATION VISCOSITY



Application viscosity
 15 – 16 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature
 18°C – 25°C

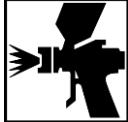
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EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.3 mm

Pressure:
2.0 bar at the air inlet

Recommandation:

DeVILBISS TE20 1.3
SATAjet 5000 B RP 1.2

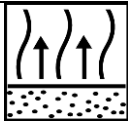
SPRAY COATS / LAYER THICKNESS



2 full spray coats

Layer thickness 50-60 µm

FLASH-OFF



Maintain a flash-off of 3 - 5 minutes between the layers

POTLIFE



80 minutes at 20 °C

ECONOMY

10 m² per liter ready to spray clear coat

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 0,97 kg/l
Flashpoint : 18 °C
Vol.% solids : 50,7%

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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.

KRISTAL COATINGS B.V.

P.O. Box 72
6640 AB BEUNINGEN GLD.
The NETHERLANDS

Tel.: +31 24 675 2636
Fax: +31 24 675 3360

E-mail: info@kristalcoatings.nl
Internet: www.kristalcoatings.com

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