

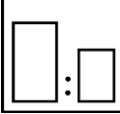


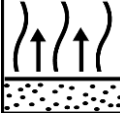





Technical Data Sheet

HS Clear Coat LV 4:1
Art.nbr.: 9100

Clear Coats
Version: **EN_NA-TDS-9100-3**
Revision: July 2015
Page: 1 of 5

FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

| | |
|---|--|
|  | <p>4 HS Clear Coat LV 1 HS Hardener LV Add, if necessary, 0-10% 2K PU Thinner PLUS</p> |
|  | <p>Spray nozzle: 1.3 – 1.4 mm Pressure: 2.0 – 2.2 bar at the air inlet 29 – 32 psi at the air inlet</p> |
|  | <p>2 spray coats</p> |
|  | <p>5 – 10 minutes</p> |
|  | <p>HS Clear Coat LV 4:1 140 °F / 60 °C HS Hardener LV STD 30 minutes</p> |
|  | <p>Application viscosity 15 – 16 seconds (DIN CUP 4 mm / 68 °F / 20 °C)</p> <p>Application- and object temperature 65 °F – 85 °F / 18 °C – 30 °C</p> |
|  | <p>Potlife 3 hours at 77 °F / 25 °C</p> |
|  | <p>Use suitable respiratory protection</p> |
|  | <p>For full technical information, please read the complete Technical Data Sheet</p> |

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FULL TECHNICAL INFORMATION



- Very easy to use Clear, can not go wrong!
- VOC Compliant
- LOW VOC: 2.1 lb/gal
- Excellent clearness

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 LV is a specially developed Clear Coat to comply with VOC limit regulations issued by the *California Air Resource Board* and *Environment Canada*. KRISTAL HS Clear Coat LV has a maximum VOC-content of 2.1 lb/gal. KRISTAL HS Clear Coat LV is a non-yellowing, high-gloss finishing finish, very easy to use. Air-drying and force drying. Suitable for passenger cars.

PRODUCT AND AUXILIARY PRODUCTS

| | HS Clear Coat LV 4:1 | |
|------------------------|-------------------------|--|
| Hardener | HS Hardener LV STD | Drying time 30 minutes at 140°F (object temp.) |
| 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 LV 4:1 | 9100 |
| | HS Hardener LV STD | 8040 |
| | 2K PU Thinner STD PLUS | 3110+ |
| | 2K PU Thinner Fast PLUS | 3111+ |
| | 2K PU Thinner Slow PLUS | 3112+ |
| | 2K Drying Booster | 3121 |

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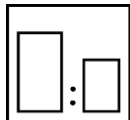
CHEMICAL BASIS

| | |
|--------------------------|------------------------|
| KRISTAL HS Clear Coat LV | Hydroxy-acrylic resins |
| KRISTAL HS Hardener LV | Isocyanate resin |

SUBSTRATES

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

MIXING



4 HS Clear Coat LV
1 HS Hardener LV
Add, if necessary, 0-10% 2K PU Thinner PLUS

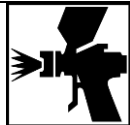
APPLICATION VISCOSITY AND TEMPERATURE



Application viscosity
15 - 16 seconds (DIN CUP 4 mm / 68°F / 20°C)

Application- and object temperature
65°F - 85°F / 18°C - 30°C

EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.4 mm

Pressure:
2.0 - 2.2 bar at the air inlet

29 - 32 psi at the air inlet

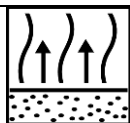
SPRAY COATS / LAYER THICKNESS



2 spraycoats

Layers thickness 2.0 - 2.4 mils / 50 - 60 µm

FLASH-OFF



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

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POTLIFE



3 hours at 77°F / 25°C

DRYING

Allow for a minimum of 5 minutes flash off time at 68°F / 20°C before moving the car into a pre-heated drying oven (booth) at 140°F / 60°C. All drying times relate to standard application and **object temperature**.



| HS Clear Coat LV | HS Clear Coat LV | HS Clear Coat LV |
|--------------------|---------------------|---------------------|
| HS Hardener LV STD | HS Hardener LV Fast | HS Hardener LV Slow |

| 68°F 20°C | Dust dry | 1 hour 30 mins | 1 hour | 2 hours |
|--------------|----------------|----------------|---------|---------|
| | Dry to handle* | 8 hours | 7 hours | 9 hours |

| 140°F 60°C | Dust dry | --- | --- | --- |
|---------------|----------------|------------|---------------|---------------|
| | Dry to handle* | 30 minutes | 25-30 minutes | 35-40 minutes |

* Following the drying cycle at 140°F / 60°C object temperature, allow the clear coat to cool down fully to ambient temperature.

ECONOMY

107 ft² / 10 m² per liter ready to spray clear coat (2.0 mils / 50 µm)

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 7.761 lb/gal - 0,93 kg/l
Flashpoint : <70°F - <21°C
Vol.% solids : 40,3%

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VOLATILE ORGANIC COMPOUND

Compliant conform U.S. National Rule, California Air Resource Board (CARB) and Environment Canada.
Multi-stage coatings, U.S. EPA & OTC limit value 5.3 lb/gal VOC (630 g/L)
Clear coats, California Air Resource Board limit value 2.1 lb/gal VOC (252 g/L)
Clear coats, Environment Canada limit value 2.1 lb/gal VOC (252 g/L)

This product contains a maximum of 2.1 lb/gal VOC (252 g/L), in combination with KRISTAL HS Hardeners LV.

STORAGE LIFE

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

STORAGE CONDITIONS

Do not store in areas exceeding temperatures of 86°F (30°C).

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 46°F (8°C) or higher than 86°F (30°C).

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Important notice

Our products are suitable for professional use only.
Registered processing times are valid under conditioned application circumstances only. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, not the suitability of the products for a specific purpose. Any date, weight, proportions, etc. given herein are for general information purpose only; they may change without prior information and do not constitute the quality of the products (product specification).
For technical support and advice with concern to choices of coatings systems and methods of application, our technical staff will be at your service at all times.