

ALPHAGAM

TECHNICAL DATA SHEET

2K Clearcoats
ACC10007 HF CLEAR PLUS

2K PU HF CLEAR PLUS

Product Code : ACC10007

PRODUCT INFO

2K PU HF CLEAR PLUS is a VOC-compliant High-Solid acrylic clear coat for complete or partial paint work of cars and commercial vehicles and provides an especially brilliant finish and optimal flow on solvent-based or water-based basecoats. **2K PU HF CLEAR PLUS** guarantees an optimal curing especially in case of oven drying but also at room temperature. It can be polished after forced drying and is highly resistant to all kind of weathering as well as to mechanical stress and chemical agents. Also suitable as protective coating for neon colours (fluorescent colours). Easy and safe application under all climatic conditions.

Approx Theoretical Coverage: 10 - 12 m²/ L (@ 50 - 60µm DFT)

SURFACE PREPARATION

Must be applied on top of a clean, dry, dust free base coat surface (use of tack 0 rag is suggested to remove dirt & dust particles from the base coat surface before clear coat application.)



Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Flow jar (high pressure)	2.5 - 3	1 - 1.1	2 - 2.5	0 - 25
HVLP (low pressure)	2.5 - 3	1.3 - 1.4	2 - 2.5	0 - 25

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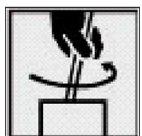
**Pot life :**

1 hr with 1-UP 2K PU HF Fast Hardener @ 30°C
1.5 hr with 1-UP 2K PU HF Medium Hardener @ 30°C
2 - 2.5 hr with 1-UP 2K PU HF Slow Hardener @ 30°C

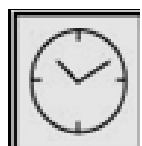
**Hardener :***for complete paint work**for partial paint work*

1-UP 2K PU HF Medium Hardener
1-UP 2K PU HF Slow Hardener

1-UP 2K PU HF Fast Hardener

**Thinner :**

1-UP 2K PU Standard Thinner
1-UP 2K PU HF Thinner
1-UP 2K PU HF EXTRA SLOW THINNER

**Drying time :**

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	25 - 35 min	8 h	12 h	NA	NA
60°C	NA	30 min	2 h	NA	NA

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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Technical Information

	Colour : Colourless
	Mixing Ratio : 2 : 1 (by volume) (2 parts of Clear & 1 part of Hardener)
	Spraying Viscosity : 18 - 20 sec. 4mm DIN
	Flash Off Time : 10 - 15 min before oven drying
	Dry Coat Thickness : 50 - 60 µm

Storage :	1year from the date of manufacturing at 30° C, if stored in a dark dry place in a tightly closed container.
VOC Regulation :	EU limit value for this product (category B/d): 420 g/l This product contains max. 420 g/l of VOC.
Processing Conditions :	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.
Processing instructions:	Optimum application: apply a light continuous spray coat followed by 1 full spray coat. In order to assure a perfect curing we recommend forced drying. When drying at room temperature, it is advisable to use the hardener 2K-HS-Fast Hardener.