

CLEAR TOPCOAT/LACURE

45-8033 [Clearcoat 2K 4:1 RGB]

1. GENERAL INFORMATION

2K 4:1 polyurethane Clear topcoat. It's providing good adhesion, high gloss and good hardness. Excellent in weathering and chemicals resistance.
Packing Size : -

2. MIXING

COMPONENTS

45-8033 (Clearcoat 2K 4:1 RGB)
21-33 (Hardener for 2K Top Coat RGB 4:1)
86-200 (2K Thinner No. 200 [FAST DRY])

MIX RATIO	Volume	By weight	Remark
45-8033	100	100.00	
21-33	25	25.75	
86-200	10	9.00	
APPLY VISCOSITY	14 - 16 second NK#2		
POT LIFE	4 - 5 Hour		

3. APPLICATION

SURFACE PREPARATION

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application.

APPLICATION

Number of coats	2 – 3 coats Medium wet coats. Remark: Mixing ratio, Mixing component and environmental effect to flash off time.
Dry film thickness	Contact our Technician
Theoretical Coverages	Contact our Technician

APPLICATION EQUIPMENT

GUN SET UP*	Compliant	Gravity Feed	1.3 – 1.6 mm/td>
		Siphon Feed	1.3 – 1.6 mm
	HVLP	Gravity Feed	1.3 – 1.6 mm
		Siphon Feed	1.3 – 1.6 mm
AIR PRESSURE*	Compliant	Gravity Feed	20 – 30 psi at the gun
		Siphon Feed	20 – 30 psi at the gun
	HVLP	Gravity Feed	6-8 psi at the cap
		Siphon Feed	6-8 psi at the cap

Remark : The listed setups cover the range for standard application equipment.

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4. DRY TIME

AIR DRY @25-30 °C

Touch Dry : 3 - 5 minutes

Setting Time : 3 - 4 Hours

Polishing Time : 6 - 8 Hours

FORCE DRY at 60-80 °C

Flash off before forcing dry : 5 - 10 minutes

Cycle Time : 30 - 40 minutes

Cool Down : 40 - 60 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Remark : Flash time and Dry times will depends on temperature, humidity and wet film thickness.

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process.

The data is not to be considered as a warranty or quality specification and assumes no liability in connection with its use.

5. SANDING / COMPOUNDING / POLISHING

SANDING

Use 1500 grit wet or finer.

Note: Use caution when sanding or polishing. Cutting too deep into the film may cause a color ring effect.

This can be repaired only by applying the Clear Topcoat over the sanding areas.

COMPOUNDING

Use finishing compound. Apply a thin ribbon of material to the area to be compounded. Use a wool pad. Maintain air or variable speed at 2000-3000 rpm. Remove a excess finishing compound with a clean soft cloth prior to applying finish polish.

POLISHING

Use finishing polish. Apply a ribbon of material to work a 2-3 foot square area. Using a foam pad, maintain a variable speed buffer at 1200-1800 rpm. Keep the polisher/buffer always moving, Over each pass approximately 50%. As finishing polish to dry, stop polishing, wipe off excess polish with a clean, soft cloth, or glaze with orbital buffer.

6. PHYSICAL PROPERTIES

Specific Gravity : 0.9 - 1 g/cm³

Total Non-Volatile Solid : 49 - 52 %

7. VOC REGULATION AREAS

These directions refer to the use of products which may be restrictors require special mixing instruction in VOC regulation areas. Follow mixing usage and recommendations in the VOC compliant products Chart for your area.

8. SAFETY AND HANDLING

For professional or trained applicator use only. Not for sale or use by the public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggles and a safety mask when using a product. Apply paint in good ventilating area.