

46-8077

PRODUCT DATA SHEET | ข้อมูลผลิตภัณฑ์



Clearcoat 2K 21 RGB

BIC-BEN® CLEAR COAT

VERSION

Version 1
Date 20 December 2019

PRODUCT DESCRIPTION

46-LINE, 2K 2:1 Polyurethane clearcoat providing High gloss, Good hardness. Excellent in weathering resistance. It's design for large area. It's provide long pot life but short time for film setting.

KEY CHARACTERISTICS

- High solid clearcoat
- High gloss and hardness
- Good weathering clear coat

PHYSICAL PROPERTIES

Supply viscosity	40 - 43 sec by Ford cup No.4
Specific gravity	0.94 – 1.04 g/cm ³
Total non-volatile	54 – 60 % at 150 °C x 30 mins
Shelf life	1 Year
	Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

APPLICATION PARAMETERS



Part A : Hardener : Thinner
2 : 1 : 5-15% By Volume

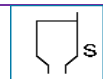
Mixing ratio

Hardener 21-77 [2K RGB 2:1 Hardener] or recommended by our staff

Reducer Thinner 2K Thinner # 86-120

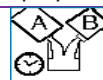
Coverage 10 m² / liter ready to use mixture at dry film 50 micron
By using the recommended application, the theoretical material coverage

Note. The practice material usage depends on many factors i.e. shape of object, roughness of the surface, application techniques, pressure and application circumstances.



Ford cup No. 4 18-20 seconds

Spray viscosity



2– 3 hr. at 25 °C

Pot life



Gravity feed 1.2 – 1.4 mm

Air pressure 1.7 -2.2 bar

Spray condition

28 – 30 psi

HVLP max 0.6 – 0.7 bar (8-10 psi) at the air cap



2 coats

Dry film thickness 50-60 micron.

Number of coats



10 – 15 mins

at 25 – 30 °C

Flash time



Dry time

	20 °C	30 °C	40 °C
Dust free time	10-15 min	5-7 mins	4-5 mins
Dry to handle	9-10 hr.	7-8 hr.	4-5 hr.
Dry to polish	9-10 hr.	7-8 hr.	4-5 hr.

PRECAUTION

Warning

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