



Art.-No.:6.7230.0750

7230

2K HS-Rapid Clearcoat 3:1

Characteristics

4CR 2K HS-Rapid Clearcoat is a VOC-compliant (3.5 lbs/gal) acrylic clearcoat, especially designed for fast high quality repairs (express-technology). Can be polished after 15 Min. / 140 °F. Also spot-repairs can be done. Excellent gloss and stability against UV-light are assured even by one coat application. It is ready to use after the addition of 4RC hardener 0408. Excellent durability against all environmental and climatic circumstances, yellowing resistant and durable gloss.

V.O.C. Value

EC limiting value for the product (cat. B/e): 840 g/l (2007)

This product contains max. 697 g/l VOC [5,82 lbs/gal]

Tech Tip

Hardener:

4CR HS Härter 0408 fast for small repairs.

4CR HS Härter 0408 standard for partial resprays.

Thinners:

VOC = 3,5 lbs/gal : add no thinner

VOC = 4,1 lbs/gal : up to 15 % 4CR 2K thinner 0505 is possible: The addition of thinner is recommended for partial resprays.

Application

Operation conditions from + 10°C and up to 75% relative air humidity.

HVLP:

Spraying pressure: refer to spraygun manufacturers information

Spraying nozzle: 1,3 - 1,4 mm

Number of coats: 2

RP (recommended):

Spraying pressure: refer to spraygun manufacturers information

Spraying nozzle: 1,2 - 1,3 mm

Number of coats: 2

Curing time / Flash off time: 4 - 5 min. between the spraying operations; 4 - 6 min. before final drying.

Drying:

Object temp. 20°C: dust dry after 10 - 12 min., set to touch after 15 - 20 min., full hardness after 4 h.

Object temp. 60°C: dust dry after 5 min., set to touch after 10 min., full hardness after 30 min.

IR drying:

Flash off time: 7 - 10 min.

Shortwave: 8 min.



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Mediumwave: 12 - 14 min.

Technical Data

Colour shade	transparent
Mixing ratio	3 : 1 by volume
Consumption	6 - 8 m ² /l
Hardener	0408
Thinner	0505 2K Thinner
Spraying viscosity 20° C	14 - 16 s 4 mm DIN
Pot life	2 h
Coat thickness / dry film	1,6 - 2,0 mill