



TECHNICAL DATA SHEET No 228

C 898 CLEAR ULTRA HS 2:1

GENERAL TECHNICAL DESCRIPTION

Ultra high solid fast clear coat suitable for full body or spot panel repairs

Excellent mechanical and high chemical resistance

Excellent surface finish

Great gloss retaining

SURFACE

HB BODY Color Solutions Basecoat Mix System

HB BODY Color Solutions 2K Acrylic Mix System

HB BODY Color Solutions Aquabase Mix System

PRETREATMENT/CLEANING OF SUBSTRATE



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER.

Make sure the surface is first wiped dry and then air dried.

PRODUCT APPLICATION: 1.5 coats. Apply a half coat and after flash off time apply the second full coat.



Mix 2 parts CLEAR with H 738 NORMAL / H 737 SLOW HARDENER
Pot life: 90 - 120 min
23°C (73°F)



Addition 5 - 10% 740 ACRYL NORMAL THINNER / REDUCER



Ready to spray: 18 - 20 s
DIN 4 / 20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 3 bar (29 - 44 psi)
1.5x coats = 50 - 60 µm
(2 - 2.4 mil)



1.2 - 1.3 mm
2 - 2.5 bar (29 - 36 psi)
1.5x coats = 50 - 60 µm
(2 - 2.4 mil)



5 - 10 min / 23°C (73°F)
Flash off time



10 - 15 min / 23°C (73°F)
Final flash off time with
spray booth recirculation



4 - 6 hrs / 23°C (73°F)
5 - 10 min / 60°C (140°F)
25 - 30 min / 40°C (104°F)
panel temperature



Flash off before IR curing:
2 - 3 min
1st step: half power 2 - 4 min
2nd step: full power 8 - 10 min
Lamp distance 60 - 80 cm

TEMP.	PARTIAL REPAIR	FULL REPAIR
15-25°C (59-77°F)	H738 + 5-10%740	H737/H738 + 5-10%740
25-35°C (77-95°F)	H737/H738 + 5-10%740	H737 + 5-10%740
Drying Time	5-10 min / 60°C (140°F) 25-30 min / 40°C (104°F)	

FLASH POINT

27°C / 81°F

SPECIFIC GRAVITY

1 g/cm³

SOLID CONTENT

(NO THINNER)

57,7% Weight

VOC (2004/42/EC)

This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 420 g/L. The VOC content in the ready for use form of this product is 420 g/L. 2004/42/IB(e)(420)420

THEORETICAL COVERAGE

10 - 12 m² / l at 50 micron (2 mil)
dry film thickness

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL thinner / reducer

REMARKS

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the specified hardeners
- Polishing possible after force drying and 20 - 30 min cooling phase or after 5h air drying

STORAGE SHELF LIFE

Store in a cool place +5°C - +25°C (+40 - +77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



Always wear protective equipment



Follow the application instructions mentioned in this TDS

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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