

C 894 CLEAR ULTRA HS 2:1



GENERAL TECHNICAL DESCRIPTION

Ultra high solid clear coat suitable for full body or spot panel repairs
Great gloss retaining
Excellent mechanical and high chemical resistance
Excellent surface finish

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 mist coat and after flash off time apply the second full coat.



Mix 2 parts CLEAR with H 733 SLOW / H 734 NORMAL / H 735 FAST HARDENER ULTRA HS
Pot life: 90 - 135 min



No THINNER / REDUCER required



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)



0 - 2 min / 23°C (73°F)
Flash off time



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



16 - 20 hrs / 23°C (73°F)
25 - 40 min / 60°C (140°F)
panel temperature



Flash off before IR curing:
4 - 5 min
1st step: half power
5 min
2nd step: full power
12 - 16 min
Lamp distance:
60 - 80 cm

Application conditions

For partial or spot repairs:

T = 15 - 20°C (59 - 68°F) use H 735 Hardener UHS Fast
T = 20 - 30°C (68 - 86°F) use H 734 Hardener UHS Normal
T = 30 - 35°C (86 - 95°F) use H 733 Hardener UHS Slow
Rel. humidity 40 - 80%

For complete car repair:

T < 25°C (77°F) use H734 Hardener UHS Normal
T = 25 - 35°C (77 - 95°F) use H 733 Hardener UHS Slow
Rel. humidity 40 - 80%

FLASH POINT

27°C / 81°F

SPECIFIC GRAVITY

0.977 g/cm³

SOLID CONTENT

(NO THINNER)

57,5% 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/IIB(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

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.

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

NOVEMBER 2021