

TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

HS 4:1

2K URETHANE CLEARCOAT

PRODUCTS

HS 4:1 2K Urethane Clearcoat
MEDIUM Hardener 1:4 for HS 2K Urethane Clearcoat

PRODUCT DESCRIPTION

2K urethane clearcoat with high solids content for quick repairs. Extremely easy to apply thanks to its great fluidity, exceptional leveling and fast hardening time. Provides perfect finish and high gloss. Ready to use without the addition of reducer!


COLOR: transparent

GLOSS GRADE: high gloss

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 510 [g/l] – 4,256 [lb/gal]

SURFACE PREPARATION

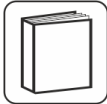
Urethane clearcoats can be applied over:

- Basecoats.
- Properly cleaned and sanded OEM finishes.

For application over recommended basecoat system:

- Allow basecoats sufficient dry times.
- Over OEM sand finish dull with P800 or gray scuff pad.

APPLICATION PROCESS

	USE For car body paint repair that requires a durable finish.		NUMBER OF LAYERS 2 coats: 2 full coats, total dry film thickness of approx. 60 µm (2.4 mils). Compliant (RP) spray gun: 1.3÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) HVLP spray gun: 1.3÷1.4 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar). Note: follow the gun producer's recommendations.						
	MIXING RATIO by volume Clearcoat 4 parts Hardener 1 part Reducer not required!		HARDENING TIME <table border="1"><tr><td>Dust dry at 68°F (20°C):</td><td>15 minutes</td></tr><tr><td>Baking at 140°F (60°C): (temperature of the panel)</td><td>30 minutes</td></tr><tr><td>Ready to polish:</td><td>after drying overnight</td></tr></table> Temperature below 68°F (20°C) significantly increases the hardening time.	Dust dry at 68°F (20°C):	15 minutes	Baking at 140°F (60°C): (temperature of the panel)	30 minutes	Ready to polish:	after drying overnight
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	SPRAYING VISCOSITY 14÷15 seconds at 68°F (20°C)/DIN4 with 10% reducer								
	POT LIFE Approx. 2,5 h at 68°F (20°C)								
	EVAPORATION TIME Between layers: approx. 5 minutes Before banking: approx. 10 minutes		IR DRYING 15÷20 minutes of short waves, , depending on the coat thickness and the type of radiator. Do not exceed 140°F (60°C). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.						

PRODUCT EFFICIENCY

1 liter of mixture is enough to cover 8÷10 m², yielding a dry film thickness of 60 µm (2.36 mils).

POLISHING AND REMOVING IMPURITY INCLUSIONS

Usually polishing is unnecessary, as the HS MASTER 4:1 2K Urethane Clearcoat gives the surface a perfect look immediately after application. However, if some dirt inclusions appear, we recommend removing them and then polishing the surface with an abrasive compound.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: To maintain safety, always follow the instructions given in the MSDS for the products.

STORAGE

Store the product between 59 to 77°F (15 to 25°C) in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use the container with product should be immediately closed.
2. Protect the hardener from frost and dampness!

WARRANTY PERIOD

HS 4:1 2K Urethane Clearcoat	– 24 months from the date of production
MEDIUM Hardener 1:4 for HS 2K Urethane Clearcoat	– 12 months from the date of production

PRODUCT	ART. No.
HS 4:1 2K Urethane Clearcoat	2247; 9546 (1l; 4l)
MEDIUM Hardener 1:4 for HS 2K Urethane Clearcoat	1925; 13755 (0,25l; 1l)

LIMITATION OF LIABILITY

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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