



TECHNICAL DATA SHEET No 219

BODY 698 CLEAR HS SR 2:1

GENERAL TECHNICAL DESCRIPTION

2K HS (High Solids) clear coat, with excellent leveling, high gloss and long lasting protection.

Easy to apply due to its high viscosity formula.

Fast hardening properties for spot panel and full automotive repairs.

Resistant to chemicals and mechanical stress.

Can be combined with 440 Texture Additive for the repair of PSA (Stellantis) cars with structured matt finishes.

SURFACE

HB BODY solvent- and waterborne basecoat paints

PRETREATMENT/CLEANING OF SUBSTRATE



Let the basecoat dry sufficiently before the clearcoat. Clean the surface from the dust with a tack cloth.

PRODUCT APPLICATION:



Mix 2 parts CLEAR COAT with 1 part BODY 620 HARDENER or H754 FAST / H753 NORMAL / H752 SLOW HARDENERS FOR TOPCOATS
 Pot life at 23°C (73°F):
 • 620: 1.5 h
 • H752 / H753: 3.5 h
 • H754: 2 h



Addition 5 - 15% 740 NORMAL / 741 SLOW ACRYL THINNER / REDUCER



Ready to spray: 16 - 19 s
 DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
 1.7 - 2.2 bar (25 - 32 psi)
 2x coats = 50 - 60 µm
 (2 - 2.4 mil)



5 - 10 min / 23°C (73°F)
 Flash off time between coats
 10 min / 23°C (73°F)
 Flash off time before drying



20 - 30 min / 60°C (140°F)
 panel temperature
 8 - 16 h / 23°C (73°F)



Short wave 8 - 12 min
 Distance: 60 - 70 cm

APPLICATION WITH

BODY 620 / H754 FAST Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)	H754/620 + 5-10% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)
15-25°C (59-77°F)			
25-30°C (77-86°F)	H754/620 + 5-10% 740/741 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)	
>30°C (86°F)			

APPLICATION WITH

H753 NORMAL / H752 SLOW Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)		H753 + 5-15% 740 30 min / 60°C (140°F)	H753 + 5-15% 740 30 min / 60°C (140°F)
15-25°C (59-77°F)	H753 + 5-10% 740 30 min / 60°C (140°F)		
25-30°C (77-86°F)		H752/H753 + 5-15% 740 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)
>30°C (86°F)	H752/H753 + 5-10% 740/741 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)	

SPECIFIC GRAVITY0.99 ± 0.01 g/cm³**SOLID CONTENT**

50 ± 2% Weight

VOC (2004/42/EC)

This is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 840 g/L.
2004/42/II B(e)(840)840

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL or 767 NITRO thinner / reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Do not use at temperatures below 10°C (50°F).
- Drying time and potlife depends on hardener, film thickness and ambient temperature (recommended film thickness 50-60 µm).

STORAGE SHELF LIFE

Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



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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