

C898 CLEAR ULTRA HS 2:1



GENERAL TECHNICAL DESCRIPTION

Ultra high solid fast clear coat suitable for full body or spot panel repairs.
Superior mechanical and chemical resistance.
Excellent surface finish and gloss retaining.
Extremely fast drying.

SURFACE

HB BODY solventborne 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: 1.5 coats. Apply a half thin closed coat followed by the second full coat.



Mix 2 parts CLEAR COAT with 1 part H738 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)



1.2 - 1.3 mm
1.7 - 2.2 bar (25 - 32 psi)
1.5x coats = 50 - 60µm
(2 - 2.4 mil)



2 - 5 min / 23°C (73°F)
Flash off time between coats



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)	

SPECIFIC GRAVITY

1 ± 0.02 g/cm³

SOLID CONTENT

(NO THINNER / REDUCER)

57,7 ± 2% Weight

VOC (2004/42/CE)

This is an automotive 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/IIIB(d)(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

- Application only with the specified hardeners and thinners / reducers.
- Polishing possible after force drying and 20 - 30 min cooling phase or after 5h air drying

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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