

## CLEAR X3

High solid, antiscratch 2K clear coat. Ready to use. The cured film is very hard and very stable due to high resistance to chemicals and weathering.

The three catalysts allow to modulate the curing rate according to temperature and working conditions. Designed for use on solvent- and waterborne base coats.

### CHARACTERISTICS:

Clearcoat:

- Specific gravity 0.97-0.99 g/cm<sup>3</sup>
- Colour: clear

Hardener:

- Specific gravity 0.97-0.99 g/cm<sup>3</sup>
- Colour: clear or light yellow

### MIXING RATIO:

By volume: 2 parts Clearcoat + 1 part Hardener

By weight: 100 g Clearcoat+ 50 g Hardener

Mix thoroughly.

Viscosity of the mixture:

- 16-18 seconds (DIN 4 mm a 20°C)
- 17-19 seconds (Ford 4 mm a 20°C)
- 31-36 seconds (ISO 4 mm a 20°C)

**POT-LIFE:** At 20°C: 120 minutes

### APPLICATION:

Apply with a gravity-feed spray gun with a nozzle diameter of 1.3 mm, operating pressure as recommended by the spray gun manufacturer.

Recommended process conditions: temperature 18°C to 22°C, relative air humidity 40 - 60%

Apply 2 normal coats with a 5-7-minute flash-off break between the coats.

Dry film thickness: 45-60 microns.

Keep the flash-off time of 10 minutes before drying in an oven.

### DRYING TIMES:

SLOW HARDENER

- Dry to touch: in air at 20°C, 8-9 hours
- Dry to polish: in air at 20°C, 11-12 hours  
In oven at 60°C, 40 minutes

STANDARD HARDENER

- Dry to touch: in air at 20°C, 6-7 hours
- Dry to polish: in air at 20°C, 10-11 hours  
In oven at 60°C, 30 minutes

FAST HARDENER

- Dry to touch: in air at 20°C, 4-5 hours
- Dry to polish: in air at 20°C, 8-9 hours  
In oven at 60°C, 20 minutes

Full hardness: in air at 20°C, 5-7 days

N.B: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down.

IR drying: 10 min. Follow the recommendations of the IR lamp manufacturer. Allow the coat to flash-off before drying.

**THEORETICAL EFFICIENCY:** 9/10 m<sup>2</sup>/L.

*The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.*

\* For any information about product codes or packs, please see our catalogue, our price list or contact us.