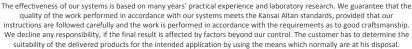


ardea

TDS 30-2-1 Cardea® 2+1 Acrylic Supercure Clearcoat

Description	Cardea® 2+1 Acrylic Supercure Clearcoat is a fast curing clearcoat with excellent film properties and polishability.					
Related Products	Cardea® 2+1 Acrylic Supercure Clearcoat Cardea® 2K Acrylic Hardener TDS no: 40-2-1 Cardea® Universal Thinners TDS no: 50-2-1					
Substrate		Cardea [®] Basecoats				
Mixing		By Volume By Weight				
		Cardea® 2+1 Acrylic Su Clearcoat	ıpercure	100	100	100
		Cardea® 2K Acrylic Ha	rdener	50	50	
		Cardea [®] Universal Thi	nners	5 - 15	5 - 15	
Viscosity	s	13 – 14 s/20°C (DIN 4)				
Pot Life		4 hours (at 20°C)				
Spray Gun Parameters	**	Gun Type		Nozzle size	Air pressure	
		Suction feed spray gun		1,4-1,6 mm	3 - 4 bars	
		Gravity feed spray gun		1,2-1,5 mm	n 3 - 4 bars	
		HVLP Suction feed spray gun		1,5-1,7 mm	·	
		HVLP Gravity feed spray gun		1,3-1,6 mm	m 2 - 2,2 bars	
Application		Spray a thin coat and then continue spraying several wet coats until full gloss. Allow 5-10 minutes flash-off between coats.				
Flash-off Time	<u>}</u> †/†/	Approximately 5 - 10 min (at 20 °C) until touch dry.				
Drying			20°C	60°C		
		Dust Dry	10 min			
		Time to Polish	3 hours	20 min		
)









TDS 30-2-1



Cardea® 2+1 Acrylic Supercure Clearcoat

Polishing	Wet sand dirt and/or uneven surface by P1500/P2000 sanding paper. Then use compound and polish for surface appearance and gloss.			
Dry Film Thickness	50 - 60 μm			
Theoretical Coverage	5,5 - 6 m²/l at 50 μm			
Equipment Cleaning	Use acrylic or cellulosic thinners.			
Package	Cardea® 2+1 Acrylic Supercure Clearcoat Cardea® 2K Acrylic Hardener	: 1 L; 5 L : 0,5 L; 1 L		
Color	No color			
Safety	Professional use only. See Material Safety Data Sheet.			



