









TDS 30-2-3


Cardea® 2+1 HS Clearcoat

Description	Cardea® HS Clearcoat is a "high-solids" category acrylic clearcoat builds extra high film volume, which ends up with excellent gloss, levelling and DOI (distinctness of image) appearance.		
Related Products	Cardea® 2+1 HS Clearcoat Cardea® 2K HS Acrylic Hardener Cardea® Universal Thinners	TDS no: 40-2-2 TDS no: 50-2-1	
Substrate	Cardea® Basecoats		
Mixing		By Volume	By Weight
	Cardea® HS Clearcoat	100	100
	Cardea® 2K HS Acrylic Hardener	50	50
	Cardea® Universal Thinners	5 - 15	5 - 15
Viscosity		15-17 s / 20°C (DIN 4)	
Pot Life	5 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 3 - 4 bars
		HVLP Suction feed spray gun	1,5-1,7 mm 2 - 2,2 bars
		HVLP Gravity feed spray gun	1,3-1,6 mm 2 - 2,2 bars
Application		2 coats	
Flash-off Time		Approximately 5 - 10 min (at 20 °C) until touch dry.	
Drying		20°C	60°C
	Dust Dry	30 min	
	Time to Polish	6 hours	30 min



TDS 30-2-3

Cardea® 2+1 HS 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		8 m ² /l at 50 µm
Equipment Cleaning		Use acrylic or cellulosic thinners.
Package		Cardea® 2+1 HS Clearcoat : 1 L; 5 L Cardea® 2K HS Acrylic Hardener : 0,5 L; 1 L
Color		No color
Safety		Professional use only. See Material Safety Data Sheet.