

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 Hard Cardea [®] Universal Thinners	Acrylic Hardener TDS no: 40-2-2			
Substrate		Cardea® Basecoats				
Mixing				By Volume By Weight		
		Cardea® HS Clearcoat		100	100	
		Cardea® 2K HS Acrylic Har	dener	50	50	
		Cardea [®] Universal Thinner	rs	5 - 15	5 - 15	
Viscosity	s	15-17 s / 20°C (DIN 4)				
Pot Life		5 hours (at 20°C)				
Spray Gun Parameters	**	Gun Type		Nozzle size	Air press	sure
		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 gu	ın	1,5-1,7 mm	2 - 2,2 k	oars
		HVLP Gravity feed spray gu	n	1,3-1,6 mm	2 - 2,2 k	oars
Application		2 coats				
Flash-off Time	<u>}</u> †/†/	Approximately 5 - 10 min (at 20 °C) until touch dry.				
Drying			20°C	60°C		
		Dust Dry	30 min			
		,	6 hours	30 min		



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.









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



