

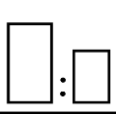


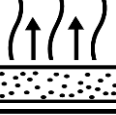
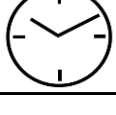





Technical Data Sheet

HS Clear Coat 92 2:1 PLUS
Art.nbr.: 9210+

Clear Coats
Version: **EN_NA-TDS-9210-3**
Revision: July 2015
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FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

	<p>2 HS Clear Coat 92 PLUS 1 HS Hardener 82 PLUS / HS Hardener 50° LT PLUS Add, if necessary, 0-10% 2K PU Thinner PLUS</p>								
	<p>Spray nozzle: 1.2 – 1.4 mm Pressure: 2.0 – 2.2 bar at the air inlet 29 – 32 psi at the air inlet</p>								
	<p>2 spray coats</p>								
	<p>5 – 10 minutes between the layers</p>								
	<table border="0"> <tr> <td>HS Clear Coat 92 2:1 PLUS</td> <td>140 °F / 60 °C</td> </tr> <tr> <td>HS Hardener 82 STD PLUS</td> <td>30 minutes</td> </tr> <tr> <td>HS Hardener 82 Fast PLUS</td> <td>15 – 25 minutes</td> </tr> <tr> <td>HS Hardener 82 Slow PLUS</td> <td>30 – 40 minutes</td> </tr> </table>	HS Clear Coat 92 2:1 PLUS	140 °F / 60 °C	HS Hardener 82 STD PLUS	30 minutes	HS Hardener 82 Fast PLUS	15 – 25 minutes	HS Hardener 82 Slow PLUS	30 – 40 minutes
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HS Hardener 50° LT STD PLUS	30 minutes								
HS Hardener 50° LT Fast PLUS	15 – 25 minutes								
	<p>Application viscosity 17 – 19 seconds (DIN CUP 4 mm / 68 °F / 20 °C)</p> <p>Application- and object temperature 65 °F – 85 °F / 18 °C – 30 °C</p>								
	<p>Potlife 4 hours at 77 °F / 25 °C</p>								
	<p>Use suitable respiratory protection</p>								
	<p>For full technical information, please read the complete Technical Data Sheet</p>								

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FULL TECHNICAL INFORMATION



- Very easy to use Clear, can not go wrong!
- VOC Compliant
- Excellent clearness
- Curing with 122° Fahrenheit / 50° Celsius

FIELD OF APPLICATION

For application as a clear coat over KRISTAL AquaGreen WB and other Metallic Basecoat Series.
Suitable for passenger cars.

KRISTAL HS Clear Coat 92 2:1 PLUS, is a non-yellowing high-gloss finishing finish, very easy to use. Air-drying and force-drying.

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PRODUCT AND AUXILIARY PRODUCTS

HS Clear Coat 92 2:1 PLUS

Hardener	HS Hardener 82 STD PLUS	Drying time 30 minutes at 140°F (object temp.)
	HS Hardener 82 Fast PLUS	Drying time 15-25 minutes at 140°F (object temp.)
	HS Hardener 82 Slow PLUS	Drying time 30-40 minutes at 140°F (object temp.)
	HS Hardener 50° LT STD PLUS	Drying time 30 minutes at <u>122°F (object temp.)</u>
	HS Hardener 50° LT Fast PLUS	Drying time 15-25 minutes at <u>122°F (object temp.)</u>
Product to add	2K PU Thinners PLUS	A thinner with which the right viscosity can be achieved
	2K Drying Booster	Drying accelerator for Clear Coats and Surfacer
Article numbers	HS Clear Coat 92 2:1 PLUS	9210+
	HS Hardener 82 STD PLUS	8210+
	HS Hardener 82 Fast PLUS	8211+
	HS Hardener 82 Slow PLUS	8212+
	HS Hardener 82 Extra Fast PLUS	8214+
	HS Hardener 50° LT STD PLUS	8215+
	HS Hardener 50° LT Fast PLUS	8217+
	2K PU Thinner STD PLUS	3110+
	2K PU Thinner Fast PLUS	3111+
	2K PU Thinner Slow PLUS	3112+
2K Drying Booster	3121	

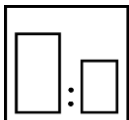
CHEMICAL BASIS

KRISTAL HS Clear Coat 92 PLUS	Hydroxy-acrylic resins
KRISTAL HS Hardener 82 PLUS	Isocyanate resin
KRISTAL HS Hardener 50° LT PLUS	Isocyanate resin

SUBSTRATES

KRISTAL AquaGreen WB
Metallic basecoat / waterbase basecoat
Sanded and degreased old layers

MIXING



- 2 KRISTAL HS Clear Coat 92 2:1 PLUS
 - 1 KRISTAL HS Hardener 82 PLUS / HS Hardener 50° LT PLUS
- Add, if necessary, 0 – 10% KRISTAL 2K PU Thinner PLUS

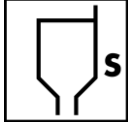
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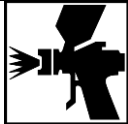
APPLICATION VISCOSITY AND TEMPERATURE



Application viscosity
17 - 19 seconds (DIN CUP 4 mm / 68°F / 20°C)

Application- and object temperature
65°F - 85°F / 18°C - 30°C

EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.3 mm

Pressure:
2.0 - 2.2 bar at the air inlet 29 - 32 psi at the air inlet

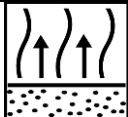
SPRAY COATS / LAYER THICKNESS



2 spray coats

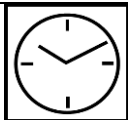
Layers thickness 2.0 - 2.7 mils / 50 - 70 µm

FLASH-OFF



Maintain a flash-off of 5 - 10 minutes between the layers

POTLIFE



4 hours at 68°F / 20°C

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DRYING

Allow for a minimum of 5 minutes flash off time at 68°F / 20°C before moving the car into a pre-heated drying oven (booth) at 140°F / 60°C. All drying times relate to standard application and **object temperature**.



HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS
HS Hardener 82 STD PLUS	HS Hardener 82 Fast PLUS	HS Hardener 82 Slow PLUS

68°F 20°C	Dust dry	1 hour 30 mins	1 hour	2 hours
	Dry to handle*	8 hours	7 hours	9 hours

140°F 60°C	Dust dry	---	---	---
	Dry to handle*	30 minutes	25-30 minutes	35-40 minutes

* Following the drying cycle at 140°F / 60°C object temperature, allow the clear coat to cool down fully to ambient temperature.

DRYING · 122°F / 50°C

Allow for a minimum of 5 minutes flash off time at 68°F / 20°C before moving the car into a pre-heated drying oven (booth) at 122°F / 50°C. All drying times relate to standard application and **object temperature**.



HS Clear Coat 92 PLUS	HS Clear Coat 92 PLUS
HS Hardener 50° LT STD PLUS	HS Hardener 50° LT Fast PLUS

68°F 20°C	Dust dry	1 hour 15 mins	1 hour
	Dry to handle*	8 hours	7 hours

122°F 50°C	Dust dry	---	---
	Dry to handle*	30 minutes	25-30 minutes

* Following the drying cycle at 122°F / 50°C object temperature, allow the clear coat to cool down fully to ambient temperature.

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ECONOMY

107 ft² / 10 m² per liter ready to spray clear coat (2.4 mils / 60 µm)

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 8.095 lb/gal - 0,97 kg/l
Flashpoint : 73,4°F - 23°C
Vol.% solids : 54%

VOLATILE ORGANIC COMPOUND

Compliant conform U.S. National Rule.
Multi-stage coatings, U.S. EPA & OTC limit value 5.3 lb/gal VOC (630 g/L)
This product contains a maximum of 3.5 lb/gal VOC (420 g/L)

STORAGE LIFE

Under normal storage conditions for up to two years in unopened tins.

STORAGE CONDITIONS

Do not store in areas exceeding temperatures of 86°F (30°C).

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 46°F (8°C) or higher than 86°F (30°C).

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Important notice

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