

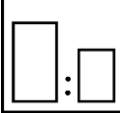


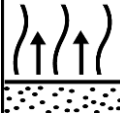
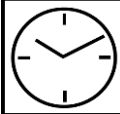




Technical Data Sheet

UHS Clear Coat 93 2:1
Art.nbr.: 9310

Clear Coats
Version: **EN-TDS-9310-7**
Revision: April 2015
Page: 1 of 6

FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

| | |
|---|--|
|  | <p>2 UHS Clear Coat 93 1 HS Hardener 83 Add, if necessary, 0-10% 2K PU ULTRA Thinner</p> |
|  | <p>Spray nozzle: 1.2 – 1.3 mm Pressure: 2.0 – 2.2 bar at the air inlet</p> |
|  | <p>Spray nozzle HVLP 1.2 mm Spray nozzle HVLP 1.3 mm Mist spray + 1 full coat Open mist spray + 1 full coat</p> |
|  | <p>Between spray coats After the last spray coat 5 – 10 minutes 5 – 10 minutes</p> |
|  | <p>UHS Clear Coat 93 2:1 60 °C HS Hardener 83 STD 30 minutes HS Hardener 83 Fast 15 – 25 minutes HS Hardener 83 Slow 30 – 40 minutes</p> |
|  | <p>Application viscosity Application- and object temperature 17 – 19 seconds (DIN CUP 4 mm / 20 °C) 18 °C – 30 °C</p> |
|  | <p>Potlife 4 hours at 20 °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



- 1 layer clear coat
- ULTRA High Solid product
- VOC Compliant
- Easy to use
- Excellent clearness

FIELD OF APPLICATION

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

KRISTAL UHS Clear Coat 93 2:1, is a non-yellowing high-gloss finishing finish. Easy to use and time saving because only 1¼ spray coats are needed to achieve 50-70 µm coat thickness. Air-drying and force-drying.

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PRODUCT AND AUXILIARY PRODUCTS

UHS Clear Coat 93 2:1

| | | |
|------------------------|---|--|
| Hardener | HS Hardener 83 STD HS Hardener 83 Fast HS Hardener 83 Slow | Drying time 30 minutes at 60 °C (object temp.) Drying time 15-25 minutes at 60 °C (object temp.) Drying time 30-40 minutes at 60 °C (object temp.) |
| Product to add | 2K PU ULTRA Thinners 2K Drying Booster | A thinner with which the right viscosity can be achieved Drying accelerator for Clear Coats and Surfacer |
| Article numbers | UHS Clear Coat 93 2:1 HS Hardener 83 STD HS Hardener 83 Fast HS Hardener 83 Slow 2K PU ULTRA Thinner STD 2K PU ULTRA Thinner Fast 2K PU ULTRA Thinner Slow 2K Drying Booster | 9310 8310 8311 8312 3130 3131 3132 3121 |

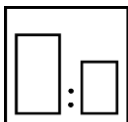
CHEMICAL BASIS

| | |
|---------------------------|------------------------|
| KRISTAL UHS Clear Coat 93 | Hydroxy-acrylic resins |
| KRISTAL HS Hardener 83 | Isocyanate resin |

SUBSTRATES

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

MIXING



- 2 KRISTAL UHS Clear Coat 93 2:1
 - 1 KRISTAL HS Hardener 83
- Add, if necessary, 0 - 10% KRISTAL 2K PU ULTRA Thinner

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APPLICATION VISCOSITY

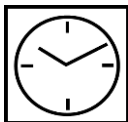


Application viscosity
17 – 19 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature
18°C – 30°C

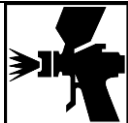
DRYING

All drying times relate to standard application and **object temperature**.



| | | UHS Clear Coat 93 | UHS Clear Coat 93 | UHS Clear Coat 93 |
|------|-------------|-----------------------|------------------------|------------------------|
| | | HS Hardener 83 STD | HS Hardener 83 Fast | HS Hardener 83 Slow |
| 20°C | Dust dry | 1 hour 15 mins | 1 hour | 1 hour 30 mins |
| | Fully cured | 8 hours | 7 hours | 9 hours |
| 60°C | Dust dry | --- | --- | --- |
| | Fully cured | 30 minutes | 25-30 minutes | 35-40 minutes |

EQUIPMENT SET-UP



Spray nozzle:
1.2 – 1.3 mm

Pressure:
2.0 – 2.2 bar at the air inlet

SPRAY COATS / LAYER THICKNESS

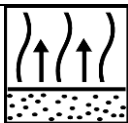


Spray nozzle HVLP 1.2 mm
Mist spray + 1 full coat

Spray nozzle HVLP 1.3 mm
Open mist spray + 1 full coat

Coat thickness 50 – 70 µm

FLASH-OFF



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

Maintain a flash-off of 5 – 10 minutes after the last spray coat

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POTLIFE



4 hours at 20°C

ECONOMY

12-14 m² per liter ready to spray clear coat (60 µm)

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 0,98 kg/l
Flashpoint : 23°C
Vol.% solids : 55,5%

VOLATILE ORGANIC COMPOUND

VOC CODE: **2004/42/IIB(d)(420)(418)**

Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready to use product IIB(d). Topcoat – All types. EU limit values: 420 g/l. (2007)
This product contains a maximum of 418 g/l. VOC

STORAGE LIFE

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

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 8°C or higher than 30°C.

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