

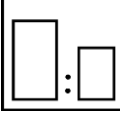


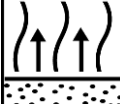






Technical Data Sheet

HS Surfacer USC Grey 4:1
Art.nbr.: 5240

Surfacers
Version: **EN_NA-TDS-5240-2**
Revision: July 2015
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FOR PROFESSIONAL USE ONLY

APPLICATION SHEET

	<p>4 HS Surfacer USC 1 HS Hardener USC Add, if necessary, 0 - 20% 2K PU Thinner PLUS</p>
	<p>Spray nozzle: 1.4 - 1.8 mm Pressure: 1.8 - 2.2 bar at the air inlet 26 - 32 psi at the air inlet</p>
	<p>1 - 3 spray coats</p>
	<p>5 - 10 minutes between the layers</p>
	<p>68°F / 20°C 140°F / 60°C 5 - 6 hours per layer 30 minutes</p>
	<p>Application viscosity 20 - 22 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 60 - 80 minutes at 68°F / 20°C</p>
	<p>Use suitable respiratory protection</p>
	<p>For full technical information, please read the complete Technical Data Sheet</p>

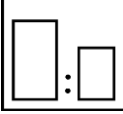


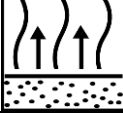
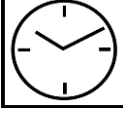




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APPLICATION SHEET <<WET-IN-WET>>

	<p>4 HS Surfacers USC 1 HS Hardener USC Add, if necessary, 0 - 20% 2K PU Thinner PLUS</p>
	<p>Spray nozzle: 1.4 - 1.8 mm</p> <p>Pressure: 1.8 - 2.2 bar at the air inlet 26 - 32 psi at the air inlet</p>
	<p>1 - 3 spray coats</p>
	<p>5 - 10 minutes between the layers</p>
	<p>68°F / 20°C 140°F / 60°C 18 hours (Thick layers / 7.8-9.8 mils / 200-250 µm) Do not dry thick layers (7.8-9.8 mils / 200-250 µm) at 60°C Wet-in-wet oversprayable after 15 minutes</p>
	<p>Application viscosity 20 - 22 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 60 - 80 minutes at 68°F / 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



- LOW VOC: 2.1 lb/gal
- Possible to spray wet-in-wet
- Excellent filling properties

FIELD OF APPLICATION

Car refinish.
Suitable for repair and new construction

KRISTAL HS Surfacer USC is a specially developed Surfacer to comply with VOC limit regulations issued by the *California Air Resource Board* and *Environment Canada*. KRISTAL HS Surfacer USC has a maximum VOC-content of 2.1 lb/gal. KRISTAL HS Surfacer USC 4:1, is a High Solid 2-pack surfacer with easy application. Air-drying and force-drying.

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PRODUCT AND AUXILIARY PRODUCTS

	KRISTAL HS Surfacer USC	
Hardener	KRISTAL HS Hardeners USC	
Product to add	KRISTAL 2K PU Thinners PLUS	A thinner with which the right viscosity can be reached
	KRISTAL 2K Drying Booster	Drying accelerator for Clear Coat and Surfacers
Article numbers	KRISTAL HS Surfacer USC Grey 4:1	5240
	KRISTAL HS Hardener USC STD	8240
	KRISTAL HS Hardener USC Fast	8241
	KRISTAL 2K PU Thinner STD PLUS	3110+
	KRISTAL 2K PU Thinner Fast PLUS	3111+
	KRISTAL 2K PU Thinner Slow PLUS	3112+
	KRISTAL 2K Drying Booster	3121

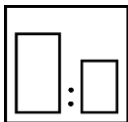
CHEMICAL BASIS

KRISTAL HS Surfacer USC 4:1 Hydroxyl acrylic resins
KRISTAL HS Hardener USC Isocyanate resin

SUBSTRATES

On top of Washprimer, fully cured old coatings and certain plastics, as described in the preparation system.

MIXING



- 4 KRISTAL HS Surfacer USC 4:1
 - 1 KRISTAL HS Hardener USC
- Add, if necessary, 0 - 20% 2K PU Thinner PLUS

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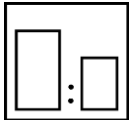
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MIXING

On weight

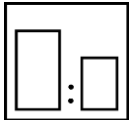


4:1

5240	KRISTAL HS Surfacer USC Grey	35 oz	992 gr
8240 - 8241	KRISTAL HS Hardener USC STD - Fast	6.3 oz	178.5 gr
3110 - 3111	KRISTAL 2K PU Thinner STD - Fast	max. 5.6 oz	max. 159 gr

MIXING

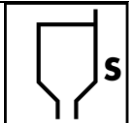
On volume



4:1

5240	KRISTAL HS Surfacer USC Grey	14 fl oz	414 ml
8240 - 8241	KRISTAL HS Hardener USC STD - Fast	3.5 fl oz	103.5 ml
3110 - 3111	KRISTAL 2K PU Thinner STD - Fast	max. 3.5 fl oz	max. 103.5 ml

APPLICATION VISCOSITY



Application viscosity
20 - 22 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:
1.4 - 1.8 mm

Pressure:
1.8 - 2.2 bar at the air inlet

26 - 32 psi at the air inlet

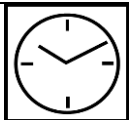
SPRAY COATS / LAYER THICKNESS



1 - 3 full spray coats

Layer thickness 2.4 - 7.1 mils / 60 - 180 µm

FLASH-OFF



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

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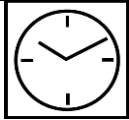
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POTLIFE



Approximately 60 – 80 minutes at 68°F / 20°C

DRYING



68°F / 20°C : 5 – 6 hours per layer
140°F / 60°C : 30 minutes

ECONOMY

86 ft² / 8 m² per liter with 2.4 mils / 60 µm, ready to spray surfacer

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 12,52 lb/gal / 1,5 kg/l
Flashpoint : >70°F / >21°C
Vol.% solids : 71-73%

VOLATILE ORGANIC COMPOUND

Compliant conform U.S. National Rule, California Air Resource Board (CARB) and Environment Canada.
Primer surfacer, U.S. EPA & OTC limit value 5.3 lb/gal VOC (630 g/L)
Primers, California Air Resource Board limit value 2.1 lb/gal VOC (252 g/L)
Primers, Environment Canada limit value 2.1 lb/gal VOC (252 g/L)

This product contains a maximum of 2.1 lb/gal VOC (252 g/L) in combination with KRISTAL HS Hardeners USC.

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).

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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).

KRISTAL COATINGS B.V.

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