
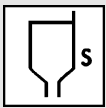




## 2K HS Clear


## 15-105

<b>Application:</b>	HS Clearcoat for basecoat / clearcoat systems Can be applied as an express 1.5 coat system -or- standard 2 coat system
<b>Properties:</b>	Higher solids content; Excellent sagging resistance; Good drying and polishing behaviour; Good quality finish.
<b>Remarks:</b>	Select hardener and reducer according to ambient temperature and size of object to be painted.



### 1. Application – Express 1.5 Coat System

	<b>Mixing ratio</b> 2 : 1 + 10%	100 Vol.%      15-105 50 Vol.%      75-52 HS Hardener Normal, -11 Fast, -13 Slow 10 Vol.%      85-02 Thinner Normal, -01 Fast, -03 Slow
	<b>Spray viscosity</b> <b>Pot life</b>	17 – 20s (DIN 4 / 20°C) 4 h. / 20°C
	<b>Number of spray coats</b> <b>Film thickness</b>	1.5 (light + Wet) 40 – 50 µm
	<b>Flash off at 20°C</b>	nil

### 2. Set-up

	<b>Spray gun</b>	1.3 – 1.4 mm 30 psi
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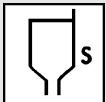

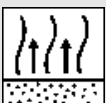
### 3. Drying

	<b>Drying @</b> <b>20°C</b> <b>60°C</b>	Overnight 30 min.
	<b>Infrared:</b> <b>short wave</b> <b>medium wave</b>	8 min. 10 - 15 min.


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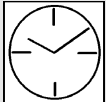

### 1. Application – Standard 2 Coat System

	<b>Mixing ratio</b> 2 : 1 + 10%	100 Vol.% 15-105 50 Vol.% 75-52 HS Hardener Normal, -11 Fast, -13 Slow 10 Vol.% 85-02 Thinner Normal, -01 Fast, -03 Slow
	<b>Spray viscosity</b> <b>Pot life</b>	17 – 20s (DIN 4 / 20°C) 4 h. / 20°C
	<b>Number of spray coats</b> <b>Film thickness</b>	2 40 – 50 µm
	<b>Flash off at 20°C</b>	5 minutes between coats

### 2. Set-up

	<b>Spray gun</b>	1.3 – 1.4 mm 30 psi
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### 3. Drying

	<b>Drying @</b> <b>20°C</b> <b>60°C</b>	Overnight 30 min.
	<b>Infrared:</b> <b>short wave</b> <b>medium wave</b>	8 min. 10 - 15 min.

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