Auto 2K HS Clearcoat
Polyurethane Clear Topcoat

PRODUCT DESCRIPTION
A two component (2K), polyurethane acrylic automotive refinish coating

INTENDED USES
Auto 2K HS Clearcoat is designed for application to suitably primed surfaces as a high performance finish for many applications, such as new work and repairs for automotive, wood and industrial finishing.

Auto 2K HS Clearcoat is used where outstanding durability & performance is required for OEM refinishing. A colourless Clearcoat for surfaces precoated with solvent and water based base coats

The HS Range offers high solids (high yield), excellent coverage and high performance.

CHARACTERISTICS
- Easy to use two component product spray applied
- Durable gloss with excellent flow
- Excellent weathering resistance
- Excellent UV Stability and gloss retention
- Excellent chemical resistance
- Excellent abrasion resistance
- Excellent adhesion
- Excellent hiding power
- High clarity clear finish

PRODUCT INFORMATION
<table>
<thead>
<tr>
<th>Colour</th>
<th>SA Car &amp; Truck colours, RAL, NCS, Pantone and SABS colours</th>
</tr>
</thead>
<tbody>
<tr>
<td>Finish</td>
<td>Gloss, satin and matt</td>
</tr>
<tr>
<td>Components</td>
<td>2</td>
</tr>
<tr>
<td>Mixing Ratio (volume)</td>
<td>2 : 1</td>
</tr>
<tr>
<td>Density</td>
<td>0.95 kg / litre</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>43%</td>
</tr>
<tr>
<td>Typical Film Thickness</td>
<td>20-25 microns dry</td>
</tr>
<tr>
<td>Typical Spreading Rate</td>
<td>17,2 m²/lt at 25 microns dry</td>
</tr>
<tr>
<td>Method of Application</td>
<td>Spray</td>
</tr>
<tr>
<td>Flash Point</td>
<td>23°C</td>
</tr>
<tr>
<td>Number of Coats</td>
<td>2 Normal</td>
</tr>
</tbody>
</table>

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**Auto 2K HS Clearcoat**

Polyurethane Clear Topcoat

### Drying Information

<table>
<thead>
<tr>
<th>Temperature</th>
<th>0°C</th>
<th>5°C</th>
<th>15°C</th>
<th>25°C</th>
<th>40°C</th>
<th>60°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Touch Dry</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>20 min.</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Hard Dry &amp; Polish</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>24 hrs.</td>
<td>-</td>
<td>1 hr.</td>
</tr>
</tbody>
</table>

### Overcoating Data – See Limitations

<table>
<thead>
<tr>
<th>Substrate Temp.</th>
<th>0°C</th>
<th>5°C</th>
<th>15°C</th>
<th>25°C</th>
<th>40°C</th>
<th>45°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>4 hrs.*</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Maximum</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Extended*</td>
<td></td>
</tr>
</tbody>
</table>

**Note**

*See Speccoats™ Definitions and Abbreviations

*Without Abrasion, can be over coated with Auto 2K HS Clearcoat. Light abrasion using sandpaper is required after 24 hours.

### CERTIFICATIONS

Consult Speccoats™ Technical Representative for details.

### SYSTEMS AND COMPATIBILITY

Can be applied direct to suitably primed surfaces. Application direct to metal is not recommended.

Consult Speccoats™ Technical Representative for coating system solutions.

### SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be cleaned and free from contamination. Prior to paint application all surface should be assessed and treated in accordance with ISO 8504:2000.

Apply Auto 2K HS Clearcoat on Speccoats approved solvent & water based basecoats.

Generally, the clear coat is applied directly after the basecoat has cured without any further surface preparation.

If any surface preparation is required, great care must be taken to not disturb the metallic or special effect pigments in the basecoat. If there is a likelihood of this happening it is advisable to recoat the basecoat before proceeding.

Consult Speccoats™ Technical Representative for coating system solutions.
APPLICATION

Mixing

Base component is supplied in one full container. It needs to be mixed with Auto 2K Hardener (2 Parts base to 1 Part Hardener)

Always mix according to specified mixing ratio. Once mixed the product should be used within the pot life specified.

Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the Auto 2K Hardener. Continue stirring until the mixture is homogeneous.

Ensure that sufficient material be mixed so that the product can be applied within its use-able life.

The temperature of the mixed product should preferably be above 10°C, otherwise extra solvent may be required to obtain application viscosity.

Too much solvent results in reduced sag resistance and slower cure.

Thinner should be added after mixing both component’s.

APPLICATION

Pot Life

4 Hours @ 25°C

Thinner

Thinner 200 or 2K Thinner 0-100% depending on Application. Typical application viscosity is between 16-18 seconds Ford 4 @ 25°C

Air Spray

Recommended Gun Pressure/Gravity Feed

Fluid Tip 1.1 mm to 1.3 mm

Method

Apply 1 + 1 full coats allowing 5-15 minutes flash off between coats (consult with Speccoats for Auto Application Terminology)

Work Stoppage

Thoroughly flush all equipment with Lacquer Thinner 200. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered and viscosity re-adjusted before being used.

Clean Up

Clean all equipment immediately after use with Lacquer Thinner 200. It is good working practice to periodically flush out the spray equipment during the course of the working day. Frequency of cleaning will depend upon the amount sprayed, temperature and elapsed time, including delays.
Environment | Surface Temperature | Ambient Temperature | Relative Humidity
---|---|---|---
Minimum | 5°C* | 5°C | No lower limit
Maximum | 45°C | 45°C | 85%

*Or 3°C above the dew point

LIMITATIONS
- In the case of drying at temperature below 60°C, when the full hardness of the film is not yet achieved, aggressive conditions (washing, rain, heavy humidity, condensation, dew and smog, detergents etc.) should be avoided.
- This product is not recommended for use in continuous immersion conditions.
- Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Speccoats™ representative for specific recommendations.
- Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures.
- Test performance results were obtained in a controlled laboratory environment and Speccoats™ makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating.

UNIT SIZE

<table>
<thead>
<tr>
<th>Volume</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.5 Lt</td>
<td>500 ml</td>
</tr>
<tr>
<td>1.0 Lt</td>
<td>1 Lt</td>
</tr>
<tr>
<td>5.0 Lt</td>
<td>5 Lt</td>
</tr>
</tbody>
</table>

STORAGE

Shelf Life | 12 months at 25°C – from date of manufacture. Subject to inspection thereafter. Store in dry conditions out of direct sunlight away from source of heat or ignition. Store at temperature between 5 and 35°C

DISCLAIMER

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user’s responsibility to ensure that this sheet is current prior to using the product.

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