

LABONAL 2K HP CLEARCOAT (2²1) (**GOLD LINE**)

For Professional Use Only

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

LABONAL 2K HP Clearcoat (2²1) is based on an high performance Acrylic Urethane resin with excellent mechanical and physical properties.

DESIGNED USAGE:

Ideally suitable for Car Refinish and Commercial Vehicles by spray application, ranging from touch-up repairs to full body spraying.

SUITABLE SUBSTRATES:

1K solvent-borne and water-borne base coat systems alongside 2K cured Top Coats after de-nibbing with 2000 grade sandpaper. Can also be used in a wet-on-wet system.

Note: Please follow recommended flash-off and re-coating time mention for the base coat.

FEATURES:

- Excellent gloss
- Ease of application
- Extremely Versatile
- Excellent speed of drying
- Excellent polish-ability
- Excellent flow and mar resistance
- Excellent chemical and weather resistance
- Excellent UV protection

HARDENER USE:

We strongly suggest the use of LABONAL PU HP Hardener ONLY for desired results

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TECHNICAL DETAILS:

Features	Attribute
Appearance	Smooth and Free Flowing
Color	Clear Transparent
Binder	Acrylic Polyol Based
Supply Viscosity of Clear (DIN F4)	@30°C 15–16 Secs/@20°C: 14–15 Secs
Specific Gravity	0.98
Flash Point	26°C/ 78.8 °F
Volatile Organic Compound (VOC)	The VOC content in ready to use form is a maximum of 576 g/ liter (4.80 lb/gallon)
Recommended Thinner	PU thinner (Slow/Medium/Fast) (Depending on Ambient temperature)
Pot Life with 10% Thinner	@20°C (77°F): 8 hours @30°C(95°F):6 hours @40°C(104°F): 4 hour
Theoretical Coverage	Under Laboratory conditions the coverage is approximately 7–8 sq.m / litre RTS at 50 microns - Dry film thickness

Note:- For practical coverage: material usage depends on many factors, i.e. shape and size of the object, roughness of the surface, application technique, pressure and application circumstances.

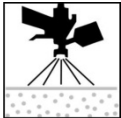
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PRODUCT PREPARATION/APPLICATION GUIDE:



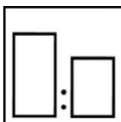
It is strongly recommended to use appropriate personal protection equipment (PPE) during application to avoid respiratory, skin and eye irritation.



Fresh Basecoat: Surface must be dried/ flashed off as per TDS before application.



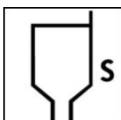
For Existing finishes: Surfaces must be thoroughly sanded and degreased before application.



LABONAL HP Clear Coat 2 ² 1	100 parts
LABONAL HP Hardener	50 parts
PU Thinner	20-25 parts



Pot life @ 20°C: 8hours
@ 30°C: 6 hours
@ 40°C: 4 hours



ISO CUP 4mm:
@ 20°C 16–18 sec
@ 30°C 14–16 sec

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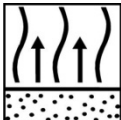
Gravity Feed:
Nozzle size: 1.3–1.4 mm
Air Pressure: 2 bar
(28 psi at spray gun air inlet)

Suction Feed:
Nozzle size: 1.5–1.7 mm
Air Pressure: 2 bar (28 psi)

HVLP:
Nozzle size: 1.5–1.7 mm
Air Pressure: 2 bar (10 psi at the air cap)



Apply 2 medium coats



5–7 minutes flash off between coats and 10–12 minutes before oven baking



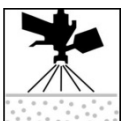
Air Dry @30°C–12 to 14 hours
Oven Bake @60°C–30 min (EMT)



Shortwave IR:
Half power: 5 min
Full power: 15–20 min



DFT after 2 coats: 45–50 microns



Labonal 2K HP Clear Coat can be recoated within 24 hours, without intermediate sanding/scuffing

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Clean spray gun after use with a suitable solvent based cleaner

REMARKS:

- Material should always be used above 25°C before application.
- In cold conditions, it is suggested to pre-heat the metal surfaces up to 25°C.
- After using the clear and hardener, ensure the cans are re-sealed as tightly as possible since the products are sensitive to moisture in the atmosphere, and hence may lose its reactivity thereby leading to soft film, adhesion issues, and low gloss.
- Excess mixed material, if not consumed, should be disposed-off as per local rules and regulations. It should not be added to the original container, or re-packed for further use.

POLISHING:

Dust and minor imperfections can be polished off after thorough air-drying as per the recommended time, or after 1–2 hours cooling down when bake at 60°C (EMT).

Carefully de-nib dust particles and restore the surface accordingly by recommended polishing compound to achieve full gloss.

SAFETY, STORAGE AND ENVIRONMENT:

Respiratory Protection:	Use suitable respiratory protection. Labon Paints always recommends fresh Air supply masks. <i>* For further details please refer MSDS of product.</i>
Product Storage:	Minimum Storage Temperature: 5°C Maximum Storage Temperature: 40°C
Shelf Life	1 year in original sealed containers.

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Packaging Size:

LABONAL 2K HP Clearcoat LGC7000: 1 Litre (JG22CG94001) and 5 Litre (JG22CG97001)

USE LABONAL PU HP Hardener LGH7000 ONLY for desired results: 500 ml (JG2HPH93001) and 2.5 Litre (JG2HPH95001)

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on extensive laboratory testing, trials, and practical experience. However, as the product may be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without prior notice. Minor product specifications may be updated without prior notice in order to comply with local requirements, rules, and regulations.

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