

HS Clear coat

HS Klarlack

D323



Shelf life: 24 months
Color: transparent
Pack: 5 l, 1 l
EU/2004/42 Cat II B(e) VOC 540 g/l
(VOC limit 840 g/l)










Properties

Two-pack High solids Clear coat D323 builds high-quality crystal coating with perfect gloss and toughness. D323 prevents the paint from discoloration because of the high UV resistance and decreases running costs due to excellent scratch-resistant properties.

Usage tips

D323 should be used with Elastic Additive D101 (see p. 23) when applied on plastics.



Substrates			
	Solvent- or waterborne basecoats		
Mixing ratio		By volume	By weight
	HS Clear coat D323	100 ml	100 ml
	HS Hardener D220	50 ml	50 ml
	Uni Thinner D110	0-10 ml	0-10 ml
Viscosity (DIN 4, at 20 °C)			
	18 sec		
Pot-life (at 20 °C)			
	4 h		
Application		Gun tip	Pressure
	Gravity gun	1,3-1,4 mm	3-4 bar
		HVLP gravity gun	1,3-1,4 mm
	Number of coats	1,5-2	
	Recommended thickness	50-60 microns	
	Humidity	≤ 75%	
	Temperature	+15 °C...+30 °C	
Flash-off time (at 20 °C)			
	10-15 min (between coats) 15 min (before forced drying)		
Drying times		at 20 °C	at 60 °C
		12 h	30 min
IR drying (short waves)			
	12 min		