

Diamond Cut Clear Coat

Technical Data Sheet

Item no.	Product description
842	Diamond Clearcoat 1L
844	Diamond Clearcoat Activator 1L
843	Diamond Clearcoat Thinner 1L
845	Diamond Clearcoat (Clearcoat 1L, Hardener 1L, Thinner 1L & mixing cups)

High gloss Clear coat especially for direct to metal applications such as diamond cut alloy wheels. Has excellent adhesion, long pot life and contains no isocyanates

Processing instructions

Mixing ratio

Mix ratio is 1:1:1

842 - DIAMOND CLEARCOAT 1L

844 - DIAMOND CLEARCOAT ACTIVATOR 1L

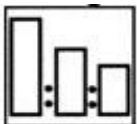
843 - DIAMOND CLEARCOAT THINNER 1L

* by volume.

or 1:1:1 842 - DIAMOND CLEARCOAT 1L: 844 - DIAMOND CLEARCOAT ACTIVATOR 1L + 50% 843 - DIAMOND CLEARCOAT THINNER 1L by volume.

For example mixes see below.

Volatile Organic Content (mixed) 680 g/L

*Total mixed paint required	90ml	180ml	300ml
			
842 - DIAMOND CLEARCOAT 1L	30ml	60ml	100ml
844 - DIAMOND CLEARCOAT ACTIVATOR 1L	30ml	60ml	100ml
843 - DIAMOND CLEARCOAT THINNER 1L	30ml	60ml	100ml

Preparation

Ensure all surfaces to be coated are dry and free from any grease and other contamination

Application

Can be sprayed over many water and solvent-based base-coats. Use conventional spray application to a dry film thickness of 20-35 microns in two coats. We recommend a substrate temperature between 15 and 25o C. Flash off for 2 mins between coats at 20o C. Flash off for 5 mins at 20C before curing

Pot life

Approx. 7 h at 20°

Drying time

Cure for 15-20 mins at 60°C substrate temperature IR Curing: 10-15 mins @20cm distance using 1KW lamp. Allow to cool to ambient temperature before exposing to external environment.

Coverage

12.5 m2 per mixed litre (assuming 100% transfer efficiency) at 25 micron dry film thickness

Notes

Storage: at least 1 years in original and unopened containers
Processing conditions: from +10° C and up to 80 % humidity