

# 491 AUTO CLEAR HS 2:1

Technical Data Sheet No 204



High solid clear coat suitable for full body repairs or spot panel repairs

Great gloss retaining

Excellent mechanical and high chemical resistance

Excellent physical properties

## General Technical Description



Mix 2 parts AUTOCLEAR 491 HS with 1 part 730 AUTO HARD HS STANDARD HARDENER



Thinner addition 20-25% HB BODY 741 ACRYLIC SLOW THINNER / REDUCER



45 min / 60°C (140°F) panel temperature



8-10 min distance: 60 - 70cm

## Surface

- HB BODY Color Solutions Basecoat Mix System

- HB BODY Color Solutions 2K Acrylic Mix System

- HB BODY Color Solutions Aqua Basecoat Mix System

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

**Product Application:** 2 coats. Apply one coat, and after flash off time apply the second full coat.



2:1 mix with 730 AUTO HARD HS STANDARD HARDENER  
Pot life: >7h / 23°C (73°F)



10 min / 23°C (73°F)  
Flash off time

**Flash Point:**  
29°C / 84°F

**Specific Gravity:**  
0.995 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
54% Weight

**VOC (2004/42/EC)**  
This product is designed to meet the market outside Europe, where the VOC legislation does not apply

**Theoretical Coverage:**  
6 - 7m<sup>2</sup> / l at 40 micron dry film thickness

**Cleaning of equipment:**  
Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with 730 AUTO HARD HS STANDARD HARDENER and 741 ACRYL SLOW THINNER.
- It can only be used by countries that do not adopt the VOC legislation

### Storage shelf life:

- Store in a cool place +5°C - +25°C (+41°F - +77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.



Addition 20-25% of thinner. Use 741 SLOW ACRYL SLOW THINNER / REDUCER



16 - 24hrs / 23°C (73°F)  
45 min / 60°C (140°F) panel temperature



Ready to spray:  
16-18 s  
DIN 4 / 20°C (68°F)



Short wave 8 - 10 min  
distance: 60 - 70cm



Compliant Spray gun  
1.3 - 1.5mm  
2 - 3 bar (29 - 44psi)  
2x coats = 40-50µm  
(1.6 - 2mil)



Always wear protective equipment



HVLP 1.2 - 1.3 mm  
2 bar (30psi)  
2x coats = 40-50µm  
(1.6 - 2mil)



Follow the application instructions mentioned in this TDS

**2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.**

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.