

# **491 AUTO CLEAR HS 2:1**

Technical Data Sheet No 204

High solid clear coat suitable for

full body repairs or spot panel

Excellent mechanical and high

Excellent physical properties

Great gloss retaining

chemical resistance





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.



repairs

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/cm3

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:

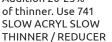
• Store in a cool place +5°C - +25°C (+41°F - +77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

Addition 20-25% of thinner. Use 741

Ready to spray:

DIN 4 / 20°C (68°F)

16-18 s





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



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)



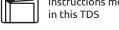
Always wear protective equipment



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



Follow the application instructions mentioned



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.

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