

C 494 CLEAR ULTRA HS 2:1

Technical Data Sheet No 203



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

Extremely high gloss

Excellent mechanical and high chemical resistance

Excellent surface finish

VOC compliant with the regulations

General Technical Description



Mix 2 parts C 494 CLEAR ULTRA with 1 part H 733 SLOW / H 734 NORMAL / H 735 FAST HARDENER



No thinner / reducer addition



20-40 min / 60°C(140°F) panel temperature **



8-15 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: 1.5 coats . Apply a mist coat, and after flash off time apply the second full coat.



2:1 mix with H 733 SLOW / H 734 NORMAL / H 735 FAST HARDENER
Pot life: 1.5 - 3h
23°C (73°F)



5-10 min / 23°C (73°F) Flash off time
10 - 15min / 23°C (73°F) Final Flash off time with spray booth recirculation

Flash Point:
24°C / 75°F

Specific Gravity:
0.990 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with **H 733 SLOW, H 734NORMAL, H 735 FAST HARDENER**
- It can also be used by countries that do not adopt the VOC legislation



No thinner / reducer required



16-20h / 23°C (73°F)
20 - 40 min / 60°C (140°F) **

Solid Content (No thinner):
55% Weight

VOC (2004/42/EC)

This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 420 g/L. The VOC content in ready for use form of this product is 410 g/L.
2004/42/IIB(d)(420) 410

Storage shelf life:

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



Ready to spray:
17-19 s
DIN 4 / 20°C (68°F)



Short wave 10-15 min (short wave)**
8-15 min distance: 60 - 70cm



Compliant Spray gun
1.3 - 1.4mm
2-3 bar inlet pressure (29-44 psi)
1.5 x coats = 50-60µm (2 - 2.40mil)



Always wear protective equipment



HVLP 1.2 - 1.3 mm
2 bar inlet pressure (29psi)
1.5 x coats = 50-60µm (2 - 2.40mil)



Follow the application instructions mentioned in this TDS

Theoretical Coverage:

9 - 10m² / l at 60micron (2.4 mil) dry film thickness

Cleaning of equipment:

Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER

Application conditions*

For partial or spot repairs:

T = 15-20°C use H 735 Fast Hardener
T = 20-30°C use H 734 NORMAL Hardener
T = 30-35 °C H 733 Slow Hardener
Rel. humidity 40 - 80%

For complete car repair:

T = 20-35°C use H 733 Slow Hardener
Rel. humidity 40-80%

** Depends on hardener and thickness of the clear coat (sug. 50-60µm (2 - 2.4 mil))

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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