

C 898 CLEAR ULTRA HS 2:1

Technical Data Sheet No 228



Ultra high solid fast clear coat suitable for full body or spot panel repairs

Excellent mechanical and high chemical resistance

Excellent surface finish

Great gloss retaining

VOC compliant with the regulations

General Technical Description



Mix 2 parts C 898 CLEAR ULTRA with 1 part H 738 NORMAL / H 737 SLOW HARDENER



Addition 5-10% of thinner / reducer . Use 740 ACRYL NORMAL THINNER / REDUCER



5 - 10 min / 60°C (140°F)
25 - 30 min / 40°C (104°F)
panel temperature



6-8 min**
distance: 80cm

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 half coat, and after flash off time apply the second full coat.



2:1 mix with H 738 NORMAL / H 737 SLOW HARDENER
Pot life: 90 - 120 min
23°C (73°F)



4 - 6h / 23°C (73°F)
5-10 min / 60°C (140°F)
25-30 min / 40°C (104°F)
panel temperature

Flash Point:
27°C / 81°F

Specific Gravity:
1,0 g/cm³

Solid Content (No thinner):
57,7% 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 the ready for use form of this product is 415 g/L.
2004/42/IIB(e)(420) 415

Theoretical Coverage:
10 - 12m² / l at 50 micron (2 mil)
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 H 738 NORMAL / H 737 SLOW HARDENER
 - It can also be used by countries that do not adopt the VOC legislation
 - 2K paint systems tend to react with water, hence all the equipment used must be moisture free.
- 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



Addition 5-10% of thinner / reducer. Use 740 ACRYL NORMAL THINNER / REDUCER



6-8 min**
Flash off time before 10 min



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



Always wear protective equipment



Compliant Spray gun
1.3 - 1.4mm
2 - 3 bar (29-44psi)
inlet pressure
1.5 x coats = 50-60µm
(2 - 2.4 mil)



Follow the application instructions mentioned in this TDS



HVLP 1.2 - 1.3 mm
2 - 2.5 bar (29-36psi)
inlet pressure
1.5 x coats = 50-60µm
(2 - 2.4 mil)



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

Temperature	Partial Repair	Full Repair
15 - 25°C	H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)	H737/H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)
25-35°C	H737/H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)	H737+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)

*After force drying and 20-30min cooling phase polishing possible or after 5h air drying. Flash of time between coats and before baking 5-10min.

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

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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