

C 894 CLEAR ULTRA HS 2:1

Technical Data Sheet No 228



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

Great gloss retaining

Excellent mechanical and high chemical resistance

Excellent surface finish

VOC compliant with the regulations

General Technical Description



Mix 2 parts C 894 CLEAR ULTRA with 1 part H 733 SLOW / H 734 NORMAL / H 735 FAST HARDENER



No thinner / reducer addition



25-40 min / 60°C (140°F) panel temperature **



12-18 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 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: 90 - 135 min
23°C (73°F)



0 - 2 min / 23°C (73°F) Flash off time
10 - 15min / 23°C (73°F) Final flash off time with spray booth recirculation

Flash Point:
27°C / 81°F

Specific Gravity:
0.977 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with H 733 SLOW / H 734 NORMAL / 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)
25-40 min / 60°C (140°F) panel temperature

Solid Content (No thinner):
57.5% 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 419 g/L. 2004/42/II(d)(420) 419

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:
18-20 s
DIN 4 / 20°C (68°F)



Short wave**
Flash off time before 5 min
Half power 5 min
Full power 12-18 min distance: 80cm

Theoretical Coverage:

10 - 12 m² / l at 50 micron (2 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 (59-68°F) use H 735 Fast Hardener
T = 20-30°C (68-86°F) use H 734 Normal Hardener
T = 30-35 °C (86-95°F) use H 733 Slow Hardener
Rel. humidity 40 - 80%

For complete car repair:

T < 25°C (77°F) use H734 Normal Hardener
T = 25-35 °C (77-95°F) use H 733 Slow Hardener
Rel. humidity 40-80%



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



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS

** 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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