

TECHNICAL DATA SHEET

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**Product Name: Two-Component Acrylic Clear Lacquer
APP Klarlack UHS 410.
APP No.: 020135-1.0L and 020136-5.0L.**

Two-component low-emission, quick drying acrylic Premium class clear lacquer. It features with high content of solids up to 59% and VOC below 410 g/L. It provides optimal drying and application during repairs of single components and whole car body. It offers very good levelling properties, easy application and polishing. It ensures high gloss and base coat colour fastness.

Packing:	Lacquer-10L, 5.0L; Hardener-0.5L, 2.5L.
Product and additives:	APP Klarlack UHS 410 - a clear lacquer, APP Harter Klarlack UHS 410 Standard - a hardener of standard setting time, APP Harter Klarlack UHS 410 Quick - of short setting time,.
Special additives:	APP Loser - a thinner for blending in, APP Anti-Silikon - an additive neutralizing effects of silicone related contamination.
Basic components:	APP Klarlack UHS 410 - an acrylic resin, APP Harter Klarlack UHS 410 - Isocyanate hardeners.
Colour:	Transparent, colourless, of high gloss.
Specific gravity:	0.99 kg/dm ³ at +20°C.
Coverage:	9 m ² /l for 2 x 1 (at 50µm dry coat). Caution! In practice coverage depends on different factors including: shape, substrate roughness, application method and operating conditions.
<u>Use:</u>	Purposed for repairs of both parts and whole car bodies, to be applied as high quality top Premium layer in case of car body two coats systems. To be used with water borne and traditional basecoats paints.
<u>Substrate:</u>	Water borne and traditional basecoats paints, old top coats.

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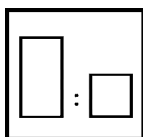
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Preparation of substrate: Before spraying firstly clean the surface to remove any loose particles and base coat dry paint dust with APP SAS dust cloth. Dull the old coat on dry with P800 or APP PM07 dulling paste and APP WS222 grey or gold abrasive, then clean to remove dust and degrease.
In case of relative humidity above 70% and at temperature below +10°C drying is recommended at temperature +60°C.

Use

Mixing ratio:



- A) At temperature over +18°C:
2 by volume APP Klarlack UHS 410
1 by volume APP Harter Klarlack UHS 410 Standard
- B) At temperature below +18°C:
2 by volume APP Klarlack UHS 410
1 by volume APP Harter Klarlack UHS 410 Quick
- C) Mixing ratio by weight:
100 APP Klarlack UHS 410
52 APP Harter Klarlack UHS 410

Volume of ready product for 0% of thinner	Mixing ratio by weight		
	APP Klarlack UHS 410	APP Harter Klarlack UHS 410	(Option) APP Acryl Verdunnung
	100	52	5%
[L]	[g]	[g]	[g]
0.1	66.0	34.3	4.36
0.2	132	68.7	8.71
0.3	198	103	13.1
0.4	264	137	17.4
0.5	330	172	21.8
0.6	396	206	26.1
0.7	462	240	30.5
0.8	528	275	34.8
0.9	594	309	39.2
1.0	660	343	43.6

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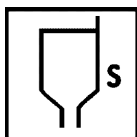
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Spraying viscosity at +20°C: 18-19 s 4 mm CF.

Caution!

Use hardeners purposed for APP Harter Klarlack UHS 410 acrylic lacquer.

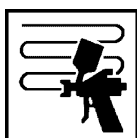
Follow strictly specified hardener volume.

If necessary add 2 to 5% of APP Anti-Silikon.

Application:

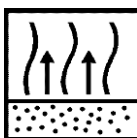


Apply with a spray gun fitted with $\varnothing 1.2$ - $\varnothing 1.4$ mm nozzle at air pressure from 2.0 to 2.5 bar.

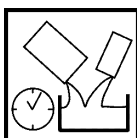


Coat qty: 2 x 1.

Dry coat thickness: 50-60 μm (2 x 1).

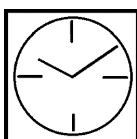


Evaporation time between coats at temperature +20°C:
- 5-10 min.



Workability time of lacquer mixture:
- 1.0-1.5 h.

Drying



At temperature +20°C:

Dust dry: 15 min.

Touch dry: 1.0 h

Dryness to touch: 1.5-2.5 h.

Polishing: 8,0 h.



At temperature +60°C: 10-15 min.

Polishing: 1.0 h upon cooling down.

IR radiator:

Pulsating (flash off): 3 min.

Continuous (full bake): 8-10 min.

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Sanding



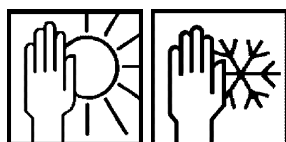
Following 8 h at temperature +20°C removal of defects and inclusions is possible with abrasives and polishing:

- on wet manually with P1500-3000 sandpaper
- with machine using P1500-3000 sandpaper.

Tool cleaning:

Clean with nitrocellulose or acrylic thinner.

Storage:



Store in closed, original containers, in dry and well ventilated spaces at temperature from +5°C to +30°C.

Occupational safety:



Product for professional use only.
See: labels on containers and MSDS.
User shall follow locally and regionally applicable industrial safety regulations.

VOC:

Permitted VOC in g/L of product ready to use:

420 g/L for APP Klarlack UHS 410.

Maximum VOC in g/L of product ready to use:

410 g/L for APP Klarlack UHS 410.

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