



### GENERAL INFORMATION:

SP4796 HS Clear Coat 2:1 is a acrylic copolymer general refinishing clearcoat. For panel, spot repairs and complete resparys, easy to polish, easy to apply good chemical resistance and gloss retention. For application over refinish basecoat.



### COMPONENTS:

SP4796 HS Clear Coat 2:1  
 SP2750 HS Hardener Medium  
 SP2760 HS Hardener Fast  
 SP3749 Thinner Medium



### SUBSTRATES:

Solvent and water basecoat  
 Properly cleaned and sanded OEM finishes



### SURFACE PREPARATION:

\* Basecoat should be fully dry



### MIXING RATIO:

2 : 1 Clear : Hardener + 15 - 20% Thinner



### GUN SET UP:

	opening(mm)	air pressure bar / psi
HVLP	1.3 - 1.5	0.7 bar at the Aircap
HE	1.3 - 1.5	2 bar / 28 psi



### APPLICATION:

2 coats 40 - 60 microns / 1.57 - 2.36 mils



### POT LIFE at 20°C / 68°F

4 hours



### FLASH OFF at 20°C / 68°F

5 - 10 minutes in between coats  
 5 minutes before bake



### DRY TIMES:

	Hardener	Flash off (min.)	Dust free (min.)	Dry to handle (min.)	Dry to polish (min.)
Air Dry 20°C (68°F)	SP2750	x	30	6 hours	Overnight
Forced Dry 60°C (140°F)	SP2750	5	x	30	After cooling down
Air Dry 20°C (68°F)	SP2760	x	20	4	Overnight
Forced Dry 60°C (140°F)	SP2465	5	x	x	After cooling down



### INFRA RED\* DRYING TIMES:

Drying time:		* Guideline for short / medium wave infra red equipment.
Flash off time	5 mins	
Distance	80 cm	
1/2 power	5 mins	
Full power	15 - 20 mins	



### CLEAN UP:

Gun Cleaner

Chemical base	2-Component acrylic copolymer resins	
Physical properties	Viscosity	16-18 sec / Din4 / 20° C
	Specific gravity (g/l)	0.983
	Flash point closed cup	31,5°C / 88,7°F
	Vol. % solids	52
	Economy	8.7 m <sup>2</sup> /L/60 µm
		88.3 ft <sup>2</sup> /qt/2.36 mil
	Gloss	High Gloss
Colour	Clear	

### STORAGE / SHELF LIFE:

Under normal storage conditions 10 - 30°C / 50 - 90°F up to two years (unopened container).



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).