

TECHNICAL DATA SHEET

Updating Date: 12/02/2024

Version: 6

(**)Indicates changes from the previous version

SECTION 1. IDENTIFICATION OF THE PRODUCT

1.1 Product identifier: Clear coat HSA 2K- 5Lt. (VOC)

Other forms of identification: **010014**

1.2 Details of the supplier of the technical data sheet: (See FDT headline).

1.3 Emergency telephone: 93 860 49 23 (8:00 - 17:30).

SECTION 2. DESCRIPTION

Clear coat HSA has been formulated for both water and solvent based bi-coat systems for spot repairs.

It stands out for its excellent gloss finish, extensibility and hardening speed, making possible to have the vehicle operational 40' after the application of the clearcoat without need of heating the booth. This can generate very significant savings in the painting cycle and an increase in the productivity.

A 10 min drying process can be done in the booth at 60°C or at 40°C for 20'. The drying time by IR is only 5 minutes. HSA clearcoat can be polished approximately 1 hour after drying.

It has a high resistance to UV rays, abrasion and chemical agents.

SECTION 3. PHYSICAL PROPERTIES

Properties	Values and units
Colour:	Colourless
Density at 20°C (g/cc):	0,98 ± 0,02
Supply viscosity at 20°C:	24 - 28 sec. Ford n°4
% Solids content (weight/ volume):	52.5% ± 2 weight; 43% ± 2 vol. (mixed with hardener)
V.O.C. (g/l):	<420 (ready to use) – (2004/42/CE) IIB (D) (420)

SECTION 4. SURFACE PREPARATION

The surfaces to be repaired must be properly primed, filled, sanded and degreased. It is recommended to use a dust cloth before the application of the clearcoat.

When using water-based undercoats it is very important to ensure that the water has completely evaporated before applying the clearcoat.

Spray directly over the basecoat (both solvent and water-based) after at least 30 min. from its application.

SECTION 5. APPLICATION METHOD

Best results are achieved with 1.2mm fluid peak. Apply two crossed-coats with an interval of 5 to 7 min. to allow flash-off.

It can be used between 5°C and 35°C. The product has been tested in extreme humidity and heat conditions.

The application must be done in the 30 min. lapse after mixing of both components.

Hardener:

- 010015 Fast hardener HSA



Mixing ratio:

Volume: 2:1

Weight: 100:52



Pot-life: 30'



Application viscosity: 18-20"

% Dilution: Thinner is not required.



Gravity gun: 1,2 mm

Application pressure: 2-2,5 bar.



Number of coats: 2 coats

Total thickness: 50-60 µm



Flash time:

5-7 between coats.

20' before accelerating drying.



Drying time:

20°C: 40'

IR Medium wave: 5'

60°C: 10'



Polishing (after drying in each case):

20°C / IR Medium wave / 60 °C: 1h.

Mixing ratios:

	Clear Coat	Hardener
100 gr	66	34
250 gr	165	85
500 gr	330	170
1000 gr	660	340

SECCIÓN 6. DRY FILM FEATURES

Theoretical yield (m²/l):	7,5-8,5 (50-60 µm)
Gloss 60°-60°:	100%
Second layer:	24h

SECTION 7. STORAGE AND SAFETY

- The use of appropriate personal protective equipment is recommended during application, to prevent the irritation of the respiratory tract, skin and eyes.
- For professional use only.
- Keep in a tightly covered container, in a dry and ventilated place, avoiding direct exposure to sunlight.
- Temperature above 5°C is recommended, between 15 and 30°C optimal.
- Can life: At least 2 years since manufacturing date in adequate storing conditions.

The technical information is based on our experience. We guarantee the quality of the product; however, as the conditions of use are not under our control, we cannot assume any responsibility for the results obtained.