

# 2K Clearcoat 268 HS




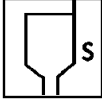

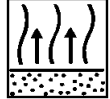


Technical Data Sheet

December 2004



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**Description** A complete 2 component High Solid clear system, suitable for use on all types of repairs and in most application conditions. Gives high quality results with a brilliant gloss level at an economical price. Two coat application maximizes paint shop efficiency.

 <p>2:1+10% - 2K Clearcoat 268 HS - 2K Hardener 720 (any) - Multi Thinner 810 (any)</p>	 <p>14-16</p>	 <p>2*1 Conventional (gravity feed) 1.2-1.5 mm 3-4 bar HVLV (gravity feed) 1.3-1.5 mm max 0.7 bar at cap</p>	 <p>8-12 mins.</p>	 <p>10-12 hrs. 20°C. 40-50 mins. 60°C</p>	
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## Product & ancillary items

**Product** Lesonal 2K Clearcoat 268 HS  
Lesonal 2K Hardener 720 (any)

### Thinners

Lesonal Multi Thinner 810-B Temperature range <20°C–30°C → panel and spot repair.  
Temperature range <20°C → multi panels and total respray.

Lesonal Multi Thinner Fast 810-C Temperature range >30°C → panel and spot repair.  
Temperature range 20°C–30°C → multi panels and total respray.

Lesonal Multi Thinner HT 810-CC Temperature range >30°C → multi panels up to total respray.

**Basic Raw Materials** 2K Clearcoat 268 HS – Acrylic Polyurethane resins  
720 Hardeners – Poly-isocyanate resins  
Multi Thinners 810 – A blend of organic solvents

### Method of use

<b>Suitable Substrates:</b>	Lesonal Basecoat SB MM 120
<b>Mixing Ratio by Volume:</b>	<ul style="list-style-type: none"> <li>- 2 parts of 2K Clearcoat 268</li> <li>- 1 part of 2K Hardener 720 (any)</li> <li>- 10% Multi Thinner 810 (any)</li> </ul> <p>Use Mixing Stick D</p>
<b>Spraying Viscosity:</b>	14-16 s DIN Cup 4 at 20°C
<b>Potlife:</b>	<ul style="list-style-type: none"> <li>- 6 hrs. at 20°C with 2K Hardener 720-B</li> <li>- 7 hrs. at 20°C with 2K Hardener 720-C</li> <li>- 7 hrs. at 20°C with 2K Hardener 720-CC</li> </ul>

<b>Spray Gun Fluid Tip and Working Pressure:</b>	<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>	
	Gravity Feed	1.2-1.5 mm	3-4 bar	
	Suction Feed	1.4-1.6 mm	3-4 bar	
	Pressure Feed	1.1-1.2 mm	5-6 bar	
	HVLP Gravity Feed	1.3-1.5 mm	max 0.7 bar at the air-cap	
	HVLP Suction Feed	1.5-1.7 mm	max 0.7 bar at the air-cap	
<b>Application Technique:</b>	Spray 2 single wet coats, allowing for a flash-off time of 8-12 minutes between the coats. Allow 10-15 minutes flash off before baking at 60°C.			
	Note: The specified flash-off times depend on temperature and air velocity.			
<b>Film Thickness:</b>	25-35 µm per coat			
<b>Material Usage:</b>	Taking into account a transfer efficiency of 70%, the theoretical material usage for one layer is 8 m <sup>2</sup> /lt ready to spray mixture which calculates to 13 m <sup>2</sup> /lt un-thinned paint at 35µm.			
	Note: The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.			
<b>Equipment Cleaning:</b>	Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820			
<b>Drying Times at 20°C:</b>		<b>720-B</b>	<b>720-C</b>	<b>720-CC</b>
	Dust Dry	15 mins.	15 mins.	25 mins.
	Tack-Free	40 mins.	45 mins.	70 mins.
	Dry to Handle	8 hrs.	8 hrs.	14 hrs.
	Hard Dry	10 hrs.	12 hrs.	16 hrs.
<b>Drying Times at 60°C:</b>	Dust Dry	9 mins.	10 mins.	16 mins.
	Tack-Free	18 mins.	24 mins.	35 mins.
	Dry to Handle	32 mins.	42 mins.	50 mins.
	Hard Dry	40 mins.	50 mins.	70 mins.
		Dust ingress and minor damage in the 2K Clearcoat 268 HS finishing can be polished out after allowing for the following drying times:  <b>At 60°C:</b> 3 hrs.		
	First flat out dust particles carefully with SF sandpaper, then polish the area manually or mechanically.			
<b>VOC:</b>	Theoretical VOC: 591 g/lt. ready to spray mixture.			
<b>Shelflife:</b>	2K Clearcoat 268 HS: 2 years			

**Health & Safety Data:** These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*