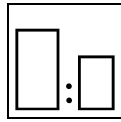


Technical Information Sheet

LOW VOC SPEED CLEAR 80-199

APPLICATION DATA



Mixing Ratio

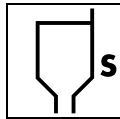
:

For 1.9 VOC:

Mix 2:1 (Low VOC Clear: LV Hardener 80-170 or 80-180)
Reduce 10% with Uni Thinner 1-141, 1-151, 1-161 or 1-171.

For 3.2 VOC:

Mix 2:1 (Low VOC Clear: MS Hardener 47-35, 47-55, or 47-65).
Reduce 5% with Uni Thinner 1-141, 1-151, 1-161 or 1-171.



Application-

Viscosity

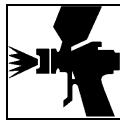
:

13 - 16 sec.

@ 20°C/70°F

DIN CUP 4 mm

Nozzle diameter (mm)



:

Gravity Feed

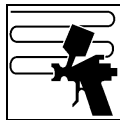
1.3-1.4

Suction Feed

1.4-1.6

HVLP/LVLP

1.3-1.4



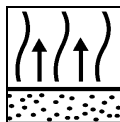
Spray Coats/

:

2 - 3 coats
maximum

Film Thickness

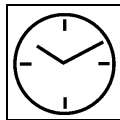
2 - 2.5 mils



Flash-off

:

3 - 6 min.
between coats

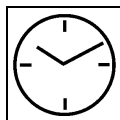


Drying*

:

20°C/70°F
5 min. flash

60°C/140°F(object temperature)
20min



Potlife

:

15 min. - 2 hours
depending on
activator selection.

@ 20°C/70°F

*Dry time will vary depending on activator selection, reducer selection, and atmospheric conditions. Excessive film build on top panels will slow through dry.

**To Polish, sand lightly or "nib" with 1500 paper, or finer, followed by a mild compound or polish on a foam polishing pad. For a full sand and polish overnight dry is recommended.

Technical Information Sheet

LOW VOC SPEED CLEAR 80-

199

Field of application and WaterBase 900 Series.	: For application as a fast dry clear topcoat over BeroBase 500 Series, This product is designed for use in spot and panel refinishing when fast cycle times are needed for maximum productivity.	
Chemical basis	: Clear acrylic finish based on highly durable hydroxy-acrylic and polyester polymers.	
General qualities	: 8-199 Low VOC Speed Clear is a non-yellowing, high-gloss finish, and very easy to use. Both air-drying and force drying are possible.	
Auxiliary materials	: 80-170 / 80-180 1-141 / 1-151 / 1-161 / 1-171 47-35 / 47-55 / 47-65	LV Hardeners Uni Thinners MS Hardeners
Mixing ratio (volume) 180)	: For 1.9 VOC: mix 2:1 (Low VOC Clear: LV Hardener 80-170 or 80-180) Reduce 10% with Uni Thinner 1-141, 1-151, 1-161 or 1-171. For 3.5 VOC: mix 2:1 (Low VOC Clear: MS Hardener 47-35, 47-55 or 47-65) Reduce 5% with Uni Thinner 1-141, 1-151, 1-161 or 1-171.	
Physical properties	Density : 9.5 lbs/gal Flashpoint : -4°F Vol.% solids : 35%. VOC as applied : 1.9 lbs/gal. or 3.4 lbs/gal (depending on mixing selection)	
Gloss	: High gloss.	
Substrates	: BeroBase Series 500 WaterBase Series 900 Degreased and sanded OEM or 2K finishes.	
Cleaning the equipment	: Lacquer Thinner or 1-000 Zero VOC Diluent (check local regulations)	
Colour	: Clear.	
Storage life container).	: Under normal storage conditions for up to two years (unopened	