

TECHNICAL DATA SHEET

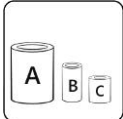
CLEARCOAT ALUM

The identification code: E-LBAL
Line: EXLAK


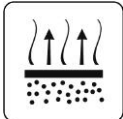
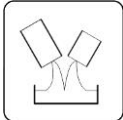
PRODUCT DESCRIPTION

This is a special clearcoat having specific adhesive properties to difficult substrate, such as aluminium. Apply directly on previously cleaned and degreased aluminium. Do not use on surfaces like "polished aluminium".

MIXING RATIO

	A: Clearcoat ALUM [code: E-LBAL]	100
	B: Hardener ALUM [code: E-UAL]	50
	C: Acryl thinner EXLAK Standard [code: E-RA]	6 - 8%
Comments:	Amount of thinner calculated for weight of the clearcoat.	
	Do not use other thinner than acryl thinner EXLAK	

APPLICATION

	Number of layers	2
	Pressure	2 - 2,5 bar
	Nozzle	1.3 - 1.4 mm
	Flash off between layers	10 - 12 min
	Mixture life after mixing clearcoat with standard type of hardener	60 min at 20°C

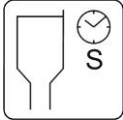
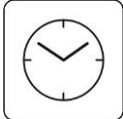
The first layer of clearcoat is applied to the pre-dried layer of basecoat. Second layer of clearcoat should be applied as a full layer and left to complete flow and hardening. Coating of clearcoat can be hardened by using IR heater. Please note that IR heater should not be turned on earlier than after about 15 minutes after application last layer of clearcoat. When painting large surfaces it is recommended to use a hardener and the acryl thinner - slow version.

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ADDITIONAL INFORMATION

	Viscosity (DIN 4/20°C)	
	Without thinner	19 - 20 s
	After adding thinner	17 - 18 s
	Operating hardness	14 h at 20°C
		45 min at 50°C
	Ending hardness	4 days
	Dust-free	10 min at 20°C
		5 min at 50°C

Hardness tested after 14 days in accordance with EN ISO 1522 Persoz pendulum – 352

CONTENT OF VOLATILE ORGANIC COMPOUNDS

Maximum content of VOC in product	540 g/l
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ALUM clearcoat is designed for industrial painting.

GLOSS

Output gloss	96°
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STORAGE TIME AND CONDITIONS

Store in tightly closed containers, in a cool, dry place away from sources of fire and heat. Avoid exposure to sunlight. Expiration date: 12 months from date of manufacture - date on the top of container.

CLEANING EQUIPMENT

For cleaning equipment can be used acryl thinner [code: E-RA] or nitro thinner [code: E-RN]. It is recommended to use thinner for cleaning paint spray guns EXLAK [code: E-RDMP].

HEALTH AND SAFETY REGULATIONS

See Safety Data Sheet of the product.

SPECIFIC WEIGHT

About 1.0 g/cm³