









TDS 30-2-1


Cardea® 2+1 Acrylic Supercure Clearcoat

Description	Cardea® 2+1 Acrylic Supercure Clearcoat is a fast curing clearcoat with excellent film properties and polishability.																
Related Products	Cardea® 2+1 Acrylic Supercure Clearcoat Cardea® 2K Acrylic Hardener Cardea® Universal Thinners	TDS no: 40-2-1 TDS no: 50-2-1															
Substrate	Cardea® Basecoats																
Mixing		<table border="1"> <thead> <tr> <th></th> <th>By Volume</th> <th>By Weight</th> </tr> </thead> <tbody> <tr> <td>Cardea® 2+1 Acrylic Supercure Clearcoat</td> <td>100</td> <td>100</td> </tr> <tr> <td>Cardea® 2K Acrylic Hardener</td> <td>50</td> <td>50</td> </tr> <tr> <td>Cardea® Universal Thinners</td> <td>5 - 15</td> <td>5 - 15</td> </tr> </tbody> </table>			By Volume	By Weight	Cardea® 2+1 Acrylic Supercure Clearcoat	100	100	Cardea® 2K Acrylic Hardener	50	50	Cardea® Universal Thinners	5 - 15	5 - 15		
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Viscosity		13 – 14 s/20°C (DIN 4)															
Pot Life	4 hours (at 20°C)																
Spray Gun Parameters		<table border="1"> <thead> <tr> <th>Gun Type</th> <th>Nozzle size</th> <th>Air pressure</th> </tr> </thead> <tbody> <tr> <td>Suction feed spray gun</td> <td>1,4-1,6 mm</td> <td>3 - 4 bars</td> </tr> <tr> <td>Gravity feed spray gun</td> <td>1,2-1,5 mm</td> <td>3 - 4 bars</td> </tr> <tr> <td>HVLP Suction feed spray gun</td> <td>1,5-1,7 mm</td> <td>2 - 2,2 bars</td> </tr> <tr> <td>HVLP Gravity feed spray gun</td> <td>1,3-1,6 mm</td> <td>2 - 2,2 bars</td> </tr> </tbody> </table>	Gun Type	Nozzle size	Air pressure	Suction feed spray gun	1,4-1,6 mm	3 - 4 bars	Gravity feed spray gun	1,2-1,5 mm	3 - 4 bars	HVLP Suction feed spray gun	1,5-1,7 mm	2 - 2,2 bars	HVLP Gravity feed spray gun	1,3-1,6 mm	2 - 2,2 bars
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Application		Spray a thin coat and then continue spraying several wet coats until full gloss. Allow 5-10 minutes flash-off between coats.															
Flash-off Time		Approximately 5 - 10 min (at 20 °C) until touch dry.															
Drying		<table border="1"> <thead> <tr> <th></th> <th>20°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>Dust Dry</td> <td>10 min</td> <td></td> </tr> <tr> <td>Time to Polish</td> <td>3 hours</td> <td>20 min</td> </tr> </tbody> </table>			20°C	60°C	Dust Dry	10 min		Time to Polish	3 hours	20 min					
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TDS 30-2-1

Cardea® 2+1 Acrylic Supercure Clearcoat

Polishing		Wet sand dirt and/or uneven surface by P1500/P2000 sanding paper. Then use compound and polish for surface appearance and gloss.
Dry Film Thickness		50 - 60 µm
Theoretical Coverage		5,5 - 6 m ² /l at 50 µm
Equipment Cleaning		Use acrylic or cellulosic thinners.
Package		Cardea® 2+1 Acrylic Supercure Clearcoat : 1 L; 5 L Cardea® 2K Acrylic Hardener : 0,5 L; 1 L
Color		No color
Safety		Professional use only. See Material Safety Data Sheet.