









TDS 30-2-2


Cardea® 2+1 Acrylic Crystal Clearcoat

Description	Cardea® 2+1 Acrylic Crystal Clearcoat is a high gloss product with excellent film properties and outdoor durability.		
Related Products	Cardea® 2+1 Acrylic Crystal Clearcoat Cardea® 2K Acrylic Hardener Cardea® Universal Thinners	TDS no: 40-2-1 TDS no: 50-2-1	
Substrate	Cardea® Basecoats		
Mixing		By Volume	By Weight
	Cardea® 2+1 Acrylic Crystal Clearcoat	100	100
	Cardea® 2K Acrylic Hardener	50	50
	Cardea® Universal Thinners	0 - 10	0 - 10
Viscosity		13 – 14 s/20°C (DIN 4)	
Pot Life	3 hours (at 20°C)		
Spray Gun Parameters		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
Application		2 coats	
Flash-off Time		Approximately 5 - 10 min (at 20 °C) until touch dry.	
Drying		20°C	60°C
	Dust Dry	15 min	
	Time to Polish	5 hours	30 min



TDS 30-2-2

Cardea® 2+1 Acrylic Crystal 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		6 m ² /l at 50 µm	
Equipment Cleaning		Use acrylic or cellulosic thinners.	
Package		Cardea® 2+1 Acrylic Crystal 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.	