

Technical Information

40-620



2K Clear mat VOC

- 40-620 2K Clear mat VOC, easy and safe to spray.
- Gloss levels between matt and satin matt (12-65 units at an angle of 60°) can be achieved by different mixing ratios with baslac clears. The gloss level may be higher with light and pure silver colors. Moreover, car bodies may show gloss level differences between vertically and horizontally coated panels. Therefore, we recommend making a spray sample before refinishing and comparing it to the area to be repaired. Deviations of +/- 5 gloss units are possible.
- In order to achieve different gloss levels, the product can be mixed with 40-440 2K VOC Clear or 40-450 HS Universal Clear VOC.

In order to avoid any gloss deviation when refinishing matt clear, the following instructions have to be observed:

- 40-620 must not be used in mixing shelves.
- Stir 40-620 manually very well.
- Consistent clear coat film thicknesses can be achieved by applying two equally full layers and staggered overlaps.

Application

	Mixing Ratio	100 % by weight	40-620
	100:33:17	33 % by weight	50-420
		17 % by weight	60-20
	Spray viscosity at 20°C	DIN 4: 16-18 s	
	Potlife at 20°C	4 h	
	HVLP spray gun		
	Nozzle size	1.3	
	Nozzle pressure	0.7 bar	
	Compliant gravity-feed spray gun		
	Nozzle Size	1.3-1.4	
	Application Pressure	2 bar	
	Number of spray coats	2	
	Film thickness	40-50 µm	

Safety advice:

2004/42/IIIB(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready to use form is max 420 g/l of VOC. The VOC content of this product is 419 g/l.

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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Flash off at 20°C

Flash off until mat after each spray coat and before drying. After the first spray coat, allow to flash off for 10 - 15 min, after the second spray coat for 15 - 20 min, depending on air speed and spray booth temperature. Do not flash off for more than 25 min after each spray coat.

Drying



Drying at 20°C

7 h

Drying at 60°C

30 min



Infrared (short wave)

8 min

Infrared (medium wave)

10-15 min

Remark

With mat surfaces it is **not** possible

- to remove dust inclusions by polishing because polishing changes the gloss level. Therefore, it is very important to work very carefully during cleaning and application.
- to fade out the clear because the film thickness in the blending area varies, which changes the gloss level. Therefore, panel repair is mandatory.

Correct gloss levels will be achieved after:

- 24 h when drying 30 min with 60°
- 72 h when air drying

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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