

## C 894 CLEAR ULTRA HS 2:1



### GENERAL TECHNICAL DESCRIPTION

Ultra high solid clear coat suitable for full body or spot panel repairs.

Great gloss retaining.

Excellent mechanical and high chemical resistance.

Excellent surface finish.

### SURFACE

HB BODY solventborne and waterborne basecoat paints

### PRETREATMENT/CLEANING OF SUBSTRATE



Let the basecoat dry sufficiently before the clearcoat. Clean the surface from the dust with a tack cloth.

### PRODUCT APPLICATION: Apply a half thin closed coat followed by the second full coat.



Mix 2 parts CLEAR COAT with 1 part H733 SLOW / H734 NORMAL / H735 FAST HARDENER ULTRA HS  
Pot life: 90 - 135 min



No THINNER / REDUCER required



Ready to spray: 18 - 20 s  
DIN 4 / 20°C (68°F)



1.2 - 1.3 mm  
1.7 - 2.2 bar (25 - 32 psi)  
1.5x coats = 50 - 60 µm  
(2 - 2.4 mil)



5 - 10 min / 23°C (73°F)  
Flash off time between coats



10 - 15 min / 23°C (73°F)  
Final flash off time with  
spray booth recirculation



16 - 20 hrs / 23°C (73°F)  
25 - 40 min / 60°C (140°F)  
panel temperature



Flash off before IR curing: 4 - 5 min  
1st step: half power 5 min  
2nd step: full power 12 - 16 min  
Lamp distance: 60 - 80 cm

### Application conditions

#### For partial or spot repairs:

T = 15 - 20°C (59 - 68°F) use  
H735 Hardener UHS Fast  
T = 20 - 30°C (68 - 86°F) use  
H734 Hardener UHS Normal  
T = 30 - 35 °C (86 - 95°F) use  
H733 Hardener UHS Slow  
Rel. humidity 40 - 80%

#### For complete car repair:

T < 25°C (77°F) use  
H734 Hardener UHS Normal  
T = 25 - 35 °C (77 - 95°F) use  
H733 Hardener UHS Slow  
Rel. humidity 40 - 80%

### SPECIFIC GRAVITY

0.98 ± 0.02 g/cm<sup>3</sup>

### SOLID CONTENT

(NO THINNER / REDUCER)

57.5 ± 2% Weight

### VOC (2004/42/EC)

This is an automotive refinishing product based on its ingredients and its properties.. The maximum VOC content in this category is 420 g/L. The VOC content in the ready for use form of this product is 420 g/L.

2004/42/IB(d)(420)420

### THEORETICAL COVERAGE

10 - 12 m<sup>2</sup> / l at 50 micron (2 mil)  
dry film thickness

### CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL  
NORMAL thinner / reducer

### REMARKS

- Application only with the specified hardeners.
- Polishing possible after force drying (30 min / 60°C) and 60 min cooling phase.

### STORAGE SHELF LIFE

Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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