



Technical Data Sheet:

07.2022




Product Details:

Product Name:	HS High Solid Clear Coat
Product Description:	Germa-Tech HS Clear Coat is a hi performance 2K clear coat, high solid, high gloss, good build, strong chemical resistance. Excellent colour gloss and protective power.

Substrates:

	1K Basecoat
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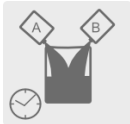
Surface Preparation:

	Clean the surface with a Tack Cloth to remove dust and particles from the surface.
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Directions For Use:
Mixing Ratio:


	Clear Coat +	Hardener +	Thinner
	2	1	15-20%
< 18 °C	HS Clear Coat	HS Fast	Premium Reducer
18 - 24 °C	HS Clear Coat	HS Standard	Premium Reducer
25 - 30 °C	HS Clear Coat	HS Standard	Premium Reducer
> 30 °C	HS Clear Coat	HS Slow	Premium Reducer

Pot Life:

Pot-Life at 25 °C

2 hours with fast hardener.

4 hours with standard and slow hardener

Shelf Life:

Shelf Life is up to 36 months if unopened and stored in a cool dry place (below 20°C). Shelf life is an optimal guide and the product is manufactured and tested to exceed shelf life recommendations, avoid ambient temperatures above 20 and exposure to direct sunlight which are amongst common factors that will diminish storage shelf life. Contact the distributor or manufacturer if requiring further advice.

If stored correctly, it can be used for up to 12 months from opening the original seal

Spray Gun Set Up:


Gravity Feed: 1.2-1.4mm Suction Feed: 1.3-1.5mm

Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar

Coats And Thickness:


Coats & Thickness	2-3 Coats, total 50-70um
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Spray viscosity (20°C, Ford Cup DIN 4) 16-18 seconds
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At 20 °C, 5-10 minutes between coats, 15-20 minutes before baking

WARNING

A flash of is required between each coat, flash off time should be adjusted +/- depending on air temperature. Fast and Slow hardeners and reducers can be used in extreme cold or extreme heat.

A flash time of 15-20 min is required before commencing of the bake.

Drying Time:


Temperature:	Dust Free	Dry to Polish (FULL BAKE)
Below 15 °C	Recommend Full Bake	
23 °C	10 Hours	16 - 24 hours
60 °C	30 minutes	60 minutes

DRY TO POLISH

Polishing and denibbing of clear coats requires sufficient dry time. Ensure bake times commence from when the oven reaches temperature of 60 °C and not before. Dry times are greatly impacted by the thickness of the coating and the ambient air temperature when applying. When temperatures are below 23 °C adjust drying times or increase baking times accordingly.

WARNING

Do not dry in direct sunlight and allow 24 hours or full bake, temperatures in directly sunlight can exceed 70 °C

Additional Information
Notes:

1. At temperatures lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
2. Mix the clear coat according to the proportion indicated by the manufacturer. The mixture should be used within 2 hours. Only use Germatech reducer.
3. At low humidity, flash off time 2-3 minutes is recommended to achieve smooth paint film.
4. At an ambient temperature higher than 30°C, add Retarder Solvent or Slow Reducer maybe required to avoid blushing. For details please refer to the Retarder Solvent TDS.
5. In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition.
6. In the event of fisheyes during application, add 0.5-1% Anti Silicon in the remaining paint and respray the affected area.

WARNING

7. Maximum coating thickness after application of clear coat, cannot exceed 300um (micron), application of product in excess of 300um can result in adverse outcomes and may require sanding back of product, refer Germatech Coating Thickness Guide.
8. Germatech Polyurethane product takes up to 12 weeks to fully cure, if reworking or sanding clear imperfections, upmost care must be taken not to break through the clear layer into the exposed basecoat, reapplication of product directly on sublayers

can results in product reactions. Sand imperfections with P1500 working to P3000 then polish.

9. Germatech Polyurethane products are specifically designed to work with the Germatech product suite ie fillers, primers, basecoat, hardeners and reducer

Packaging: 1U4L

The information contained in this file is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.