



Technical Data Sheet:

07.2022



Product Details:

Product Name:

High Velocity Clear Coat

Product Description:

High Solid speed clear - air dry or fast 15 min bake to polish for high velocity workshops requiring an excellent finish in high production output.

Germa-Tech High Velocity Clear Coat is a double pack High Solid acrylic extra fast drying clear coat, easy application, good gloss, suitable for metal, solid basecoat and spot repair.

Suitable repairs single to 3 panels, rapid repairs not full resprays.

Substrates:



1K Basecoat

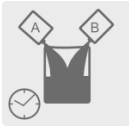
Surface Preparation:



Clean the surface with a Germa-Tech Tack Cloth to remove dust and particles from the surface.

Directions For Use:
Mixing Ratio:


	Clear Coat +	Hardener +	No Reducer
	2	1	
< 18 °C	PC-6800	PC-6671 Fast	No Reducer
18 - 30 °C	PC-6800	PC-6672 Standard	No Reducer
>30 °C	PC-6800	GT-6673 Slow	No Reducer

Pot Life:

Pot-Life at 25 °C

Within One Hour

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 Coats, total 40um
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At 20 °C, NO FLASH OFF TIME between coats, 15-20 minutes before baking

WARNING

NO FLASH OFF TIME IS REQUIRED BETWEEN COATS. This express air dry clear and as such application on any more than 2-4 panels will be appropriate.

DO NOT ADD REDUCER.

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

<p>Drying Time:</p> 	<table border="1"> <thead> <tr> <th>Temperature:</th> <th>Dust Free</th> <th>Dry to Polish</th> </tr> </thead> <tbody> <tr> <td>10 °C</td> <td>30-40 minutes</td> <td>120 minutes</td> </tr> <tr> <td>15 °C</td> <td>20-30 minutes</td> <td>60 minutes</td> </tr> <tr> <td>25°C</td> <td>15-20 minutes</td> <td>40 minutes</td> </tr> <tr> <td>60°C</td> <td></td> <td>10-15 minutes MAX</td> </tr> </tbody> </table>	Temperature:	Dust Free	Dry to Polish	10 °C	30-40 minutes	120 minutes	15 °C	20-30 minutes	60 minutes	25°C	15-20 minutes	40 minutes	60°C		10-15 minutes MAX	
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	<p>DRY TO POLISH</p> <p>Polishing and denibbing of clear coats requires sufficient dry time. Whilst this clear is a air dry clear, dry to polish time can be achieved by baking at 60°C for a maximum 10-15 min - do not exceed</p> <p>WARNING</p> <p>Do not dry in direct sunlight and allow 24 hours or full bake, temperatures in directly sunlight can exceed 70 °C</p>																

Additional Information

Notes:

1. Mix the clear coat according to the proportion indicated by the manufacturer. The mixture should be used within 2 hours. Only use Germatech reducer.
2. In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition.
3. In the event of fisheyes during application, add 0.5-1% Anti Silicon in the remaining paint and respray the affected area.

WARNING

4. DO NOT REDUCE
5. 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.
6. Germatech Polyurethane product takes up to 12 weeks to fully cure, if reworking or sanding clear imperfections, utmost 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.

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.