

# Technical Data Sheet

## Perfect Line Economic VOC Clear Coat

### Clear Coats



Version 09/2018

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### Supplier

#### Importer and supplier

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### Product

The Perfect Line **Economic** VOC Clear Coat is a multi-purpose clear coat that can be used for a wide range of automotive body parts. This product has perfect curing, high convex gloss and optimal protection against weather influences.

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### Item number(s)

PL.ECO.CC.5 (= 5L can)

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### Physical and chemical product properties

Packing	: 5L
Appearance	: Liquid
Colour	: Transparent
Density	: 1000 ± 20 g/litre
Spray viscosity	: 8 - 9 m <sup>2</sup> /litre
VOC value	: < 420 g/litre
Pot life	: 1 hour at 20°C
Storage	: Store in a dry and cool place, away from heat sources.

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### Substrates

- Solvent-based or water-based base paints (for a 2-layer finish).
- All cleaned and sanded OEM or repair finishes.

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### Preparation

- First clean the surface thoroughly with soap and water. Rinse and rub dry.
  - Pre-clean with solvent-based or water-based products. (Recommended: Perfect Line Degreaser M600).
  - Before applying base or 2K paint, degrease with a mild degreaser (recommended: Perfect Line Aqua Degreaser) and wipe dry with a clean cloth.
  - Wait until the base coat is completely dry. Then apply the clear coat.
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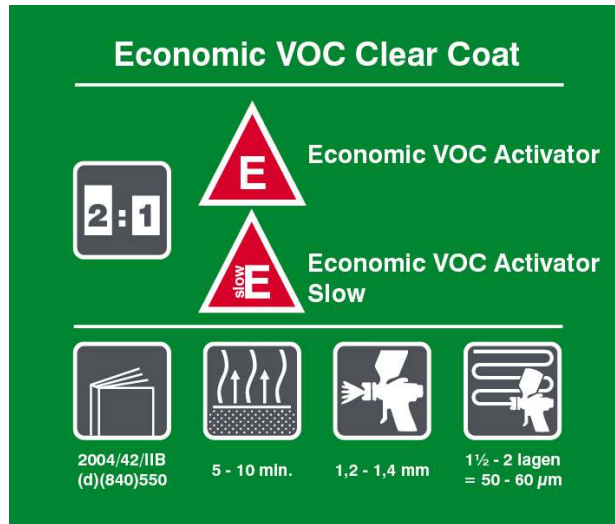
### Clear Coats



Version 09/2018

### Mixing ratio and technical information

Mix the Perfect Line Economic VOC Clear Coat with the Perfect Line Economic VOC Activator or the Perfect Line Economic VOC Activator Slow 2:1 at volume, as shown in the diagram below:



**Dilution** : 1 - 10% dilution with Perfect Line Uni Thinner. Dilution with Perfect Line Uni Thinner Slow is also possible.

### Application

**Nozzle** : 1.2 - 1.4 mm  
**Air pressure** : 2.3 bar (at the bottom of the entrance of the spray gun)  
**Number of spraying cycles** : 1.5 - 2 layers. First layer by flood coat, after 5 minutes second layer as full coat  
**Recommended layer thickness** : 50 - 60 microns

### Drying process

#### Air drying at 20°C

**Dust free** : 30 - 40 minutes  
**Dry to handle** : 5 - 6 hours  
**Tape-free** : 24 hours

#### Force drying, 20 - 30 minutes at 60°C

**Flash time before drying** : 5 - 10 minutes  
**Dry to handle** : After the object has reached the ambient temperature  
**Tape-free** : 10 minutes

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#### **Infra-red drying**

Guideline for short-wave IR equipment.

<b>Flash time before drying</b>	: 8 - 10 minutes
<b>Distance</b>	: 70 - 80 cm
<b>Half power</b>	: 5 minutes
<b>Full power</b>	: 12 - 15 minutes

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#### **Disclaimer**

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