Technical Data Sheet

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Product name

MASTERMIX

HS CLEARCOAT SB

POLYURETHANE TOPCOAT(PLA 10)

PRODUCT DESCRIPTION

A two-component polyurethane acrylic finish.

INTENDED USES

- Finish coating for cars, buses, trucks, trailers, tippers, cranes, earth moving equipment and farm machinery.

FEATURES AND BENEFITS

- Easy to use
- No dilution required
- Fast drying
- Good mechanical and chemical resistance
- High gloss
- VOC compliant

PRODUCT INFORMATION

Appearance	High Gloss
Colours	Clear
Volume Solids	± 35% (mixed)
Recommended DFT	Min: 25µm, Max: 30µm per coat(2 coats required)
Recommended WFT	Min: 70µm, Max: 85µm per coat(2 coats required)
Theoretical spreading rate	11.6m²/L at 30µm DFT at stated volume solids
VOC	<250g/L
Flash Point	<-18°C
Viscosity	15 – 17seconds (typical) DIN Cup No.4 @ 20°C

APPLICATION DETAILS

Mixing Ratio	2 parts base(PLA 10) to 1 part curing agent(PLA 15) by volume 100g base(PLA 10) to 52g curing agent(PLA 15) by mass		
Mixing	Stir both components separately with a paddle until homogenous. Add the curing agent to the base and mix thoroughly together. Mix only in proportions shown above.		
Method	Conventional spray: Nozzle orifice: 1.2 – 1.3mm Nozzle pressure: 2.0 – 2.5bar		
Application environment	Surface Temperature	Min*: 10°C	Max: 40°C
	Ambient Temperature	Min*: 10°C	Max: 40°C
	Relative Humidity	Min*: 10%	Max: 80%
	*or 3°C min. above dew point		
Thinning	Not Recommended. Ready for use		
Cleaning	FLOWLINE THINNER(KNT 1)		
Drying Time	Flash off	10min at 20°C between layers	
	Touch dry	1h at 20°C	
	Overcoating(Min)	1h at 20°C	
	Overcoating(Max)	48h at 20°C	
	Dry to handle	16h at 20°C	
	Full Cure	7 Days	
	Accelerated Drying	30min at 60°C(panel temperature)	
Pot Life	4h at 23°C		

STORAGE AND PACKAGING

Store away from direct sun, heat, open flames, sparks and severe cold.
Shelf Life: 60 months(base)
24 months(curing agent)
Twin Packs: 1L, 5L (base)
500ml , 2,5L(curing agent)

SURFACE PREPARATION

Ensure that surfaces are dry, sound, and free from dust, dirt, grease, and oil before painting.

MILD STEEL

- Degrease with ACRYLINE PRE-CLEANER SB(ATH 310) and rinse with fresh water until water break free surface.
- To remove rust, mill scale and other contaminants abrasive blast clean to Grade Sa 2½ of ISO 8501-1:2007 with a blast profile of 30 – 50µm.
- Alternatively wire brush to Grade St 3 of the same standard. This is not as effective and may result in a shorter maintenance-free period.
- Alternatively sand substrate with 80 – 120 grit paper to a smooth finish.
- Prime surfaces with MASTERMIX 1K ETCH PRIMER SB(EPP RANGE), MASTERMIX FLOWLINE PRIMER SB(PSS 147), MASTERMIX 2K PRIMER(PTK 105), ACRYLINE 2K PRIMER(APU 108)

PHOSPHATED STEEL,GALVANISED STEEL AND ALUMINIUM

- Degrease with ACRYLINE PRE-CLEANER SB(ATH 310) and rinse with fresh water until water break free surface.
- Sand substrate with Scotch Brite pads
- Alternatively sand substrate with 280 – 320 grit paper to a smooth finish.
- Prime surfaces with MASTERMIX 1K ETCH PRIMER SB(EPP RANGE), ACRYLINE 2K PRIMER(APU 108)

POLYPROPYLENE and PLASTIC – NEW

- Bake for two cycles 30min at 60°C to exude release agents.
- Remove all contamination with MASTERMIX PRE-CLEANER(PTK 310)by using the spray on wipe off method.
- Abrade surfaces with P5000 - 800 grit sandpaper to provide a key.
- Leave overnight or bake for 40min at 60°C.
- Prime surfaces with MASTERMIX PLASTIC PRIMER(PTK 186)

APPLICATION INFORMATION

- 2K materials react with humidity - take care that all containers and tools are absolutely dry
- Use air fed respirator during application
- For professional use only.
- Not suitable for use over thermoplastic acrylic lacquers and synthetic air drying enamels.
- Applicators must ascertain the most suitable needle, Fluid tip, and air cap for the article being coated. Air and atomising pressures must be set to produce the optimum delivery efficiency and quality of finish.

SAFETY PRECAUTIONS

- Always keep paint out of reach of children.
- Ensure good ventilation during application and drying.
- If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.
- Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.
- Harmful if swallowed. Seek medical attention and do not induce vomiting.
- Do not smoke while painting.
- Flammable. Store in a cool dry place away from heat and sparks.
- CATALYST contains isocyanate – use suitable respirator, particularly during spray application of the mixed material.
- Refer to Safety Data Sheet for complete information.

DISCLAIMER

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be dependable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

NB: Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.
NB: TO ORDER: Quote product name, product code number, packaging, and colour.

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