

TECHNICAL DATA SHEET

IC-608-411 High Solids Express Clearcoat

Description

IC-608-411 is a 4:1:1 ratio fast-drying clearcoat that is designed to increase profitability and productivity of the refinishing application. It features high gloss, easy to apply and have a good flow and leveling property. Moreover, it is easy to polish, and is suitable from spot to panel repair, which provides the flexibility for different using scenarios.

Features

- Fast drying, 4 hours air dry at 20°C to polish
- Excellent gloss, DOI, leveling, blending, and buffing characteristics
- Suitable for spot & panel repair
- 4:1:1 ratio application

Products

- IC-608-411 Clearcoat
- IC-678 Hardener Series
- IC-950 Reducer Series

For matt finish and other application requirements:

- | | |
|--------------------------|---|
| • IC-2K290 Matting Agent | For an excellent matt effect of the clearcoat surface. |
| • IC-360 Anti-silicon | For preventing cratering in an individual repair. |
| • IC-800 Degreaser | For removing grease, oil, wax and silicone prior to application. |
| • IC-820 Quick Drier | For accelerating the reaction between the resin and the hardener. |
| • IC-350 Blending Agent | For eliminating the color difference between the new and old paint surfaces |
| • A5 Compound Paste | For obtaining a glossy and durable finish. |



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Preparation of substrate

IC-608-411 is suitable to be applied on top of a clean and dust-free basecoat surface. Please degrease with IC-800 degreaser to wash off residues and tack thoroughly before application. The use of a rag is recommended. See TDS of basecoat for other preparations of substrate.



Mixing Ratio

Product	Volume	Weight
IC-608-411	100	100
IC-668/678/688	25	27
IC-940/950/960	25	23

Note:

IC-668/IC-940 is for temperatures between 5-15°C

IC-678/IC-950 is for temperatures between 15-25°C

IC-688/IC-960 is for temperatures above 25°C

Mix well and strain before application.



Pot Life

2 hrs at 25°C



Spray Viscosity

14-17 s with DIN 4 cup at 25°C

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Spray Guns

Type	Nozzle Size	Pressure	Spray Distance
HVLP Gravity-feed Spray Gun	1.2-1.3 mm	1.5-2.0 bar	10-15 cm
Compliant Gravity-feed Spray Gun	1.3-1.6 mm	3.0-4.0 bar	15-20 cm



Number Of Coats

1 half wet + 1 wet coat



Film Thickness

50-60 μm



Drying Times

	20°C/68°F	60°C/140°F
Flash off	2-5 min	-
Dust Free	10-15 min	-
Ready for Assembly	3-3.5 hrs	-
Ready for Polish	4 hrs	-



IR Drying

After dust free:

Step 1 - short wave: 5 mins at an 80 cm distance

Step 2 - medium wave: 20 mins at an 80 cm distance



Product Specifications

Color: Transparent

Shelf Life: 24 months at 25°C

Theoretical Coverage: 250-300 m^2/L at 1 μm thickness

Ready to use density: 975 g/L

Weight of ready to use solids: 41.9 %

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HEALTH AND SAFETY



Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

- Hardeners contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

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