



Clear Coat

IC - 608 - NR - 411 High Solids Express Clear Coat

Product Description

IC - 608NR - 411 H.S. Express Clear is a U.S. National Rule Compliant acrylic urethane clear which works well in air dry environment and provide excellent gloss, DOI, leveling, blending, and buffing characteristics. It is an easy to apply two coat clear that offers a range of reducers to meet your different temperature needs.

Technical Characteristics	
Color: Transparent	Recommended Storage Temperature: 5°C - 25°C/41°F - 77 °F
Shelf life: 24 months	Theoretical spreading rate: 250 - 300 m² /l (avg) at 1 μm

Pre-treatment

IC - 608NR - 411 H.S. Express Clear is suitable to be applied on top of a clean and dust - free InnoColor basecoat. See TDS of basecoat for other preparation of substrate.

Mixing Ratio	IC - 608 - NR - 411 Clear coat IC - 678 Hardener IC - 950 - 21V Reducer Mix well and strain before app Note: IC - 668/IC - 940 - 21V is for te IC - 678/IC - 950 - 21V is for te IC - 688/IC - 960 - 21V is for te Spray Viscosity (20°C /68°F) Pot - Life (20°C /68°F)	100 (vol) 25 (vol) 25 (vol) blication. Emperatures be emperatures be 17 - 19 s 3 - 4 h	etween 5°C - 15°C/4 etween 15°C - 25°C etween 25°C - 35°C	41°F - 59°F /59°F - 77°F /77°F - 95°F	
Spray Guns	HVLP gravity - feed spray gun Conventional gravity - feed sp	oray gun	1.2 - 1.3 mm 1. 1.3 - 1.6 mm 3.	5 - 2.0 bar 0 - 4.0 bar	10 - 15 cm 15 - 20 cm
Application	Number of spray coats Film thickness	2 wet coats 60 um			
Drying	- Flash off Dust free after Ready for assembly after Ready for polish after	20°C/68°F 5 - 10mins 30 - 40mins 4 hours 4 hours	60°C/160°F - - 30 - 40mins 30 - 40mins		
IR Drying	IR drying after dust free Step 1 - short wave: 6 - 10mins at a 80 cm distance Step 2 - medium wave:6 - 10mins at a 80 cm distance				
VOC(Ready to spray)	Actual VOC (Maximum) Regulatory VOC (Maximum) Weight of Solid Applied Note : Use reducer according to shop VOC Reducers will increase VC Further Treatment: Polish aft	408g/l (3. 495g/l (4. 39.9% o conditions. U OC. er specified dr	41lbs/gal) 13lbs/gal) sing reducers othe ying times and coc	r than Zero bling.	