

Clear Coat

IC-810 Extreme 4:1 Spot/Panel Clearcoat

Product Description

Extreme 4:1 Spot/Panel Clearcoat for application ranging from spot repair to panel repair.

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-810 Extreme 4:1 Spot/Panel Clearcoat 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-810 Clear	100 (vol)	100 g	
		IC-877 Hardener	25 (vol)	25 g	
	Spray Viscosity and Potlife	Mix well and strain before application.			
		Note:			
		IC - 867 is for temperatures between 5°C - 15°C/41°F - 59°F			
		IC - 877 is for temperatures between 15°C - 25°C/59°F - 77°F			
		IC - 887 is for temperatures between 25°C - 35°C/77°F - 95°F			
		Spray Viscosity (20°C /68°F)	16-18 s		
		Pot - Life (20°C /68°F)	1- 2 h		
	Spray Guns	HVLP gravity - feed spray gun	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
		Conventional gravity - feed spray gun	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm
	Application	Number of spray coats	1 thin + 1 wet coat		
		Film thickness	40-60 um		
	Drying	Drying	20°C/68°F	60°C/160°F	
		Flash off	2- 5 mins	-	
		Dust free after	10 - 15 mins	-	
		Ready for assembly after	120-140 mins	15 mins	
		Ready for polish after	5 - 6 hours	45 mins	
	IR Drying	IR drying after dust free			
		Step 1 - short wave: 5 mins at a 80 cm distance			
		Step 2 - medium wave: 20 mins at a 80 cm distance			
	VOC(Ready to spray)	Actual VOC (Maximum)	475g/l (3.97lbs/gal)		
		Regulatory VOC (Maximum)	500g/l (4.17lbs/gal)		
		Weight of Solid Applied	47.3%		
		Further Treatment: Polish after specified drying times and cooling.			