

Clear Coat

IC-830 Extreme 4:1 Overall Clearcoat

Product Description

Extreme 4:1 Overall Clearcoat for application of overall refinsh.

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-830 Extreme 4:1 Overall 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  Spray Viscosity and Potlife  Spray Guns  Application  Drying  IR Drying  VOC(Ready to spray)	IC-830 Clear 100 (vol) 100 g IC-877 Hardener 25 (vol) 25 g
	Mix well and strain before application. Note: IC - 867 is for temperatures between 5°C - 15°C/41°F - 59°F IC - 678/ 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) 16-19 s Pot - Life (20°C /68°F) 1- 2 h
	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
	Number of spray coats 1 thin + 1 wet coat Film thickness 40-60 µm
	Drying 20°C/68°F 60°C/160°F Flash off 2- 5 mins - Dust free after 10 - 15 mins - Ready for assembly after 180-200 mins 15 mins Ready for polish after 7 - 8 hours 45 mins
	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
	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.