

# Clear Coat

## IC – 9903 High Solid Clear (H.S)

### Product Description

High Solid clears for application ranging from spot repair, panel repair to overall refinish.

### Technical Characteristics

Color: Transparent

Recommended Storage Temperature: 5°C - 25°C/41°F - 77 °F

Shelf life: 24 months

Theoretical spreading rate: 250 - 300 m<sup>2</sup> /l (avg) at 1 µm

### Pre-treatment

IC - 9903 High Solid 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



#### Spray Viscosity and Potlife



#### Spray Guns



#### Application



#### Drying



#### IR Drying



#### VOC(Ready to spray)

<b>IC - 9903 Clear coat</b>	100 (vol)	100 g
<b>IC - 9703 Hardener</b>	50 (vol)	50.2 g
<b>IC - 950 Thinner</b>	10-15 (vol)	9-13 g

Mix well and strain before application.

Note:

IC - 9603/IC - 940 is for temperatures between 5°C - 15°C/41°F - 59°F

IC - 9703/IC - 950 is for temperatures between 15°C - 25°C/59°F - 77°F

IC - 9803/IC - 960 is for temperatures between 25°C - 35°C/77°F - 95°F

<b>Spray Viscosity (20°C /68°F)</b>	15 - 17 s
<b>Pot - Life (20°C /68°F)</b>	4-5 h

<b>HVLP gravity - feed spray gun</b>	1.2 - 1.3 mm	1.5 - 2.0 bar	10 - 15 cm
<b>Conventional gravity - feed spray gun</b>	1.3 - 1.6 mm	3.0 - 4.0 bar	15 - 20 cm

<b>Number of spray coats</b>	1 half wet + 1 wet coat	
<b>Film thickness</b>	60 - 70 µm	

-	20°C/68°F	60°C/160°F
<b>Flash off</b>	8 - 10 mins	-
<b>Dust free after</b>	20 mins	-
<b>Ready for assembly after</b>	6 hours	30 mins
<b>Ready for polish after</b>	overnight	70 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

<b>Actual VOC (Maximum)</b>	526g/l (4.39lbs/gal)
<b>Regulatory VOC (Maximum)</b>	526g/l (4.39lbs/gal)
<b>Weight of Solid Applied</b>	46.3%

**Further Treatment: Polish after specified drying times and cooling.**