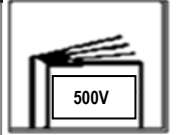




HS CLEAR 0320 1.360.0320

HIGH SOLIDS ACRYLIC CLEAR

HS CLEAR 0320 offers high solid content, fast drying, strong film hardness, and excellent gloss, with the flexibility of different hardener options, and simple mixing ratios for different types of repair.
HS CLEAR 0320 can be used for spot repair, full panel, or total respray for best results and durability.



SUBSTRATES

AQUAMAX BASECOAT – MAXI CAR

PREPARATION

Allow AquaMax to dry thoroughly before application of Clearcoat.
 Clean basecoat colour with a tackrag, before clearcoat application.



	MIX RATIO / VOLUME
HS CLEAR 0320	2
HS HARDENER	1
VISCOSITY- DIN4, 20° C	17 – 19 seconds
POT LIFE	1 hour @ 20°C with 2730/40 1.5 hours @ 20°C with 2720

Note: As with all UHS products, cold RFU paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that RFU product is applied at a temperature above 15°C.

HARDENERS

HS HARDENERS	1.954.2740*	18°C to 25°C
	1.954.2730	25°C to 30°C
	1.954.2720	Above 30°C

* Best choice for low bake environment or where the panel temperature does not achieve 60°C through the drying process.

ADDITIVES

Antisilicone	AD2341 (1.975.2341)	See Technical Datasheet 411V
Flexible Additive	AD1208 (1.975.1208)	See Table on Page 3 of this TDS
Texture additive – Fine	1.975.5500	See Table on Page 3 of this TDS
Texture additive – Coarse	1.975.5501	See Table on Page 3 of this TDS



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APPLICATION

Gun setup

Gravity spray gun nozzle (mm)
 Pressure at the gun
 Number of coats
 Suggested thickness

Compliant Sprayguns

1.2-1.3
 As per manufacturers recommendations.
 1 medium coat + 1 full coat or 2 full coats.
 50/60 microns

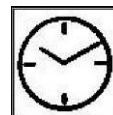


Important:

Single Visit Process: Apply one medium, continuous coat followed by one full coat. The first coat should be applied to all repair panels before the second coat is applied. For less than 3 panels, 2-3 minutes flash between coats. For more than 3 panels, no flash is required.

Two coat Process: Apply 2 full coats with a 5 minute flash off between coats. DO NOT apply more clearcoat than indicated. The recommended build above is easily obtained.

DRYING



OVEN DRYING

with 2720 hardener
 with 2730 hardener
 with 2740 hardener*

30 minutes at 60°C
 15-20 minutes at 60°C
 15 minutes at 60°C

* Best choice for low bake environment or where the panel temperature does not achieve 60°C through the drying process.

Through dry at 20°C

with 2730/2740 hardener

8 hours

Flash off before oven drying

0-5 minutes

INFRARED DRYING

medium wave
 short wave

15 minutes
 10 minutes

RECOATABILITY

Recoatible, 1 hour after baking, and then sanding.



BEST PRACTICES WITH HS PRODUCTS

PAINT STORAGE CONDITIONS



Keep ready for use paint in good conditions to ensure correct viscosity. RFU temperature above a minimum of 15°C, and ideally over 18°C. This includes paint, hardeners and thinners.

MIXING AND MAKING READY FOR USE

Activate accurately, and by weight where ever possible.

Where mixing must be by volume, only use a round and parallel sided mixing container together with the correct mixing stick. If using a measuring container marked in percentages, you must be sure that the percentages give the correct quantities.

Make sure that Hardener and Thinner is mixed in well. High solids or high viscosity products can take a little longer to mix in, so a good practice is to stir Hardener in first, then add thinner before stirring again. Use mixed product as quickly as possible.

Choose the correct Hardener for the required bake cycle.

Keep to the recommended levels of additives.

Do not exceed the recommended level of additives such as Flexibilisers.

APPLICATION TECHNIQUE, PROCESS AND EQUIPMENT CHOICES

Use correct spraygun set ups, and set up the spraygun correctly.

Use a "Single Visit" application wherever possible, following the advice given in the application section.

Check that the spraybooth is operating effectively. If necessary make an oven check to be sure that metal temperature is reached, especially on low down repair areas.

MaxMeyer recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.



GUIDELINES FOR WEIGHT MIXING

Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below. The weights are cumulative - please do NOT tare the scale between additions.

Volume of RFU Paint (Litres)	Weight	Weight
	1.310.0320	1.954.2740/ 2730 / 2720
0.10 L	66.0g	99.0g
0.20 L	132.0g	198.0g
0.3 L	198.0g	297.0g
0.4 L	264.0g	396.0g
0.5 L	330.0g	495.0g
0.6 L	396.0g	594.0g
0.7 L	462.0g	693.0g
0.8 L	528.0g	792.0g
0.9 L	594.0g	891.0g
1 L	660.0g	990.0g

RATIOS FOR FLEXIBLE AND TEXTURED FINISHES

The addition of 1.975.5500 & 1.975.5501 can be used to give a textured finish. Over flexible substrates, 1.975.1208 should be used.

Note: The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

The table below gives a **1L WEIGHT MIX** for various topcoat appearances, ready to spray. The weights in grams are cumulative.

PLEASE DO NOT TARE the scale between additions.

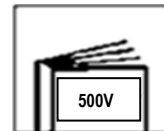
Substrate	Appearance	HS Clear 0320	Fine Texturing 5500	Coarse Texturing 5501	Flexible Additive 1208	HS Hardener	Thinner 1.911.2510/20
Rigid	Gloss	648g	-	-	-	978g	-
	Fine Text.	299g	673g	-	-	822g	961g
	Coarse Text.	417g	-	756g	-	968g	-
Flexible	Gloss	530g	-	-	712g	982g	-
	Fine Text.	216g	539g	-	613g	888g	972g
	Coarse Text.	284g	-	516g	614g	976g	-



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TECHNICAL DATA

Packsizes	5 Ltr
Storage	Store in a cool dry place away from heat
Theoretical Coverage	8 sq.m. ready for use product at 50 microns build.



VOC INFORMATION

The EU limit for this product (product category: IIB.d) in ready for use form is max. 420g/l of VOC.
The VOC content of this product in ready for use form is max. 420 g/l.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

NOTE:

Combinations of this product with 1.975.1208, 1.975.5500 or 1.975.5501 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC.



SAFETY AND HANDLING

These products are for professional use only and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet, also available at: www.maxmeyer.com



For further information please contact:

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