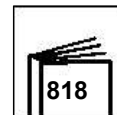


HS CLEAR 0520

1.360.0520

HIGH SOLIDS ACRYLIC CLEAR

HS Clear coat 0520 is a new acrylic 2 component clear coat optimised for use over AQUAMAX® & AquaMax Extra or MAXICAR® basecoats. Suitable for all types of repair, this new Clear coat was developed to improve the repair process allowing an easy to apply conventional in 2 coat or 1 visit application mode. 0520 gives a faster 15min drying process - being hard yet easy to polish if needed and gives great final appearance.



SUBSTRATES

HS Clear coat 0520 should be applied on top of clean and dust-free basecoat.
The use of a tack rag is recommended just prior to clear coat application

PREPARATION

Allow AquaMax to dry thoroughly before application of Clearcoat.
Clean basecoat colour with a tack rag, before clear coat application.

	MIX RATIO / VOLUME
HS Clear 0520	2
HS Hardener 1.954.2730/20/10	1
HS Thinner 1.911.4305/10/20- OR 1.921.6071 High Temperature	0,5
Viscosity- DIN4, 20° C	14 – 16 seconds
Pot Life	2 hour @ 20°C with 2730 1.5 hours @ 20°C with 2720/2710

It is strongly recommended that RFU product be applied at a temperature above 15°C.

HARDENERS AND THINNERS

Temperature	Hardener	Thinner
Up to 20°C	1.954.2730	1.911.4310
20°C - 30°C	1.954.2720	1.911.4310/4320
Above 30°C & IR	1.954.2710	1.921.6071

NOTE

The choice of hardener/thinner should be made according to application temperature, air movement and size of job.

When using IR drying equipment - thinner 1.921.6071 must be used.

At temperatures above 30°C

- Over Aquamax or AquaMax Extra basecoat, thinner 1.921.6071 must be used.
- Over Maxicar basecoat either thinner 1.911.4320 or 1.921.6071 can be used.



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CAR REFINISH

HS CLEAR 0520

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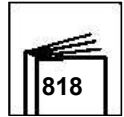
APPLICATION

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 2710 hardener
with 2720 hardener
with 2730 hardener

20 minutes at 60°C
15 minutes at 60°C
15 minutes at 60°C
5 minutes
16-20 hours

Flash off before oven drying
Through dry at 20°C

Infrared Drying

Medium wave
Short wave

*15 minutes
*10 minutes

*Depending on Color and Equipment

RECOATABILITY

Recoatable, 1 hour after baking, and then sanding.



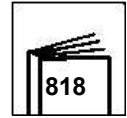
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BEST PRACTICES WITH HS PRODUCTS



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.

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.



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HS CLEAR 0520

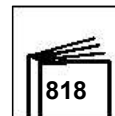
GUIDELINES FOR WEIGHT MIXING

GUIDELINES FOR WEIGHT MIXING

Where a specific volume of clear coat mix is required, this is best achieved by weight mixing.

The weights are cumulative - please do **NOT** tare the balance between additions.

Target Volume of RFU Paint required (Litres)	Weight Clearcoat 0520	Weight Hardener 1.954.2730/20/10	Weight Thinner 1.911.4305/10/20 1.921.6071 High Temp.
0.10 L	57.0	85.3	98.2
0.20 L	114.1	170.6	196.3
0.50L	285.1	426.6	490.9
0.75 L	427.7	639.9	736.3
1.0 L	570.3	853.1	981.7
1.5L	855.4	1279.7	1472.6
2.0 L	1140.6	1706.3	1963.4



POLISHING

If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time.

- Denib dirt with P1200, followed by P1500 dry disc.
- Lightly damp a 3M Trizact P3000 disc or similar with clean water ensuring that the P1500 scratches are eliminated.
- Use Specialty Polishing system SPP1001.
- It is important to start with the lambs wool pad at minimum speed, to avoid the surface becoming too hot. If necessary, allow the panel to cool down before continuing to polish.
- Complete the process using a hard sponge followed by a soft sponge.



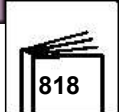
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CLEAR COAT BLENDING PROCEDURE

1. It is recommended to use Aerosol Spot Blender 5411 or Spot Blender 5421.
2. Prepare the surrounding area (the area to be blended) by abrading with Prep Paste 2400 and Grey Ultrafine Scotch-Brite.
3. Thoroughly clean and tack the area to be refinished, ready for painting.
4. Apply 0520 HS Clearcoat according to the information above.
5. After normal application, the gun is arced away from the panel in the blend area leaving a fine, dry overspray edge.
6. Apply the Spot Blender Aerosol (or the Spot Blender through a spraygun) to the clearcoat edge, in light coats to melt the overspray edge. DO NOT apply heavy coats.
7. Allow the paint film to thoroughly cure following the drying recommendations.
8. Lightly polish the blend area with polishing compound (SPP1001), taking care not to polish through the blend. Finish with a finishing polish.



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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