



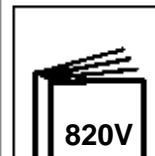
UHS Extra Clearcoat

1.360.0396

UHS Extra Clearcoat

UHS Extra Clearcoat and its dedicated hardeners and thinners have been developed by MAX MEYER® brand using the latest technology to provide an easy to use, extremely fast product which can be used on any sized repair and delivers excellent final appearance. This provides the repairer with a clear and simple choice of clearcoat.

This water white clearcoat has been designed for use over Aquamax Extra and Maxi car. It uses a dedicated hardener to achieve the best performance and a choice of thinners to cover all temperatures.



SUBSTRATES

AQUAMAX® BASECOAT SYSTEMS and MAXICAR®

PREPARATION

Allow basecoat to dry thoroughly before application of clearcoat.
Clean with a tackrag before clearcoat application.



	VOLUME
UHS Extra Clear 1.360.0396	2
UHS HARDENER 1.954.2936/37	1
THINNER 1.921.6075/76	0.6
VISCOSITY- DIN4, 20° C	18-19"
POT LIFE	45-60 min. @ 20° C.

CHOICE OF HARDENER & THINNER

Hardener and Thinner selection – Recommendation			
Temperature (°C)	< 20 and Air-dry	20 < T < 30 Air-dry and Bake	>30 and Bake
Hardener	2936	2937	2937
Thinner	6076	6076	6075

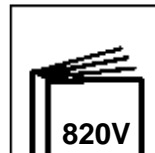


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ADDITIVES

Texture Additive – Fine/Coarse	1.975.5500/5501	See Table on Page 3 of this TDS
Flexible Additive	1.975.1208	



APPLICATION



Gun setup	<i>Compliant Sprayguns</i>
Gravity spray gun nozzle	1.2 mm
Pressure at the gun	As per manufacturers recommendations
Number of coats	½1 coats: 1 medium <u>closed</u> coat + 1 full coat
Suggested thickness	50/60 microns

Important:

One visit application:

1. Visit - One light/medium & one full coat. The first coat should be applied as a light closed coat. Second coat is applied as a full coat

Flash off between coats

One visit application: If 1 -2 panels; 1 minute flash off.

DRYING



	20°C	40°C	60°C
Dust free:	20 minutes	-----	-----
Dry to handle:	60 minutes	20 minutes	5 minutes
Polishing:	90 minutes	after cooling	after cooling

IR Drying: Short wave – 2-3 min @ 50% followed by 5-6 minutes @ 100%

*Note: For IR process use only UHS Hardener 2936 and 6075 Slow Thinner

Drying times will depend on the type of infrared lamp used.

RECOATABILITY

Recoatable, after sanding



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GUIDELINES FOR WEIGHT MIXING

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



Target Volume of RFU Clear Required (Litres)	Weight Clearcoat 1.360.0396	Weight Hardener 1.954.2936/37	Weight Thinner 1.921.6075/76
100,0 ml	56,2g	86,6g	101,6g
200,0 ml	112,4g	173,1g	203,2g
300,0 ml	168,7g	259,7g	304,8g
400,0 ml	224,9g	346,2g	406,4g
500,0 ml	281,1g	432,8g	508,0g
600,0 ml	337,3g	519,3g	609,6g
700,0 ml	393,6g	605,9g	711,2g
800,0 ml	449,8g	692,4g	812,8g
900,0 ml	506,0g	779,0g	914,5g
1000,0 ml	562,2g	865,6g	1016,1g

RATIOS FOR TEXTURED FINISHES

The addition of 1.975.5500/5501 can be used to give a textured finish and 1.975.1208 for flexible finish.

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

PLEASE DO NOT TARE the scale between additions.

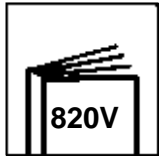
Substrate	Appearance	0396	5500	5501	1208	2936/37	6075/76
RIGID	Gloss	562,2g	-	-	-	865,6g	1016,1g
	Fine Textured	279,8g	612,6g	-	-	763,6g	980,0g
	Coarse Textured	361,4g	-	647,1g	-	816,1g	988,1g
	Appearance						
FLEXIBLE	Gloss	453,1g	-	-	605,4g	866,1g	1014,4g
	Fine Textured	205,1g	497,9g	-	601,3g	748,9g	980,7g
	Coarse Textured	273,5g	-	489,7g	627,6g	814,5g	993,5g



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BEST PRACTICES WITH UHS PRODUCTS



FADE - OUT REPAIR PROCESS

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Apply 0396 according to the information above.
- Take care to minimise the clearcoat edge in the fade-out area.
- Immediately melt overspray edge useing Spot Blender **5421**.
- It is not recommended to fade out on ½ panels such as doors. It is more efficient to Clearcoat the whole panel.
- After a thorough bake or if necessary application of an IR lamp for 5 mins, sand the edge briefly with 3000 grade soft pad on a DA sander.
- This step is not essential but makes the polishing much easier.
- Polish with normal process system.



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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

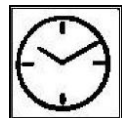


Use correct spraygun set ups, and set up the spraygun correctly.

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

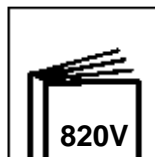


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TECHNICAL DATA

Packsize	5 Ltr
Storage	Store in a cool dry place away from heat
Theoretical coverage	10,2 sqm/l of ready for use product, 50 microns thickness



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:

PPG Industries (UK) Limited. MaxMeyer Division Customer Service & Sales Group, Needham Road, Stowmarket, Suffolk. IP14 2AD, England. Tel: 01449 771779 Fax: 01449 773495

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