



BODY 698 CLEAR COAT HS SR 2:1

Technical Data Sheet No 219

High solid clear coat suitable for full body repairs or spot panel repairs

Excellent mechanical and high chemical resistance

Excellent physical properties

General Technical Description



Mix 2 parts 698 HS CLEAR SR with 1 part BODY 620 / H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENER



Thinner addition 5-15% 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER



Force drying 20-30 min / 60°C (140°F) panel temperature



IR drying 8-14 min distance: 60 - 70cm

Surface

HB BODY Color Solutions Basecoat Mix System

HB BODY Color Solutions 2K Acrylic Mix System

HB BODY Color Solutions Aquabase Mix System

Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER



Make sure the surface is first wiped dry and then air dried.



Make sure you always use appropriate face protection and good ventilation

Product Application: 2 passes »» Apply one coat, and after the 5-10 min flash off time apply the second full coat.



2:1 mix with BODY 620 / H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENER
Pot life: > 4h / 23°C (73°F)



5-10 min / 23°C (73°F)
Flash off time

Flash Point:
24°C / 75°F

Specific Gravity:
0.979g/cm³

Solid Content (No thinner):
50% Weight

VOC (2004/42/EC)
This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 567 g/L.
2004/42/II(b)(e)(840)567

Theoretical Coverage:
8 - 9m² / l at 50 micron (2.4mil) dry film thickness

Cleaning of equipment:

Clean after final use with 740 ACRYL NORMAL THINNER

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with BODY HARDENERS
- It can only be used by countries that do not adopt the VOC legislation
- 2K paint systems tend to react with water, hence all the equipment used must be moisture free.

Storage shelf life:

- Store in a cool place +5°C - +25°C (+40 - +77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



Addition 5-15% of thinner. Use 740 NORMAL / 741 SLOW ACRYL THINNER



Non force drying 8 - 16 hrs / 23°C (73°F)
Force drying 20 - 30 min / 60°C (140°F) panel temperature



IR drying Short wave 8-10 min distance: 60 - 70cm

Always wear protective equipment



Ready to spray:
16-17s
DIN 4 / 20°C (68°F)



Compliant Spray gun
1.3 - 1.5 mm
2-3 bar (29 - 44 psi) inlet pressure
2x coats = 50 - 60µm (2 - 2.40mil)



Follow the application instructions mentioned in this TDS



HVLP 1.2 - 1.3mm
2 bar (29 psi) inlet pressure
2x coats = 50 - 60µm (2 - 2.40mil)

Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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Product Application with Hardener 620 / H754 FAST:

Temperature	Orange peel Surface 1-2 parts	Levelling Surface 1-2 parts	Full Repair
<15°C	H754/620+5-10%740 20min / 60 °C (140°F)	H754/620+5-15%740 20min / 60 °C (140°F)	H754/620+5-15%740/741 20min / 60 °C (140°F)
15-25°C			
25-30°C	H754/620+5-10%740/741 20min / 60 °C (140°F)	H754/620+5-15%740/741 20min / 60 °C (140°F)	
>30°C			

Product Application with H753 NORMAL / H752 SLOW Hardener:

Temperature	Orange peel Surface 1-2 parts	Levelling Surface 1-2 parts	Full Repair
<15°C	H753+5-10%740 30min / 60 °C (140°F)	H753+5-15%740 30min / 60 °C (140°F)	H753+5-15%740 30min / 60 °C (140°F)
15-25°C			
25-30°C		H752/H753+5-15%740 30min / 60 °C (140°F)	H752/H753+5-15%740/741 30min / 60 °C (140°F)
>30°C	H752/H753+5-10%740/741 30min / 60 °C (140°F)	H752/H753+5-15%740/741 30min / 60 °C (140°F)	

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