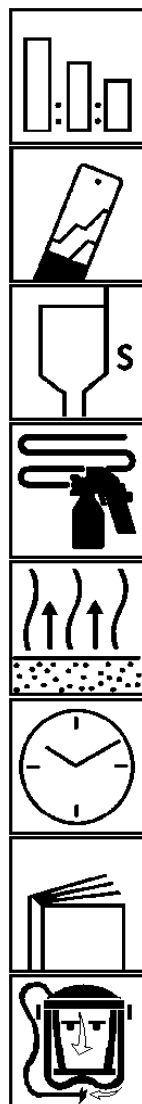


PRIMACLEAR 808



100:50:10
 Primaclear 808
 Hardener 808
 Multi Thiner

1

15-16

(syphon feed)
 2*1
 1.3-1.6 mm
 2-4 bar

5-10 mins.

3 hrs. 30°C.
 20 mins. 60°C.

7.3.2.0.3

Description:

Two-pack clearcoat formulated for the Primabase/Catinabase system

Product and Additives:

Primaclear 808
 Hardener 808
 Multi Thiner

Basic Raw Materials:

Primaclear 808: acrylic resins.
 Hardeners: polyisocyanate resins.

Suitable Substrates:

- Catinabase
- Primabase
- Catinacryl

Mixing Ratio by Volume:

100 parts of Primaclear 808
 50 parts of Hardeners 808
 10 parts of Multi Thiner

Spraying Viscosity:

15-16 s DIN Cup 4 at 20°C.

Potlife:

When mixed with Hardener 808: 2½ hrs at 20° C

Spray gun fluid tip and working pressure:

Spray gun:	Fluid tip:	Working pressure:
Gravity feed:	1.2-1.5 mm	4-5 bar
Syphon feed:	1.4-1.6 mm	4-5 bar
Pressure feed:	1.1-1.2 mm	5-6 bar

Application Process:

Spray 2 single wet coats, allowing for a flash-off time of 7-10 minutes between coats.

Note: The specified flash-off times depend on temperature and air velocity. After allowing for a flash-off time of 8-10 minutes of the final coat of Primaclear 808, it can be force dried at 60°C.

Lettering: Within 48 hours, Catinacryl can be applied directly over Primaclear 808. After this 48 hour-period, previous scuffing with Scotch Brite Type S Ultra Fine or application of an intermediate coat of Catinacryl Sealer is required.

Film Thickness:

20-25 µm per coat

Cover rate:Theoretical: 9 m²/l unthinned paint at 70µm.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

In Multi Thiner, Catina Solvent or a nitrocellulose thinner.

Drying times:	At 20°C:	
Hardener 808	20°C:	60°C:
Dust dry:	45 mins	5 mins
Tack-free:	4 hrs	20 mins
Dry to handle:	10 hrs	30 mins
Hard dry:	13 hrs	45 mins

Dust ingress and minor damage in the Primaclear 808 finish can be polished out after allowing for the following drying times:

Ready to polish:	At 20°C:	At 60°C:
	2 days	1.5 hrs

First flat out dust particles carefully with SF sandpaper, then polish the area manually or mechanically.

Packaging:

1 lt & 5 lt

HEALTH & SAFETY DATA concerning Primaclear 808:For professional use only.(See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.