







TECHNICAL DATA SHEET ULTIMATE 2K HS DTM Clearcoat

DESCRIPTION

Date: 18-Jul-2023

ULTIMATE 2K HS DTM CLEARCOAT is a compliant clear – it is a high solids clearcoat specially formulated to allow easy application, good vertical hold up while also giving good flow properties. The Direct To Metal (DTM) clearcoat when cured, gives good depth of gloss to the final finish.

Composition: Acrylic Resins
Colour: Water white
Shelf life: 36 months in unopened container
Pack size: 1 Litre/5 Litre
Pre-treatment: FL8050 **ULTIMATE 2K HS DTM CLEARCOAT** can be applied direct to metal.

	Health and safety “For professional use only” Important: When using any new product, consult the “Health and Safety” data sheet. Always read the risks and precautions stated on the product label.														
	Mixing Ratio 2 : 1 10% <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: center; width: 33%;">2</td> <td style="text-align: center; width: 33%;">1</td> <td style="text-align: center; width: 33%;">10%</td> </tr> <tr> <td style="text-align: center;">FL8050</td> <td style="text-align: center;">FL2050</td> <td style="text-align: center;">FL2021/2</td> </tr> <tr> <td style="text-align: center;">ULTIMATE DTM 2K HS CLEARCOAT</td> <td style="text-align: center;">ULTIMATE 2K HS HARDENER</td> <td style="text-align: center;">Final Systems 2K Thinners</td> </tr> </table>			2	1	10%	FL8050	FL2050	FL2021/2	ULTIMATE DTM 2K HS CLEARCOAT	ULTIMATE 2K HS HARDENER	Final Systems 2K Thinners			
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ULTIMATE DTM 2K HS CLEARCOAT	ULTIMATE 2K HS HARDENER	Final Systems 2K Thinners													
	Spraying Viscosity 18 to 20 seconds BS 4 cup at 20°C – 14 to 16 seconds DIN4 cup 20°C Pot life – 2 ½ hours at 20°C dependent on speed														
	HTE/RP spray gun fluid tip 1.2 – 1.3 HVLP gravity feed fluid tip 1.2 – 1.5 Recommended Spray Pressure 2 – 2.5 bar														
	Number of coats 2 First coat: ½ coat closed Second coat: full coat At 20°C 3 to 5 minutes flash off between coats – 5 minutes flash off before bake or IR curing. Film thickness 40 – 50 micron.														
	Air Dry at 20°C dust free 10 minutes, tack free 1 hour, hard dry 3½ hours (fast) <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 5px;"> <thead> <tr style="background-color: #333; color: white;"> <th style="text-align: left;">Hardener</th> <th style="text-align: center;">Bake Time (60 °C)</th> <th style="text-align: center;">IR Drying Time</th> </tr> </thead> <tbody> <tr> <td style="text-align: left;">STANDARD</td> <td style="text-align: center;">30 minutes</td> <td style="text-align: center;">16 minutes</td> </tr> <tr> <td style="text-align: left;">FAST</td> <td style="text-align: center;">20 minutes</td> <td style="text-align: center;">12 minutes</td> </tr> <tr> <td style="text-align: left;">EXTRA FAST</td> <td style="text-align: center;">15 minutes</td> <td style="text-align: center;">9 minutes</td> </tr> </tbody> </table> Gloss will vary depending on speed used. For best results fast hardener will give good dry time and gloss level. Bare in mind booth temperature and the time taken to get to temperature. Times may vary based on the environment. Accelerators should not be used with DTM products. ULTIMATE 2K HS Super Rapid Hardener should not be used under any circumstances with ULTIMATE 2K HS DTM Clearcoat.			Hardener	Bake Time (60 °C)	IR Drying Time	STANDARD	30 minutes	16 minutes	FAST	20 minutes	12 minutes	EXTRA FAST	15 minutes	9 minutes
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