

GENERAL INFORMATION

C401 HS420 High Production Clear is a polyurethane high quality clear with high durability for application over W00 - W999 Octobase Eco Plus System and B00 - B999 Octobase System. Suitable for most repair work due to its good processing properties. Specially developed for air drying and also suitable for low bake and forced drying.

MIXING RATIO



3 : 1 Clear : HS420 Hardener + 10% Uni Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F)	H23	✓		
	H24	✓	✓	
	H25		✓	✓
	H26			✓
25°C - 30°C (104°F)	H23			
	H24	✓	✓	
	H25	✓	✓	✓
	H26		✓	✓
>30°C (140°F)	H23			
	H24	✓		
	H25		✓	
	H26		✓	✓

POT LIFE AT 20°C / 68°F



HARDENER	H23	H24	H25	H26
Potlife (min)	20	35	40	55

COMPONENTS



H23 HS420 Hardener Very Fast
H24 HS420 Hardener Fast
H25 HS420 Hardener Medium
H26 HS420 Hardener Slow
TA900 Uni Thinner Fast
TA910 Uni Thinner Medium
TA920 Uni Thinner Slow
TA855 Spot Repair Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1,2-1,4	2,0-2,5/29-36

APPLICATION



1½ - 2 coat 50 - 80 µm (2,0-3,2 mil)

1,5 coats: No flash off between coats.
2 coats: 5-10 min flash off between coats.

FLASH OFF AND DRY TIMES



	HARDENER	FLASH OFF BEFORE BAKE (MIN.)	DUST FREE (MIN.)	DRY TO HANDLE (MIN.)	DRY TO POLISH (H)
Air Dry 20°C (68°F)	H23	x	25	90 - 110	5
	H24	x	35	120 - 140	12
	H25	x	45	130 - 150	16
Low bake 40°C (104°F)	H23	2 - 2	x	30	After cooling down
	H24	5 - 10	x	45	
	H25	10 - 15	x	60	
Forced Dry 60°C (140°F)	H23	2 - 2	x	25	After cooling down
	H24	5 - 10	x	35	
	H25	10 - 15	x	40	

***Depending on the layer thickness and temperature.**
Use matching thinners.

INFRARED DRYING



After full flash off and at proper distance		
Half-bake		4 min 50°C
Full-bake		10 min 65°C
See IR Manufacturer information		

SUBSTRATES



W00 - W999 Octobase Eco Plus System and B00 - B999 Octobase System. Sanded and degreased old layers.

Basecoat should be fully dry.

ADDITIVES



AE001 Elastic 2K
AC001 2K Structure Coat Fine
AC002 2K Structure Coat Coarse

Use TA875 Fade-Out Thinner for blending or fade-out areas.

SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIIB(d)(420)412
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIIB/d. Topcoat - All types. EU limit values: 420 g/l (2007). This product contains amaximum of 412 g/l VOC.
Chemical Base	Solventborne 2K Polyurethane	
Physical Properties	Viscosity (RTS)	16 - 18 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,004
	Flash Point Closed Cup	34°C / 93,2°F
	Volume % Solids	48
	Economy	9,6 m²/L/50 µm 390 ft²/Gal/2 mil
	Gloss	High gloss
	Colour	-

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



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