

GENERAL INFORMATION

F00 - F98 Octocoat HS420 System is a VOC compliant high quality 2-pack finish. With a high UV resistance and gloss retention. Specially developed for passenger cars, commercial vehicles and equipment.

OCTOCOAT HS420 SYSTEM

F00 - F98

MIXING RATIO



2 : 1 HS420 Top Coat : Octocoat Hardener + 20% Thinner 2 : 1 HS420 Top Coat : Octocoat Hardener + 20% AT001

HS Taping Additive

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2 - 1,3	2/29
HE	1,2 - 1,3	2,0 - 2,5 / 29 - 36
Pressure tank	0,85 - 1,1	-
Airless/ Airmix	0,009" - 0,011" / 40°	180 - 200

APPLICATION



1,5 - 2 coat 50 - 75 μm (2,0 - 3,0 mil) 3 - 12 minutes Flash off

FLASH OFF AND DRY TIMES

	Type of repair	Hardener	Thinner	Time at 60°C
<u> </u>	High temp. total respray objects (van)	H20	TF20	40 minutes
	Normal temp. total respray high temp. panel repair	H20	TF10	30 minutes
	Normal temp. panel repair	H20	TF00	20 minutes

roper distance

INFRARED DRYING

	After full flash off and at
	Half-bake
	Full-bake
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l-bake 8 min 80 °C
See IR Manufacturer information

SUBSTRATES



F00 - F98 Octocoat HS420 System should only be applied over well sanded/scuff ed and degreased primed bare steel, primed aluminium and primed plastic. Old paint systems in good condition.

4 min 60°C

Please make sure you choose a suitable primer/ surfacer by checking the TDS of the primer/surfacer.

POT LIFE AT 20°C / 68°F

30 - 120 minutes

COMPONENTS



H20 Octocoat Hardener TF00 Octocoat Thinner Fast TF10 Octocoat Thinner Medium TF20 Octocoat Thinner Slow TA855 Spot Repair Thinner TA875 Fade-Out Thinner

ADDITIVES



AC001 2K Structure Coat Fine AC002 2K Structure Coat Coarse AE001 Elastic 2K AM004 HS Matting Agent AT001 HS Taping Additive AE001 2K Elastic

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P400 or fi ner grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with TD20 Silicone Remover wipe on and wipe dry.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



PHYSICAL DATA

EU REGULATIONS F00 - F98 Octocoat HS420 System						
VOC Code		2004/42/IIB(d)(420)402				
Product sub category (according directive 2004/42/ EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/d. Topcoat - All types. EU limit values: 420 g/l. (2007). This product contains a maximum of 402 g/l VOC.				
Chemical Base	2K Polyurethane Topcoat					
	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C				
	Specific Gravity (kg/l)	1,034				
	Flash Point Closed Cup	28,5°C / 83,3°F				
	Volume % Solids	54				
	Economy	11 m²/L/50 μm				
		440 ft²/Gal/2 mil				
	Gloss	High gloss				
	Colour	-				

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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).

NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.

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