

### 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.

### MIXING RATIO



2 : 1 HS420 Top Coat : HS420 Hardener + 15% Special Thinner

### GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,4	2/29
HE	1,2-1,4	2,0-2,5/29-36
Pressure tank	0,85-1,1	-
Airless/ Airmix	0,009"- 0,011"/40°	180-200

### APPLICATION



2 coat 50 µm (2,0 mil)

### FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 10 minutes	Flash off	5 - 10 minutes
Dust free	-	Dust free	-
Dry to handle	15 minutes	Dry to handle	20 - 40 minutes
Dry to tape	15 minutes	Dry to tape	-
Dry to sand	15 hours	Dry to sand	20 - 40 minutes
Dry to polish	15 hours	Dry to polish	48 hours

### SUBSTRATES



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

**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 minutes - 120 minutes

### COMPONENTS



H23 HS420 Hardener Very Fast  
H23 HS420 Hardener Very Fast  
H24 HS420 Hardener Fast  
H25 HS420 Hardener Medium  
H26 HS420 Hardener Slow  
PE420 HS420 Special Thinner  
TA900 Uni Thinner Fast  
TA910 Uni Thinner Medium  
TA920 Uni 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

### SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P400 or finer 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		
VOC Code	2004/42/IIIB(d)(420)402	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the	IIIB/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	
Physical Properties	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 m <sup>2</sup> /L/50 µm 440 ft <sup>2</sup> /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](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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