



# C 894 CLEAR ULTRA HS 2:1

Technical Data Sheet No 228

VOC compliant with the regulations

Ultra high solid clear coat suitable for full body or spot panel repairs

Great gloss retaining

Excellent mechanical and high chemical resistance

Excellent end finish

## General Technical Description



Mix 2 parts C 894 CLEAR ULTRA with 1 part **H 734 NORMAL / H 735 FAST / H 733 SLOW HARDENER**



No thinner addition



Oven force drying\*\*  
25-40 min / 60°C (140°F)  
panel temperature



IR drying 12-18 min\*\*  
distance: 80cm

## Surface

Body Basecoat

Waterborne base coat

2K Acryl paints

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

**Product Application:** 1.5 passes »» Apply a 'gripping' coat, and after a 0 - 2 min waiting time apply the second full coat.\*



2:1 mix with **H 734 NORMAL / H 735 FAST H 733 SLOW HARDENER**  
Pot life: 90 - 135 min  
23°C (73°F)



Non force dry\*\*  
Air drying over night  
16-20h 23°C (73°F)  
Flash off time before you can stop spray booth recirculation (air drying) 10-15min.

**Flash Point:**  
27°C / 81°F

**Specific Gravity:**  
0.977 g/cm<sup>3</sup>

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with **H 734 NORMAL, H 735 FAST and H 733 SLOW HARDENER**
- It can also be used by countries that do not adopt the VOC legislation



No thinner required



Oven force dry\*\*  
25-40 min / 60°C (140°F)  
panel temperature  
Flash off time before force drying 10-15 min

**Solid Content (No thinner):**  
57.5% Weight

### VOC (2004/42/EC)

This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 420 g/L. The VOC content in the ready for use form of this product is 419 g/L. 2004/42/IIIB(d)(420) 419

### Storage shelf life:

- Store in a cool place +5°C - +25°C (41 - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.



Ready to spray:  
18-20 s  
DIN 4 / 20°C (68°F)



IR drying (short wave)\*\*  
Flash off time before IR drying 15 min  
Half power 5 min  
Full power 12-18 min  
distance: 80cm

### Theoretical Coverage:

10 - 12 m<sup>2</sup> / l at 50 micron (2 mil)  
dry film thickness

### Application conditions\*

#### For partial or spot repairs:

T = 15-20°C (59-68°F) use H 735 Fast Hardener  
T = 20-30°C (68-86°F) use H 734 NORMAL Hardener  
T = 30-35°C (86-95°F) use H 733 Slow Hardener  
Rel. humidity 40 - 80%

#### For complete car repair:

T < 25°C (77°F) use H734 Normal Hardener  
T = 25-35°C (77-95°F) use H 733 Slow Hardener  
Rel. humidity 40-80%



Compliant Spray gun  
1.3 - 1.4mm  
2 - 3 bar (29-44psi)  
inlet pressure  
1.5 x coats = 50-60µm  
(2 - 2.4 mil)



Always wear protective equipment



HVLP 1.2 - 1.3 mm  
2 - 2.5 bar (29-36psi)  
inlet pressure  
1.5 x coats = 50-60µm  
(2 - 2.4 mil)



0 - 2 min / 23°C (73°F)  
Flash off time



Follow the application instructions mentioned in this TDS

\*\* Depends on hardener and thickness of the clear coat (sug. 50-60µm (2 - 2.4 mil))

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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