



# Product Training

Clearcoat

A brand of

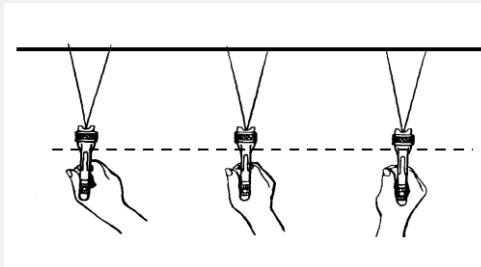
 **BASF**

We create chemistry

# Clearcoat

## HVLP technology

Due to the reduced spraying pressure of the HVLP spraygun, the paint must be applied to the panel from a distance of just about 10 to 15 cm.





## Clearcoat

The spraygun stroke must be parallel to the panel surface. Even on vertical surfaces, the spray pattern should be aligned with the shape of the car body.

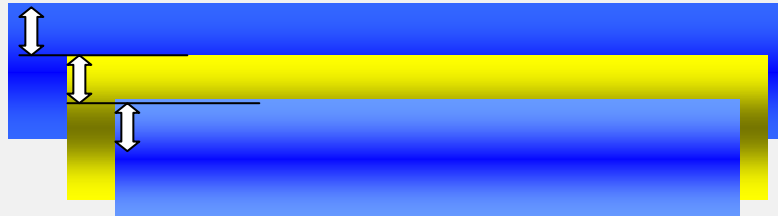
Especially when painting horizontal surfaces such as bonnets, perfect spraygun handling is absolutely indispensable for achieving a perfect result.



# Clearcoat

## Overlaps

The gun strokes must overlap by about 75%.



# Clearcoat



## 40-10 2 K Panel Clear

This clearcoat is easy and safe to spray and fast drying. It is easy to polish and can be used in bodyshops with simple equipment not having the possibility of forced drying. The clearcoat is used vertical on 1 or 2 panels, for multi-coloured paint-jobs, sign-writing, panel repairs and plastic parts.



# Clearcoat



## 40-40 2K Clear Universal

A high quality HS clear for baslac basecoat 35 with high solids content, excellent weathering resistance, good polishing, high gloss and high finish quality.

As MS standard clear for baslac basecoat 35 with medium solids content, easy and safe to spray, fast drying, high finish quality, easy to handle and polish.





# Clearcoat

## 40-440 2K Clear VOC

HS VOC clear for basecoat

This clearcoat is safe to spray with high solids content. It has excellent flow and levelling abilities is fast drying with an excellent surface hardness, polishing behavior and tape resistance.

Select hardener and reducer according to ambient temperature and size of object to be painted



# Combination of baslac hardeners and reducer in baslac clearcoats



Clears

	50-15	50-20	50-30	50-415	50-420	60-10	60-20	60-30	60-40
40-10	X	X	X			X	X	X	X
40-40	X	X	X			X	X	X	X
40-440				X	X				



Not applicable



Possible combination





## 40-10 / 2K Panel Clear

MS clear for baslac basecoat 35-

- Easy and safe to spray, fast drying, easy to polish
- To be used on: 1 or 2 vertical panels
- Multi-colored paint jobs, signwriting and plastic parts





# 40-10 / 2K Panel Clear

## Application



	<b>Mixing ratio</b> 2 : 1 + 10-30%	100% by vol. 40-10 50% by vol. 50-20, -15, -30 10-30% by vol. 60-10, -20, -30, 40
	<b>Spray viscosity</b> DIN 4 at 20°C	16 s
	<b>Potlife</b>	4 h / 20°C
	<b>High pressure spray gun</b>	1.3 – 1.4 mm
	<b>Number of spray coats</b> <b>Film thickness</b>	2 – 3 50 – 60 µm





# 40-10 / 2K Panel Clear

## Drying

	<b>Drying at 20°C</b> <b>at 60°C</b>	Tack free 2 h -	Polishable 4 h -
	<b>Infrared: (short wave)</b> <b>(medium wave)</b>	8 min. 10 – 15 min.	





## 40-40 / 2K Universal Clear

Clear for baslac basecoat 35-

- High solids content, excellent weathering resistance
- Good polishing behavior
- High gloss, high finish quality





# 40-40 / 2K Universal Clear

Application Process for high quality HS clear




	<b>Mixing ratio</b> 2 : 1 + 10%	100% by vol. 50% by vol. 10 % by vol.	40-40 50-20, -30 60-10, -20, -30, 40
	<b>Spray viscosity</b> DIN 4 at 20°C	18 - 20 s	
	<b>Potlife</b>	4 h / 20°C	
	<b>High pressure spray gun</b>	1.3 – 1.4 mm	
	<b>Number of spray coats</b> <b>Film thickness</b>	2 50 – 70 µm	





# 40-40 2K Universal Clear

Drying Process for high quality HS clear

	<b>Flash off at 20C</b>	<b>2 – 3 minutes after each spray coat</b>
	<b>Drying at 20°C at 60°C</b>	<b>8 h</b>
	<b>Infrared: (short wave) (medium wave)</b>	<b>8 min. 10 – 15 min.</b>





# 40-40 / 2K Universal Clear

## Application Process for MS standard clear




	<b>Mixing ratio</b> 2 : 1 + 30%	100% by vol. 40-40 50% by vol. 50-20, -30 30 % by vol. 60-10, -20, -30, 40
	<b>Spray viscosity</b> DIN 4 at 20°C	14 - 16 s
	<b>Potlife</b>	4 h / 20°C
	<b>High pressure spray gun</b>	1.3 – 1.4 mm
	<b>Number of spray coats</b> <b>Film thickness</b>	2 – 3 40 – 60 µm





# 40-40 2K Universal Clear

## Drying Process for MS standard clear

	<b>Flash off at 20°C</b>	<b>2 – 3 minutes after each spray coat</b>
	<b>Drying at 20°C</b> <b>at 60°C</b>	<b>5 h</b> <b>30 min.</b>
	<b>Infrared: (short wave)</b> <b>(medium wave)</b>	<b>8 min.</b> <b>10 – 15 min.</b>







## 40-440 / 2K VOC Clear

HS VOC clear for basecoat

- High solids content, safe to spray
- Excellent flow and levelling
- Fast drying, excellent surface hardness
- Polishing behavior and tape resistance

Select hardener and reducer according to ambient temperature and size of object to be painted.





# 40-440 / 2K VOC Clear

## Application

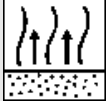


	<b>Mixing ratio</b> 2 : 1	100% by vol. 50% by vol.	40-440 50-420, -415
	<b>Spray viscosity</b> DIN 4 at 20°C	20 – 22 s	
	<b>Potlife</b>  <b>High pressure spray gun</b>	2 h / 20°C	
	<b>Number of spray coats</b> <b>Film thickness</b>	2 40 – 60 µm	1/2 + 1 can be applied to vertical surfaces (no flash-off between coats required) approx. 50 µm





# 40-440 2K VOC Clear

## Drying

	<b>Flash-off at 20°C</b>	3 minutes between spraycoats
	<b>Drying at 20°C</b> <b>at 60°C</b>	10 h 30 min.
	<b>Infrared: (short wave)</b> <b>(medium wave)</b>	8 min. 10 – 15 min.

