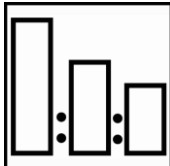

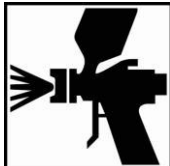
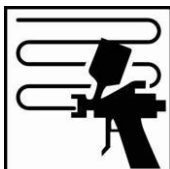
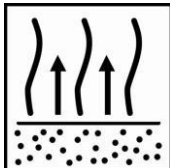




2K super weather resistance Clear coat A855

FOR PROFESSIONAL USE ONLY

Description		
High-build, two-component clear coat designed for universal application and optimal appearance for onwings and onwaves' coat system which secures excellent flow and gloss.		
	100 A855 50 Hardener 20-30 Thinner	
	Use Donglai measuring stick	
	Spray gun set-up: 1.5-1.7mm(suction type gun) 1.3-1.5mm((gravitational type)	Application pressure: 1.7-2.2 bar at the air inlet
	2 x 1 coat Apply 2 single coats(40~80 μm)	
	Between coats 3-5 minutes at 20 ℃ Thinner selection according temperature	Before curing 3-5 minutes at 20 ℃ Flash-off time depending on oven type
	Air-dry time at 68°F/20℃ Force dry at 140°F/60℃	3 ~ 4hours 45 ~ 60 minutes
	Use suitable respiratory protection Donglai onwings Car Refinishes recommends the use of a fresh air supply respirator.	

2K super weather resistance Clear coat A855

FOR PROFESSIONAL USE ONLY

Product and additives

For repair over plastics (bumpers etc).

Add 15% plastic softener A825 to the clear coat component.

Product name

2K Super Clear coat A855

Hardener

A803 Slow dry Hardener; repairs at 25-35 °C

A802 Standard Hardener; repairs at 15-25 °C

A801 Fast dry Hardener; repairs at 5-15 °C

Thinner

A812 Slow dry Thinner; repairs at 25-35 °C

A811 Standard Thinner; repairs at 15-25 °C

A810 Fast dry Thinner; repairs at 5-15 °C

Basic raw materials

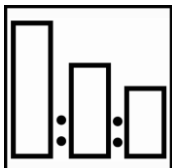
2K Super clear coat A855: Acrylic and polyester resins

Hardener: Poly-isocyanate resins

Suitable substrates

Onwings or onwaves basecoat after 15 minutes flash off time at 25 °C

Mixing



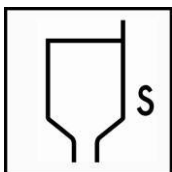
100 A855

50 A802

20-30 A811

Use Donglai measuring stick

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C

Spray gun set-up / application pressure

Spray gun set-up

Gravity feed gun 1.3-1.5 mm

suction type gun 1.5-1.7mm

Application pressure

1.7-2.2 bar at the spray gun air inlet

Application process

Apply a full coat, allowing for a 5-8 minutes flash-off time at 20 °C.

Next, apply a full coat, allowing for a 5-8minutes flash-off time at 20 °C before baking

2K super weather resistance Clear coat A855

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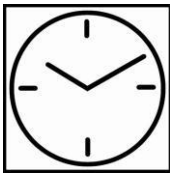
Pot-life

Slow dry Hardener 3-4 hour at 20 ℃
Standard Hardener 4 hours at 20 ℃
Fast dry Hardener 4 hours at 20 ℃

Film thickness

By using the recommended application: 40-80 μm.

Drying times



Dust free 8-10min at 20 ℃, 45min at 60 ℃
Dry to handle 5hrs at 20 ℃, 60min at 60 ℃

Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60 ℃ object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according polishing recommendations. Ready to polish approximately 1 hour after cool down to ambient temperature.

Material usage

By using the recommended application, the theoretical material usage is ±7.2 m²/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Onwings solvents

Product storage

Product shelf-life is 2 years when products are stored unopened at 20 ℃. Avoid extreme temperature fluctuation.