

C320 2K Clearcoat

FOR PROFESSIONAL USE ONLY

Description

A 2K medium solids clearcoat for spot and panel applications. U-TECHC320 2K Clearcoat offers excellent flow and rich gloss levels with just two coats. Designed for ease of polishing, this Clearcoat allows for quick polishing even after aggressive sanding of film. The clearcoats film hardens to the standards of even the toughest fleet finishes. U-TECH C320 Clearcoat offers excellent durability and a high gloss finish over U-TECH Polybase, or Polybase Plus.



4 C320 2K Clearcoat
1 U2KA Activator



Use measuring stick
109



Spray gun set-up:
1.2-1.5 mm
HVLP max. 10 psi at air cap

Application pressure:
40-50 psi (3-4 bar)
o Check gun manufacturer specification



2-3 x 1 coat
Apply single coats



Between coats
7-10 minutes at 70°F (20°C)



Dry Times	70°F (20°C)	140°F (60°C)
Dust	20 Minutes	15 Minutes
Handle	6 Hours	30 Minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Description

A two component clearcoat consisting of one clearcoat, one universal hardener that can be used in the P80 2K Primer.

Product and additives

Product	C320 2K Clear
Hardener	U2KA Activator
Reducers	None
Additives	None

Basic raw materials

C320 2K Clear: Acrylic resin, solvent additives
U2KA Activator: Poly-isocyanate solvents

Suitable substrates

- U-Tech Polybase or Polybase Plus after a minimum flash off time of 15 minutes at 70°F (20°C).
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

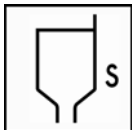
Mixing Ratio



4 parts by volume of C320 2K Clear
1 parts by volume U2KA Activator

For easy and accurate mixing, use measuring stick No. 109

Viscosity



18-12 seconds – DIN Cup #4 at 70°F (20°C)
40-50 psi at the spray gun air inlet

Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
HVLP gravity	1.2-1.5 mm	HVLP max 10 psi at the air cap
High Transfer gravity	1.2-1.5 mm	Check gun manufacturer specification.
High Transfer Pressure Feed	1.2-1.0 mm	
HVLP Pressure Feed	N/A	

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Application process



Apply two-three coats, allowing for a 7-10 minutes flash off time.
Allow for a 0-5 minutes flash-off time before baking.

Pot-life

2 hours at 70°F (20°C)

Film thickness

Per coat: 1.0-1.2 mils. (25-30 µm)
The total dry layer thickness: 1.7-2.4 mils. (45-60 µm)

Drying times

Allow a 5 minute flash-off time before moving the car into a pre-heated drying oven (booth).
All drying times relate to standard application and object temperature.



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70°F (20°C)	Dust dry	20 minutes
	Dry to handle	6 hours

140°F (60°C)	Dust dry	15 minutes
	Dry to handle	30 minutes

Through-hardening:

Following the drying cycle at 140°F (60°C) object temperature, allow the C320 2K Clear to cool fully to ambient temperature to complete the through-hardening process.

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Recoatibility & blending

- Recoatable with itself at any stage. Sanding becomes necessary after 24 hours
- For blending (spot repair and panel blends), Please see TDS Spot Repairs with Polybase and Polybase Plus Basecoat

Polishability



Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according to the polishing recommendations.

- Ready to polish approximately 1 hour after cool down to ambient temperature.
- Carefully sand out dust particles with #1500 then #2000 grit paper wet or finish with the 3M Trizact P3000 system, and then polish the area mechanically with 3M Perfect-It 3000 Rubbing Compound System.

Material usage

With recommended application, the theoretical material usage is ± 410 sq.ft./gl (10 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, method and application circumstances.

Cleaning of equipment

Clean equipment with solvent borne gun cleaners

VOC

(4:1 Ready to spray mixture) C320 2K Clear: 2.1 lb/gal 250 g/liter – Need data from lab

Product storage

Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C) Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- Product shelf life: 3 years

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IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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