HS Clear Coat

Technical Data Sheet: 450-49
H0150

1. Introduction

ALEXSEAL HS Clear Coat is a high solid two-component polyurethane based clearcoat developed for base coat / clear coat application over ALEXSEAL HS Base Coat. ALEXSEAL HS Clear Coat is characterized by a high gloss appearance with wet-look effect, as required for yacht coatings. The special product properties reduce the cleaning and maintenance effort and increase the value retention. After curing, the coating meets the highest requirements for gloss and color stability, even under extreme climatic conditions.

2. Range of application

ALEXSEAL HS Clear Coat is used in combination with ALEXSEAL HS Base Coat as an extreme high-gloss topcoat in spray applications. It can be used internally or externally in areas not subject to permanent water immersion.

3. Color

Clear

4.Coverage

Volume Solids catalyzed without reduction: 50%
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base and converter.

	m² / liter	**m² / gal**	**sq. ft. / gal**	**@ DFT in µm (mils)**
Theoretical	7.5	28.5	313.5	70 (2.8)
Practical				
Conventional Air Spray Equipment	4.5	17.1	188	70 (2.8)
HVLP Air Spray Equipment	5.7	21.4	235	70 (2.8)

5. Substrate pre-treatment

ALEXSEAL HS Clear Coat has to be applied after the ALEXSEAL HS Base Coat has dried a minimum of 2 hours at 20°C (68°F), up to a maximum of 72 hours. The maximum re-coating time of the ALEXSEAL HS Base Coat should not be exceeded.

6. Trade names & Packaging

H0150	ALEXSEAL HS Clear Coat	1 Gal
C5067	ALEXSEAL HS Clear Coat Converter	1 Gal
R5561	ALEXSEAL HS Clear Coat Activator Medium	1 Gal
R5531	ALEXSEAL HS Clear Coat Activator Slow	1 Gal

7. Mixing ratio

1 parts by volume	H0150	ALEXSEAL HS Clear Coat
1 part by volume	C5067	ALEXSEAL HS Clear Coat Converter
1 part by volume	R….	ALEXSEAL HS Clear Coat Activator (see above)

Example: 1 : 1 : 1 = 50 % reduction

The amount of ALEXSEAL HS Clear Coat Activator (activated reducer) is fixed and cannot be changed. Mixed material must be filtered with a decent sized paint filter before application.

8. Application

Viscosity	Zahn #2 Signature≈19 - 21 sec, DIN 4 cup 4mm≈15 - 17sec, ISO 3≈45 sec
Nozzle Size Gravity Gun	1.0 to 1.3 mm (0.040 to 0.051 inch) - Conventional & HVLP
Nozzle Size Siphon Cup	1.0 to 1.3 mm (0.040 to 0.051 inch) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	0.8 to 1.0 mm (0.032 to 0.040 inch) - Conventional & HVLP
Atomizing Pressure	2.5 to 4.0 bar (40 to 60 PSI) - Conventional & HVLP
Pot Pressure	0.5 to 1.2 bar (7 to 16 PSI) - Conventional & HVLP

Application by Spraying:

ALEXSEAL HS Clear Coat is intended to be part of a base coat / clear coat finish. This system needs to be applied in 2 steps.

After the ALEXSEAL HS Base Coat has dried, 2 coats of ALEXSEAL HS Clear Coat are applied to seal the base coat. Apply 2 cross coats with a wet film thickness (WFT) of 80 - 100 µm (3 - 4 mils) per cross coat. After one cross coat, flash-off time is 30 minutes to 4 hours.

Professional Use Only

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This results in a dry film thickness (DFT) of 60 - 100 µm (2.4 - 4 mils) in two cross coats. Use freshly prepared material for the second application.

9 Pot life and Drying Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life Clear Coat- approx.	3 hrs	2.5 hrs	2 hrs	1.5 hrs	N/A
Dust Free	3 hrs	3 hrs	2 hrs	2 hrs	N/A
Tape Dry and sandable	24 hrs	24 hrs	24 hrs	16 hrs	N/A
Fully Cured	10 days	7 days	7 days	7 days	N/A
Recoat after tack up with additional coats of ALEXSEAL HS Clear coat	90 min	60 min	60 min	45 min	48 hrs
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will affect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F).					

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