

BODY PROLINE 691 2:1 UHS SR CLEAR COAT

Technical Data Sheet No 218



High solid clear coat suitable for full body repairs or spot panel repairs

Great gloss retaining

Excellent mechanical and high chemical resistance

Excellent physical properties

General Technical Description



Mix 2 parts 691 UHS SR with 1 part H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS



Thinner addition 20% BODY 740 NORMAL / 741 ACRYLIC SLOW THINNER



Oven force drying 25 - 30 min / 60°C (140°F) panel temperature



IR drying 10-15 min distance: 60 - 70cm

Surface

Body Basecoat

Aqua Body Waterborne mix system

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: 2 passes



Apply one coat, and after the 10 - 15 min flash off time apply the second full coat*



2:1 mix with H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS
Pot life: 6h - 10h 23°C (73°F)



10-15 min / 23°C (73°F)
Final flash off time



Addition 20% of thinner. Use 740 NORMAL or 741 SLOW ACRYLIC THINNER



Non force dry 16-20h / 23°C (73°F)
Forced dry: 25-30 min / 60°C (140°F) panel temperature



Ready to spray: 16-17 s
DIN 4 / 20°C (68°F)



Short wave 10 - 15 min
distance: 60 - 70cm



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS

Flash Point:
29°C / 84°F

Specific Gravity:
0.988 g/cm³

Solid Content (No thinner):
51% 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 840 g/L. The VOC content in the ready for use form of this product is 520 g/L. 2004/42/IIB(e)(840) 520

Theoretical Coverage:

8 - 9m² / l at 50 micron (2mil) dry film thickness

Cleaning of equipment:

Clean after final use with Body 740 ACRYL NORMAL

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with H 752 SLOW / H 754 FAST / H 753 NORMAL HARDENERS
- It can also be used by countries that do not adopt the VOC legislation

Storage shelf life:

- Store in a cool place +5°C - +25°C (+40°F - +77°F) and use within 12 months for best results
- Guaranteed shelf life of 24 months in unused original containers.

Temperature	Partial repair	Full repair
<15°C <(59°F)	H 754+10-20%740	—
15-20°C (59 - 68°F)	H 754+10-20%740 H 753+10-20%740	H 754+20%741
20-25°C (68 - 77°F)	H 754+10-20%740 H 753+10-20%740	H 754+20%741 H 753+20%740
25-30°C (77 - 86°F)	H 754+10-20%740 H 754+10-20%741 H 753+10-20%740 H 753+10-20%740	H 754+20%741 H 753+20%740 H 753+20%741
>30°C >(86°F)	H 753+10-20%740 H 752+20%740	H 753+20%741 H 752+20%740 H 752+20%741

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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