

# C 898 CLEAR ULTRA HS 2:1

Technical Data Sheet No 228



Ultra high solid fast clear coat suitable for full body or spot panel repairs

Excellent mechanical and high chemical resistance

Excellent surface finish

Great gloss retaining

VOC compliant with the regulations

## General Technical Description



Mix 2 parts C 898 CLEAR ULTRA with 1 part H 738 NORMAL / H 737 SLOW HARDENER



Addition 5-10% of thinner / reducer . Use 740 ACRYL NORMAL THINNER / REDUCER



5 - 10 min / 60°C (140°F)  
25 - 30 min / 40°C (104°F)  
panel temperature



6-8 min\*\*  
distance: 80cm

## Surface

HB BODY Color Solutions Basecoat Mix System

HB BODY Color Solutions 2K Acrylic Mix System

HB BODY Color Solutions Aquabase Mix System

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

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:** 1.5 passes »» Apply a medium coat, and after 5- 10 min waiting time apply the second full coat.



2:1 mix with H 738 NORMAL / H 737 SLOW HARDENER  
Pot life: 90 - 120 min  
23°C (73°F)



4-6h 23°C (73°F)  
Flash off time before you can stop spray booth recirculation (air drying) 10-15min.



Addition 5-10% of thinner / reducer. Use 740 ACRYL NORMAL THINNER / REDUCER



5-10 min / 60°C (140°F)  
25-30 min / 40°C (104°F)  
panel temperature  
Flash off time before 5-10 min



Ready to spray:  
18-20 s  
DIN 4 / 20°C (68°F)



6-8 min\*\*  
Flash off time before 10 min



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



Always wear protective equipment



HVLP 1.2 - 1.3 mm  
2 - 2.5 bar (29-36psi)  
inlet pressure  
1.5 x coats = 50-60µm  
(2 - 2.4 mil)



Follow the application instructions mentioned in this TDS



5 - 10 min / 23°C (73°F)  
Flash off time

**Flash Point:**  
27°C / 81°F

**Specific Gravity:**  
1,0 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
57,7% 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 420 g/L. The VOC content in the ready for use form of this product is 415 g/L.  
2004/42/IIB(e)(420) 415

**Theoretical Coverage:**  
10 - 12m<sup>2</sup> / l at 50 micron (2 mil)  
dry film thickness

### Cleaning of equipment:

Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with H 738 NORMAL / H 737 SLOW HARDENER
- It can also be used by countries that do not adopt the VOC legislation
- 2K paint systems tend to react with water, hence all the equipment used must be moisture free.

### Storage shelf life:

- Store in a cool place +5°C - +25°C (+41 - +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 - 25°C	H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)	H737/H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)
25-35°C	H737/H738+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)	H737+5-10%740* 5-10min / 60 °C (140°F) 25-30min / 40 °C (104°F)

\*After force drying and 20-30min cooling phase polishing possible or after 5h air drying. Flash of time between coats and before baking 5-10min.

\*\* Depends on hardener and / or thickness of the clear coat (sug. 50-60µm (2 - 2.4 mil))

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.

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Issue 2 / 2019, October 2019