



KRONOX 610

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UHS CLEAR COAT

DEFINITION

- Low VOC emission clearcoat.
- Very fast drying times, very easy application, excellent leveling properties.
- Suitable for spot repairs and large surfaces.
- The clearcoat flows extremely well into a wet edge.
- High productivity – short drying times – optimising booth time.
- When necessary, it can be polished after 5 hours.

PHYSICAL CHARACTERISTICS



Nature:	Acrylic 2K		
Colour:	Colourless		
Specific weight:	1,0 kg/l at 20°C		
Viscosity CF/4:	18-19" at 20°C		
Dry film thickness:	50-60 microns (2 coats)		
Yield:	9 m ² /l (50 microns)		
VOC:	410 g/l	Application	2004/42/EC - IIB(d)(420) 410g/l
Solids content:	59 %	Application	

AUXILIARY PRODUCTS

KX44 Slow Hardener
KX45 Standard Hardener
KX46 Fast Hardener

SURFACE PREPARATION

Apply **KRONOX 610** on the base coat after the flash off time recommended by the manufacturer.

		
<i>T^a</i> (°C)	<i>Hardener</i>	<i>Hardener</i>
< 18	KX46	KX46
18 – 28	KX45 - KX46	KX45 - KX44
> 28	KX44-KX45 Max. 4 parts	

MIXING RATIO

KRONOX 610				
			20°C	
KX44	100:50 volume	2 : 1	18-19" F/4	1,5 h
KX45	100:52 Weight			1,5 h
KX46				1 h

APPLICATION METHOD

	mm	bar	cm		
	1,2-1,4	2-2,5	15 - 20	½ + 1 or 2	5'-10'
	1,3-1,5	4	15 - 20		
	1,2-1,3	2	10		

DRYING TIMES

20° C						50° C		Short wave IR		
									FLASH OFF	FULL BAKE
KX44	20'	1h15'	2h	2h30'	5h	KX44	15'	LIGHT	4'	6'
KX45	15'	1h	2h	2h30'	5h	KX45	10'	DARK	3'	5'
KX46	14'	45'	1h30'-1h45'	2h15'	5h	KX46	5-10'	METALLIC	4'	6'

REMARKS

If required the clearcoat can be polished, once the area has fully cooled down.
Humidity affects clear coat components so the application equipment should be absolutely dry.
Close the hardener container immediately after use.
When relative humidity is higher than 70% and/or temperatures lower than +10°C it is recommended to dry at 50°C.

EQUIPMENT CLEANING

Use a cleaning thinner before the pot life has expired.

SAFETY

Follow instructions of product label. For more information check the Safety Data Sheet. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +5°C and +30°C.

GUARANTEE

In unopened original packaging, one year from manufacturing date.

SUGGESTION:

For complete repairs and/or high temperatures, the use of KX44 improves the application and finish. Remove the masking tape before drying to assemble.

For any technical information contact with our Customer Attention Service or our Technical Department. ROBERLO SA declines any responsibility due to an incorrect use of the product.