

BODY 699 CLEAR HS SR 2:1

Technical Data Sheet No 219



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 699 HS CLEAR SR with 1 part H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS FOR TOPCOATS



Thinner addition 0-15% 740 NORMAL / 741 ACRYL SLOW THINNER



Force drying 15-20 min / 60°C (140°F) panel temperature



IR drying 8-12 min distance: 60 - 70cm

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: 2 coats. Apply one coat, and after flash off time apply the second full coat. *
For temperature range: <15-25°C (59-77°F) *



2:1 mix with H 754 FAST HARDENER FOR TOPCOATS
 Pot life: >4h 23°C (73°F)



8 - 12 min / 20-23°C (68-73°F)
 Final flash off time



Addition 0-15% of thinner. Use 740 ACRYL NORMAL THINNER



Dust free: 30 min
 Ready for assembly: 6-7hrs @ 23°C (73°F)
 Non force dry 14-18h / 23°C (73°F)
 Forced dry: 15 - 20 min / 60°C (140°F) panel temperature



Ready to spray: 15-16s
 DIN 4 / 20°C (68°F)



IR drying
 Short wave 8-12 min distance: 60 - 70cm



Compliant Spray gun
 1.3 - 1.4 mm
 2-3 bar (29-44psi) inlet pressure
 2x coats = 50-60micron (2 - 2.40mil)



Always wear protective equipment



HVLP 1.2 - 1.3 mm
 2bar(29psi) atomization pressure
 2x coats = 50-60micron (2 - 2.40mil)



Follow the application instructions mentioned in this TDS

Temperature	Orange peel texture 1-2 parts	Leveling surface 1-2 parts	Partial Repair
<15°C	H 754 15min / 60 °C (140°F)	H 754+ max 15% 740 15min / 60 °C (140°F)	H 754 + max 15% 740 / 741 15min / 60 °C (140°F)
15-25°C	H 754 15min / 60 °C (140°F)	H 754+ max 15% 740 15-20 min / 60 °C (140°F)	H 754+ max 15% 741 15-20 min / 60 °C (140°F)
25-35°C	H 754 15min / 60 °C (140°F)	H 754 + max 15% 740 / 741 15-20 min / 60 °C (140°F)	H 754+ max 15% 741 15-20 min / 60 °C (140°F)
>35°C	H 754+ max 15% 741 15-20 min / 60 °C (140°F)	H 754+ max 15% 741 15-20 min / 60 °C (140°F)	

* The specified temperatures are based on theoretical calculations only and does not mean that this combination cannot be used out of this range.

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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Mix 2 parts 699 HS CLEAR SR with 1 part H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS FOR TOPCOATS



Thinner addition 0-15% 740 ACRYL NORMAL / 741 ACRYLIC SLOW THINNER / REDUCER



Force drying 15-20 min / 60°C (140°F) panel temperature



IR drying 8-12 min distance: 60 - 70cm

Surface

HB BODY Color Solutions Basecoat Mix System

- HB BODY Color Solutions 2K Acrylic Mix System

- HB BODY Color Solutions Aqua Basecoat 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: 2 coats. Apply one coat, and after flash off time apply the second full coat. *
For temperature range: 25-35°C (79-95°F)*



2:1 mix with H 753 NORMAL HARDENER FOR TOPCOATS
Pot life: >7h 23°C (73°F)



8 - 12 min / 20-23°C (68-73°F)
Final flash off time



Addition 0-15% of thinner. Use 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



Dust free: 40 mins
Ready for assembly:
7 - 8hrs @ 23°C (73°F)
17-18h / 23°C (73°F)
20 min / 60°C (140°F)
With H 753 Hardener
30 min / 60°C (140°F)
With H 752 Hardener



Ready to spray:
15-16s
DIN 4 / 20°C (68°F)



Short wave 8-10 min
distance: 60 - 70cm



Compliant Spray gun
1.3 - 1.4 mm
2-3 bar (29-44psi) inlet pressure
2x coats = 50-60micron (2 - 2.40mil)



Always wear protective equipment



HVLP 1.2 - 1.3 mm
2bar(29psi) atomization pressure
2x coats = 50-60micron (2 - 2.40mil)



Follow the application instructions mentioned in this TDS

Flash Point:
27°C / 81°F

Specific Gravity:
0.960 g/cm³

Solid Content (No thinner):
46% 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 560 g/L.
2004/42/IIB(e)(840)560

Theoretical Coverage:
7 - 8m² / l at 50micron (2mil) 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 BODY HARDENERS
- It can only be used by countries that do not adopt the VOC legislation

Storage shelf life:

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

Temperature	Orange peel texture 1-2 parts	Leveling surface 1-2 parts	Partial Repair	Full repair
<15°C				H 753 + max 15% 740 20 min / 60°C (140°F)
15-25°C		H753 + max 15% 740 15-20 min / 60°C (140°F)	H 753 + max 15% 741 15-20 min / 60°C (140°F)	H 753 + max 15% 740 / 741 20 min / 60°C (140°F)
25-35°C		H753 + max 15% 740 / 741 15-20 min / 60°C (140°F)	H753+ max 15% 741 15-20 min / 60°C (140°F)	H753 + max 15% 741 20 min / 60°C (140°F)
>35°C	H753+ max 15% 741 15-20 min / 60°C (140°F)	H753 + max 15% 741 15-20 min / 60°C (140°F)	H753 + max 15% 741 30 min / 60°C (140°F)	H 752+ max 15% 741 30 min / 60°C (140°F)

* The specified temperatures are based on theoretical calculations only and does not mean that this combination cannot be used out of this range.

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