

## GENERAL INFORMATION

C401 HS420 High Production Clear is a polyurethane high quality clear with high durability for application over W00 - W999 Octabase Eco Plus System and B00 - B999 Octabase System. Suitable for most repair work due to its good processing properties. Specially developed for air drying and also suitable for low bake and forced drying.

## MIXING RATIO



3 : 1 Clear : HS420 Hardener + 10% Uni Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F)	H23	✓		
	H24	✓	✓	
	H25		✓	✓
	H26			✓
25°C - 30°C (104°F)	H23			
	H24	✓	✓	
	H25	✓	✓	✓
	H26		✓	✓
>30°C (140°F)	H23			
	H24	✓		
	H25		✓	
	H26		✓	✓

## GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1,2-1,4	2,0-2,5/29-36

## APPLICATION



1½ - 2 coat 50 - 80 µm (2,0-3,2 mil)

**1,5 coats: No flash off between coats.**  
**2 coats: 5-10 min flash off between coats.**

## FLASH OFF AND DRY TIMES



	HARDENER	FLASH OFF BEFORE BAKE (MIN.)	DUST FREE (MIN.)	DRY TO HANDLE (MIN.)	DRY TO POLISH (H)
Air Dry 20°C (68°F)	H23	x	25	90 - 110	5
	H24	x	35	120 - 140	12
	H25	x	45	130 - 150	16
Low bake 40°C (104°F)	H23	2 - 2	x	30	After cooling down
	H24	5 - 10	x	45	
	H25	10 - 15	x	60	
Forced Dry 60°C (140°F)	H23	2 - 2	x	25	After cooling down
	H24	5 - 10	x	35	
	H25	10 - 15	x	40	

**\*Depending on the layer thickness and temperature. Use matching thinners.**

## INFRARED DRYING



After full flash off and at proper distance	
Half-bake	4 min 50°C
Full-bake	10 min 65°C
See IR Manufacturer information	

## SUBSTRATES



W00 - W999 Octabase Eco Plus System and B00 - B999 Octabase System. Sanded and degreased old layers.

**Basecoat should be fully dry.**

## POT LIFE AT 20°C / 68°F



HARDENER	H23	H24	H25	H26
Potlife (min)	20	35	40	55

## COMPONENTS



H23 HS420 Hardener Very Fast  
H24 HS420 Hardener Fast  
H25 HS420 Hardener Medium  
H26 HS420 Hardener Slow  
TA900 Uni Thinner Fast  
TA910 Uni Thinner Medium  
TA920 Uni Thinner Slow  
TA875 Fade-Out Thinner

## ADDITIVES



AE001 Elastic 2K  
AC001 2K Structure Coat Fine  
AC002 2K Structure Coat Coarse

**Use TA875 Fade-Out Thinner for blending or fade-out areas.**

## SURFACE PREPARATION



**Mask entire vehicle to eliminate unwanted overspray.**

## NEXT LAYER



## PHYSICAL DATA

EU REGULATIONS	
VOC Code	2004/42/IIIB(d)(420)412
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIIB/d. Topcoat - All types. EU limit values: 420 g/l (2007). This product contains a maximum of 412 g/l VOC.
Chemical Base	Solventborne 2K Polyurethane
Viscosity (RTS)	16 - 18 Dincup 4 / 20°C
Specific Gravity (kg/l)	1,004
Flash Point Closed Cup	34°C / 93,2°F
Volume % Solids	48
Economy	9,6 m <sup>2</sup> /L/50 µm 390 ft <sup>2</sup> /Gal/2 mil
Gloss	High gloss
Colour	-

### PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

[https://sds.octoral.com/en/octoral/choose\\_localization](https://sds.octoral.com/en/octoral/choose_localization)

### CLEAN UP



Gun Cleaner

### STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



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