



KRONOX 510

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UHS CLEAR COAT

DEFINITION



KRONOX 510 is a high solids content and very easy to apply clearcoat. There is the possibility to achieve a graduated thickness resulting from very uniform vertically sprayed applications. Its high solids content and high viscosity give it an excellent coverage power and less risk of runs. The finish obtained results in an excellent gloss, levelling and hardness.

PHYSICAL CHARACTERISTICS

| | |
|----------------------------|---|
| Nature: | Acrylic 2K |
| Colour: | Colourless |
| Specific weight: | 1,0 kg/l at 20°C |
| Viscosity CF/4: | 19" at 20°C |
| Dry film thickness: | 50-60 microns (2 coats) |
| Yield: | 9 m ² /l |
| Solids content: | 63 % Kronox 510 |
| | 62 % Application (100:50 vol) |
| | 59 % Application (100:50:5 vol) |
| VOC: | 380 g/l Application (100:50 vol) 2004/42/EC - IIB (d)(420)(380) |
| | 407 g/l Application (100:50:5 vol) 2004/42/EC - IIB (d)(420)(407) |

AUXILIARY PRODUCTS

| | |
|--------------------------|-----------------------|
| KX43 Extra Slow Hardener | |
| KX44 Slow Hardener | S322 Standard thinner |
| KX45 Standard Hardener | S324 Slow thinner |
| KX46 Fast Hardener | |

| |  |  | |
|---------------------------|---|---|-------------------------|
| <i>T^a</i> (°C) | <i>Hardener</i> | <i>Hardener</i> | <i>Thinner Optional</i> |
| < 18 | KX46 | KX45-KX46 | S322 |
| 18 - 25 | KX45- KX46 | KX44-KX45 | S322 |
| 25-30 | KX45-KX44 | KX44-KX43 | S324 |
| >30 | KX43 | KX43 | S324 |

SURFACE PREPARATION

Apply **KRONOX 510** on the base coat after the flash off time recommended by the manufacturer.

MIXING RATIO

| Kronox 510 | | | | |
|-----------------------|--|-------|------------|---------|
| | | | 20°C | |
| KX44/ KX43 | 100:50:0-5 volume 100:52:0-4 weight | 2 : 1 | 19" F/4 | 1,5-2 h |
| KX45 | | | | |
| KX46 | | | | 1-1,5 h |

APPLICATION METHOD

| | mm | bar | cm | | |
|--|---------|-------|---------|---|--------|
| | 1,2-1,4 | 2-2,5 | 15 - 20 | 2 | 5'-10' |
| | 1,3-1,4 | 4 | 15 - 20 | | |
| | 1,2-1,4 | 2 | 10 | | |

DRYING TIMES

| 20° C | | | | | | 60° C * | | Short wave IR | | |
|-------------|-----|----|----|----|-----|-------------|-----|---------------|-----------|-----------|
| | | | | | | | | | FLASH OFF | FULL BAKE |
| KX43 | 55' | 4h | 6h | 8h | 24h | KX43 | 20' | LIGHT | 5' | 10' |
| KX44 | 45' | 4h | 6h | 8h | 24h | KX44 | 20' | DARK | 4' | 8' |
| KX45 | 40' | 3h | 5h | 6h | 24h | KX45 | 20' | METALLIC | 5' | 10' |
| KX46 | 35' | 3h | 4h | 5h | 24h | KX46 | 15' | | | |

(*) Wait 10-15 minutes before applying temperature

REMARKS

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 60°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.

These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.

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