

# **BODY PROLINE 699 2:1 HS SR CLEAR COAT**

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

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

Mix 2 parts 699 HS CLEAR

SLOW / H 753 NORMAL /

H 754 FAST HARDENER

SR with 1 part H 752



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

Тетрега

<15°C

15-25°C

25-35°C

>35°C

Body Basecoat

Body 2K Autoemail acrylic paint

Orange peel texture

1-2 parts

H 754 15min / 60 °C (140°F)

H 754

15min / 60 °C (140°F)

H 754

15min / 60 °C (140°F)

H 754+ max 15% 741

15 -20 min / 60 °C (140°F)

### Pretreatment / Cleaning of substrate



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

Make sure the surface is first wiped dry and then air dried.



Leveling surface

1-2 parts

H 754+ max 15% 740

15min / 60 °C (140°F)

H 754+ max 15% 740

15 - 20 min / 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)

Make sure you always use appropriate face protection and good ventilation

Partial

Repair

H 754 + max 15% 740 / 741

15min / 60 °C (140°F)

H 754+ max 15% 741

15 - 20 min / 60 °C (140°F)

H 754+ max 15% 741

15 - 20 min / 60 °C (140°F)

Product Application: 2 passes »» Apply one coat, and after the 8-12 min 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 Pot life: >4h 23°C (73°F)

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

Dust free: 30 min

Non force dry

Ready for assembly:

6-7hrs @ 23°C (73°F)

14-18h / 23°C (73°F)

/ 60°C (140°F) panel temperature

Short wave 8-12 min

distance: 60 - 70cm

Always wear

Forced dry: 15 - 20 min



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



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



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



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



Follow the application instructions mentioned in this TDS

protective equipment

\* The specified temperatures are based on theoritical 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.

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 8 / 2017, December 2017



# **BODY PROLINE 699 2:1 HS SR CLEAR COAT**

Technical Data Sheet No 219

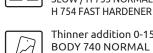
High solid clear coat suitable for full body repairs or spot panel repairs

Great gloss retaining

Excellent mechanical and high chemical resistance

Excellent physical properties

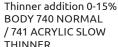
Mix 2 parts 699 HS CLEAR SR with 1 part H 752 SLOW / H 753 NORMAL /



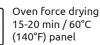
Description



**General Technical** 



**BODY 740 NORMAL** / 741 ACRYLIC SLOW THINNER



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

(68-73°F)

Final flash off time

Dust free: 40 mins

Non force dry

Forced dry:

Ready for assembly:

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

Short wave 8 - 10 min

distance: 60 - 70cm

Always wear

7 - 8hrs @ 23°C (73°F)

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

Product Application: 2 passes »» Apply one coat, and after the 8 - 12 min flash off time apply the second full coat. \* For temperature range: 25-35°C (79-95°F)\* 8 - 12 min / 20-23°C Flash Point:



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

Addition 0-15% of thinner. Use BODY 740 NORMAL / 741 SLOW ACRYLIC THINNER



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



Compliant Spray gun 1.3 – 1.4 mm 2-3 bar (29-44psi) inlet

pressure 2x coats = 50-60micron (2 - 2.40mil)



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



Follow the application instructions mentioned in this TDS

protective equipment

	1-2 parts	1-2 parts	nepun	
<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)

Leveling

surface

Make sure you always use appropriate face protection and good ventilation

Cleaning of equipment: Clean after final use with BODY 740 NORMAL ACRYLIC THINNER

### 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:

Partial

Renair

• 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

Full repair

\* The specified temperatures are based on theoritical 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.

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 8 / 2017, December 2017



Pretreatment / Cleaning

air dried.

Clean substrate using

a soft cloth and BODY

770 ANTISIL NORMAL /

**BODY 771 ANTISIL FAST** 

Make sure the surface is

first wiped dry and then

of substrate

Surface

Body Basecoat

27°C/81°F

0.960 g/cm<sup>3</sup>

46% Weight

Specific Gravity:

VOC (2004/42/EC)

product is 560 g/L.

film thickness

Temper

ature

2004/42/IIB(e)(840)560

Theoretical Coverage:

Solid Content (No thinner):

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

7 - 8m<sup>2</sup> / l at 50micron (2mil) dry

Orange peel

texture

Body 2K Autoemail acrylic paint