



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



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



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



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



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

Surface

Body Basecoat

Body 2K Autoemail acrylic paint

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.



Make sure you always use appropriate face protection and good ventilation

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



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



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 HARDENER



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



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



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

Surface

Body Basecoat

Body 2K Autoemail acrylic paint

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.



Make sure you always use appropriate face protection and good ventilation

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)*



2:1 mix with H 753 NORMAL HARDENER
 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 BODY 740 NORMAL / 741 SLOW ACRYLIC THINNER



Dust free: 40 mins
 Ready for assembly: 7 - 8hrs @ 23°C (73°F)
 Non force dry 17-18h / 23°C (73°F)
 Forced dry: 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 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:

- 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)

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