



# Fontedur Clear Plus

## DESCRIPTION

A water-borne, two-component polyurethane lacquer with outstanding gloss and color protection properties.

## PRODUCT FEATURES AND RECOMMENDED USES

- Excellent UV-resistance
- User and environmentally friendly
- Very good spraying properties
- Slightly milky surface as wet eases to control the quality of the surface
- Resistant against moderate mechanical and chemical stress
- Recommended to be used on solvent-borne and water-borne polyurethane topcoats on coating systems where high gloss and great color stability of underlying topcoat is required

## TECHNICAL DATA

**Volume solids** 36±2%. (ISO 3233)

**Weight solids** 39±2%.

**Specific gravity** 1.1±0.1 kg/l (mixed)

**Mixing ratio** Base 2 parts by volume Fontedur Clear Plus  
Hardener 1 parts by volume 007 1610

**Pot life (+23°C)** 1 h

## Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
100µm	35µm	10.0 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

## Drying time

DFT 35 µm	+15°C	+23°C	+35°C
Dust dry, after	4h	2h	1h
Touch dry, after	12h	6h	3h
Fully cured, after	14d	7d	3d

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation

**Gloss** Full gloss.

**Color shades** Clear

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## APPLICATION INSTRUCTIONS

<b>Surface preparation</b>	Primed surfaces: Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)
<b>Recommended primers</b>	Fontebase, Fontedur HB 80, Fontedur SC 35, Temadur 10, Temadur 20, Temadur 50, Temadur 90, Temadur HS 90.
<b>Recommended topcoats</b>	Fontedur Clear Plus.
<b>Application conditions</b>	All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and lacquer should not fall below +15°C during application and drying. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use power mixer for mixing. Insufficient mixing or incorrect mixing ratio will result in uneven drying of the surface and weaken the properties of the coating.
<b>Application</b>	<p>For conventional spraying, product is thinned approximately 0–5% to the viscosity 23–33 s/DIN4 (+23°C). Recommended nozzle tip is 1.4–1.6 mm and pressure 3–4 bar.</p> <p>For air-assisted airless spraying, product is thinned approximately 0–5% to the viscosity 23–33 s/DIN4 (+23°C). Recommended nozzle tip is 0.009"–0.011" and pressure 120–160 bar. Atomising air pressure should be about 2–3 bar. Spray angle shall be chosen according to the shape of the object.</p>
<b>Thinners</b>	Water
<b>Cleaning of equipment</b>	<p>Clean the spraying equipment immediately after use as follows:</p> <ol style="list-style-type: none"><li>1. Run the equipment with water to remove excess lacquer from the equipment.</li><li>2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times.</li><li>3. Finally wash with undiluted Thinner 1109.</li></ol> <p>Wash the equipment with water before starting to lacquer again. Unwashed equipment can cause serious surface defects.</p> <p>Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.</p>
<b>VOC</b>	<p>The Volatile Organic Compounds amount is 224 g/litre of lacquer.</p> <p>VOC content of lacquer (thinned 5% with water) is 214 g/l.</p>
<b>HEALTH AND SAFETY</b>	<p>Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets.</p> <p>A health and safety data sheet is available on request from Tikkurila Oyj.</p>

**For industrial use only.**



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The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.