

Technical Data Sheet

KRISTAL

eXcellent

TimeClear 94

Art.nbr. 9410

Clear Coats

Version: **EN-TDS-9410-1.2**

Revision: February 10


FOR PROFESSIONAL USE ONLY

SHORTENED APPLICATION SHEET

FIELD OF APPLICATION

For application as a clear coat over Metallic Basecoat Series.
Suitable for passenger cars.

	4 TimeClear 94 1 TimeHardener 1 TimeAdd
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	Spray nozzle: 1.2 - 1.3 mm	Pressure: 3.5 – 4.5 bar 2.1 – 2.4 bar at the air inlet
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	2 spraycoats Layer thickness 50-60 µm
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	See overview on page 4.
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	Application viscosity 15 – 17 seconds (DIN CUP 4 mm / 20°C)
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	Potlife 3 hours at 20°C
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	Use suitable respiratory protection.
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For full technical information, read the complete Technical Data Sheet.

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EXTENSIVE TECHNICAL INFORMATION

FIELD OF APPLICATION

For application as a clear coat over Metallic Basecoat Series.
Suitable for passenger cars.

KRISTAL TimeClear 94, is an easy-to-use chemical resistant, non-yellowing, finishing clear finish. Air-drying and force-drying.

PRODUCT AND AUXILIARY PRODUCTS

	TimeClear 94	
Hardener	TimeHardener	
Product to add	TimeAdd	
Article numbers	TimeClear 94	9410
	TimeHardener	8410
	TimeAdd STD	3410
	TimeAdd Fast	3411
	TimeAdd Slow	3412
	TimeAdd Extra Fast	3414

CHEMICAL BASIS

KRISTAL TimeClear 94	Hydroxy-acrylic resins
KRISTAL TimeHardener	Isocyanate resin

SUBSTRATES

Metallic basecoat / waterbase basecoat.
Sanded and degreased old layers

MIXING



4 TimeClear 94
1 TimeHardener
1 TimeAdd

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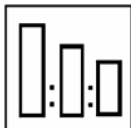
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MIXING



- 4 TimeClear (A)
- 1 TimeHardener (B)
- 1 TimeAdd (C)
- STD (3410)
- Fast (3411)
- Slow (3412)

100 ML	
A	64,52 gr
B	16,45 gr
C	14,52 gr

200 ML	
A	129,04 gr
B	32,90 gr
C	29,04 gr

300 ML	
A	193,56 gr
B	49,35 gr
C	43,56 gr

400 ML	
A	258,08 gr
B	65,80 gr
C	58,08 gr

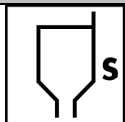
500 ML	
A	322,60 gr
B	82,25 gr
C	72,60 gr

600 ML	
A	387,12 gr
B	98,70 gr
C	87,12 gr

700 ML	
A	451,64 gr
B	115,15 gr
C	101,64 gr

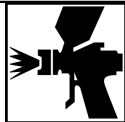
800 ML	
A	516,16 gr
B	131,60 gr
C	116,16 gr

APPLICATION VISCOSITY



Application viscosity
15 – 17 seconds (DIN CUP 4 mm / 20°C)

EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.3 mm

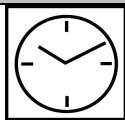
Pressure:
3.5 – 4.5 bar
2.1 – 2.4 bar at the air inlet

SPRAY COATS / LAYER THICKNESS

2 spray coats.

Layer thickness 50 – 60 µm

POTLIFE



Potlife
3 hours at 20°C

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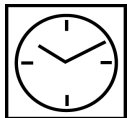
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DRYING

All drying times relate to standard application and **object temperature**.



TimeClear 94	TimeClear 94	TimeClear 94
TimeHardener	TimeHardener	TimeHardener
TimeAdd STD	TimeAdd Fast	TimeAdd Slow

20°C	Dust dry	12 – 14 minutes	9 – 11 minutes	14 – 16 minutes
	Dry to handle	30 – 40 minutes	20 – 30 minutes	45 – 60 minutes
	Dry for assembly	70 – 80 minutes	50 – 60 minutes	90 – 100 minutes
	Dry to polish	80 – 90 minutes	60 – 70 minutes	100 – 110 minutes
	Fully cured	Approx. 13 hours	Approx. 11 hours	Approx. 15 hours

40°C	Dust dry	8 – 9 minutes	6 – 7 minutes	10 – 12 minutes
	Dry to handle	15 – 20 minutes	15 – 20 minutes	20 – 25 minutes
	Dry for assembly	25 – 30 minutes	25 – 30 minutes	30 – 35 minutes
	Dry to polish	40 – 50 minutes	35 – 40 minutes	50 – 60 minutes
	Fully cured	Approx. 9 hours	Approx. 7 hours	Approx. 10 hours

ECONOMY

10 m² per liter ready-to-use clear coat

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 0,98 kg/L
 Flashpoint : 21 °C
 Vol.% solids : 46%

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VOLATILE ORGANIC COMPOUND

VOC CODE: **2004/42/IIB(e)(840)(540)**

Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready-to-use product.

IIB(d\e). Special finishes – All types. EU limit values: 840 g/l. (2007)

This product contains a maximum of 540 g/l. VOC

STORAGE LIFE

Under normal storage conditions for up to two years in unopened tins.



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Important notice

Our products are suitable for professional use only.

Registered processing times are valid under conditioned application circumstances only. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, not the suitability of the products for a specific purpose. Any date, weight, proportions, etc. given herein are for general information purpose only; they may change without prior information and do not constitute the quality of the products (product specification).

For technical support and advice with concern to choices of coatings systems and methods of application, our technical staff will be at your service at all times.