



# KRONOX 620

E33

VERSION: 190619  
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## UHS CLEAR COAT

### DEFINITION

Low VOC emission 2K clearcoat that is easy to apply with a high level of finish. In addition, its ultra-fast drying allows an optimization of the facilities. Despite its drying speed, it is a suitable clearcoat for partial repairs as well as for complete vehicles, allowing excellent versatility in this case. When necessary, it can be polished after 5 hours.

### PHYSICAL CHARACTERISTICS

<b>Nature:</b>	Acrylic 2K		
<b>Colour:</b>	Colourless		
<b>Specific weight:</b>	1,0 kg/l at 20°C		
<b>Viscosity CF/4:</b>	18-19" at 20°C		
<b>Dry film thickness:</b>	50-60 microns (2 coats)		
<b>Yield:</b>	9 m <sup>2</sup> /l (50 microns)		
<b>VOC:</b>	410 g/l	Application	2004/42/EC - IIB(d)(420) 410g/l
<b>Solids content:</b>	59 %	Application	

### AUXILIARY PRODUCTS

KX44	Slow Hardener
KX45	Standard Hardener
KX46	Fast Hardener

### SURFACE PREPARATION

Apply **KRONOX 620** on the base coat after the flash off time recommended by the manufacturer.

		
<i>T<sup>a</sup></i> (°C)	<i>Hardener</i>	<i>Hardener</i>
< 18	KX46	KX46
18 – 28	KX45 - KX46	KX45 - KX44
> 28	KX44-KX45 Max. 4 parts	

## MIXING RATIO

KRONOX 620				
			20°C	
KX44	100:50 volume	2 : 1	18-19" F/4	1,5 h
KX45	100:52 Weight			1,5 h
KX46				1 h

## APPLICATION METHOD

	mm	bar	cm		
	1,2-1,4	2-2,5	15 - 20		½ + 1 or 2
	1,3-1,5	4	15 - 20		
	1,2-1,3	2	10		

## DRYING TIMES

	20° C					50° C		Short wave IR		
									FLASH OFF	FULL BAKE
KX44	20'	1h15'	2h	2h30'	5h	KX44	15'	LIGHT	4'	6'
KX45	15'	1h	2h	2h30'	5h	KX45	10'	DARK	3'	5'
KX46	14'	45'	1h30'-1h45'	2h15'	5h	KX46	5-10'	METALLIC	4'	6'

## REMARKS

If required the clearcoat can be polished, once the area has fully cooled down.  
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 50°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.

### SUGGESTION:

For complete repairs and/or high temperatures, the use of KX44 improves the application and finish. Remove the masking tape before drying to assemble.

For any technical information contact with our Customer Attention Service or our Technical Department. ROBERLO SA declines any responsibility due to an incorrect use of the product.