



KRONOX 510

E64

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UHS CLEAR COAT

DEFINITION

KRONOX 510 is a high solids content and very easy to apply clearcoat. There is the possibility to achieve a graduated thickness resulting from very uniform vertically sprayed applications. Its high solids content and high viscosity give it an excellent coverage power and less risk of runs. The finish obtained results in an excellent gloss, levelling and hardness.



PHYSICAL CHARACTERISTICS

Nature:	Acrylic 2K
Colour:	Colourless
Specific weight:	1,0 kg/l at 20°C
Viscosity CF/4:	19" at 20°C
Dry film thickness:	50-60 microns (2 coats)
Yield:	9 m ² /l
Solids content:	63 % Kronox 510
	62 % Application (100:50 vol)
	59 % Application (100:50:5 vol)
VOC:	380 g/l Application (100:50 vol) 2004/42/EC - IIB (d)(420)(380)
	407 g/l Application (100:50:5 vol) 2004/42/EC - IIB (d)(420)(407)

AUXILIARY PRODUCTS

KX44 Slow Hardener
 KX45 Standard Hardener
 KX46 Fast Hardener

S322 Standard thinner
 S324 Slow thinner

			
T° (°C)	Hardener	Hardener	Thinner Optional
< 18	KX46	KX45-KX46	S322
18 - 25	KX45- KX46	KX44-KX45	S322
> 25	KX44-KX45	KX44	S324

SURFACE PREPARATION

Apply **KRONOX 510** on the basecoat after the flash off time recommended by the manufacturer. On a solvent-based basecoat system, apply the clear coat after the coat is completely cured.

MIXING RATIO

Kronox 510			20°C	
			19"	F/4
KX44	100:50:0-5 volume 100:52:0-4 weight	2 : 1	19"	1,5-2 h
KX45				1,5-2 h
KX46				1-1,5 h

APPLICATION METHOD

	mm	bar	cm			
	1,2-1,4	2-2,5	15 - 20			
	1,3-1,4	4	15 - 20		2	5'-10'
	1,2-1,4	2	10			

DRYING TIMES

20° C						60° C *		Short wave IR		
									FLASH OFF	FULL BAKE
KX44	45'	4h	6h	8h	24h	KX44	20'	LIGHT	5'	10'
KX45	40'	3h	5h	6h	24h	KX45	20'	DARK	4'	8'
KX46	35'	3h	4h	5h	24h	KX46	15'	METALLIC	5'	10'

(*) Wait 10-15 minutes before applying temperature

REMARKS

Humidity affects clear coat components so the application equipment should be absolutely dry.
Close the hardener container immediately after use.
Do not use when relative humidity is higher than 70%.
Do not use at temperatures lower than +10°C. In this case dry in spraybooth.

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.

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.