



INTERPLAN 1650 HIGH GLOSS CLEARCOAT

DESCRIPTION Waterborne 2-pack glossy polyurethane-acrylic varnish. Can be applied on basecoat or directly on the substrate (wood, composite, plastic, etc.).

Gloss > 95 GU (gloss unit).

SPECIFICATIONS -Passes the FAR25.853.

PRETREATMENT

1. Clean dry with Scotch Brite Red Type A very fine.
2. Remove dust by using air pressure or clean cloth.
3. Degrease with isopropyl alcohol or other approved solvent.

MIXING RATIO

	<u>By weight</u>	<u>by volume</u>
Base	100g	10 part
Hardener IP1042	50g	4.5 part
Water	40-50g	4-5part

APPLICATION Pneumatic equipment with nozzle orifice 1,2 – 1,4mm
SPRAY VISCOSITY 15-20 seconds DIN Cup 4

OPTIMAL WORKING Temperature 15-30°C
CONDITIONS Relative humidity 50-70%

CLEANING Clean equipment, immediately after use, with water
EQUIPMENT

PRECAUTIONS Use masks and respiratory devices.
See SDS for further detailed information.

DRYING TIMES Dust free: 60 minutes
(T=25°C/R.H.55%) Tack free: 120 minutes
(ASTM D5895) Dry hard: 8 hours
Full cure: 7 days

Flash off time between coats or before oven cure: minimum 60 minutes (at 40µm dry). Curing @ 60°C: minimum 1 hour.

DENSITY

Base	1,005 kg/L ± 0,010 kg/L
Hardener	1,100 kg/L ± 0,010 kg/L
Mixed	1,025 kg/L ± 0,015 kg/L

VOC (ASTM D3960)

240 g/L (less water).

SOLIDS CONTENT (ASTM D5201)

Base	40% ± 2 by weight	39.8% ± 2 by volume
Hardener	76% ± 2 by weight	70,5% ±2 by volume
Mixed	49% ± 3 by weight	48 % ± 3by volume

THEORETICAL SPREADING RATE

Base + hardener: 11,9m²/L @ 40 microns

THICKNESS

1 Cross coat: 30-40 µm (Dry)
Maximum 2 layers per day. Flash off between 2 layers minimum 1 hr.
Overcoating window without sanding 24hr.

POTLIFE (20°C)

3 hours. Do not apply after pot life is expired. Do not add leftovers to fresh paint.

PACKAGING

1 Mini-kit = 1.0 kg 0.5 kg	INTERPLAN 1650 HG Clearcoat + INTERPLAN 1042.
1 Kit = 3.2 kg 2 x 0.8 kg	INTERPLAN 1650 HG Clearcoat + INTERPLAN 1042.

STORAGE STABILITY

In closed containers and at T = 5-25°C: 12 months

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