



## KLARLACK 410 GLOSS Acrylic Clearcoat

**Description:** KLARLACK 410 GLOSS is an acrylic clearcoat with scratch resistant (SR) properties. KLARLACK 410 ensures very high-gloss coating with high final hardness. It has a good flowability and an optimum drying time. The product is compatible with most of commercially available solventborne and waterborne basecoats. It is UV and weather resistant.

**Mixing ratio:**

	Volume ratio	Weight ratio
KLARLACK 410 GLOSS Acrylic Clearcoat	2	100
KLARLACK HÄRTER Hardener for acrylic clearcoat	1	50
THINNER Acrylic, epoxy and basecoat thinner	20%	18

**Complementary articles:** KLARLACK HÄRTER Hardener for acrylic clearcoat  
THINNER Acrylic, epoxy and basecoat thinner

**Potlife:** Ca. 90 min. at 20°C

**Application parameters:**

Spray viscosity:	DIN 4/20°C - 16÷18 s
Spray gun nozzle:	Ø1.3÷1.4 mm
Operating pressure:	2÷4 bar

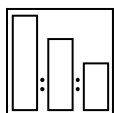
**Volatile organic compounds content:**

VOC II/B/e limit\* = 840g/l  
VOC = 570g/l

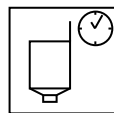
\* for ready to use mixture acc. to EU Directive 2004/42/CE

**Procedure:**

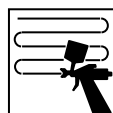
The clearcoat is applied on sprayed and dust-free basecoat layers. Spray two or three single layers with the flash-off time of 5÷7 min for each one (depending on the temperature and thickness of layer). The coating is ready for heating in 5 minutes from application of the last layer.



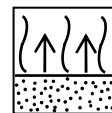
2 + 1 + 20%



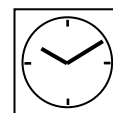
DIN 4/20°C  
16÷18 s



2÷3x  
2÷4 bar  
Ø 1.3÷1.4 mm



5÷7 min



Operating hardness  
14 h/20°C  
40 min/60°C

<b>Coating thickness:</b>	20÷25 µm per each layer
<b>Use:</b>	Use for small and large repairs. It is not recommended for full body painting above 28°C.
<b>Drying time:</b>	Dust-free: 25 min at 20°C or 5 min at 60°C Operating hardness: 14 h at 20°C or 40 min at 60°C. Final hardness: 7 days at 20°C.
<b>Theoretical yield:</b>	The complete mixture (1 l of the clearcoat + the correct ratio of the hardener and thinner) gives ca. 12 m <sup>2</sup> of ca. 50 µm thick dry layer.
<b>Colour:</b>	Transparent.
<b>Equipment cleaning:</b>	NC solvent, THINNER Acrylic, epoxy and basecoat thinner.
<b>Storage conditions and shelf life:</b>	Store in cool, well-ventilated rooms, away from sources of fire and heat. Avoid direct exposure to sunlight. KLARLACK 410 GLOSS Acrylic clearcoat: 24 months at 20°C. KLARLACK HÄRTER Hardener for acrylic clearcoat: 18 months at 20°C. THINNER Acrylic, epoxy and basecoat thinner: 24 months at 20°C.
<b>Safety regulations:</b>	See the Safety Data Sheet of the product in question.
<b>Notice:</b>	Use KLARLACK 410 GLOSS only with the dedicated hardener. Using other hardeners may reduce the UV resistance, and the chemical and mechanical resistance of the clearcoat.
<b>Other informations:</b>	Registration number: 000024104. The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.