Technical Data Sheet
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OP919G5
Detailed Description **2K CLEAR SB TCOAT G05**
2K CLEAR SB POLYURETHANE TOPCOAT G05
Technical Description
Clear PUR matt top coat, 5GL

Main Data

Primary Sector 	✓ Cupboard doors ✓ Indoor furnitures ✓ Indoor fittings ✓ Flat panels for indoors ✓ Tables for indoors
Main Features	Outstanding Scratch resistance Outstanding Matt uniformity Outstanding Surface hardness

Chemical and Physical Properties

Physical state notes	Opalescent off-white liquid
Solid Content %	42 ± 2
Gloss	5 gloss ± 2.0

Yield

Min	Max	UM
7.1	8.3	m2/Kg
273.8	320.0	sqft/gal

Instructions for use

Instructions for use	Mix well before use 
Pigmentability	The product can be pigmented: refer to the “Pigmented coatings” manual or ask technical assistance service.

Substrate

Substrate	✓ Bicomponent solvent based base coats ✓ Polyester base coats ✓ Polyurethane base coats
Substrate preparation	✓ Sand the base coat with grain 320 and then with grain 400 paper. Dust carefully with compressed air. 
Substrate information	All general information refers to ICA Group products

Application

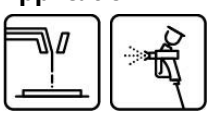
Hardener

Hardener	% in weight	% in volume	Pot life (h)	How to add
C376A	80.0	80.0	2	Mix manually

Thinner

Thinner	% in weight	% in volume	How to add
D1010	30.0	30.0	Mix manually
D1007	30.0	30.0	Mix manually

Product preparation
Dilute from 5% to 30% by weight, or by volume, depending on application requirement

Application 

Application	Application Notes
Curtain coater	Maintaining the working viscosity periodically replenishing the lost solvent by evaporation
Spray-paint	With cup airbrush, nozzles from 1.8 - 2 mm and air pressure at 3 atm

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Quantity per coat	Min Quantity	Max quantity	Un. Measure
	120	140.0	g/sqm
	5.0	5.8	wet mils
Number of coats	Up to two		
Interval between coats (23°C-73°F 50% RH) (h)	1-2		

Drying

Touch dry (23°C-73°F 50% RH) (h)	0.5 
Drying and cross-linking information	The figures indicated serve as a guide and are for reference. The drying time depends on the substrate, coat thickness, temperature, relative atmospheric humidity and ventilation.

Specification of supplied product

Analysis		Value		Un. Measure	Method
Flow Cup Viscosity	Ford Cup 4	65.0	± 20.0	Seconds	F.C.4 visc. 20°C (sec) MP04
Specific Gravity		0.97	± 0.05	g/ml	Density (g/ml) MP01
		8.1	± 0.05	lb/gal	Density (lb/gal) MP01
Fineness		15.0	± 5.0	µm	Fineness (µm) MP12

N.B.

Shelf life (days)	730
Storage and use Information	Store in a cool, dry place protected from light sources. Close the package after using. Store at temperatures above 5°C (41°F) and below 35°C (95°F) 
N.B.	Store in a cool, dry place, away from direct sunlight

Viscosity Notes

The quality control value of the viscosity refers to the product immediately after checking. Any variations of the data specified in the technical data sheet could be due to circumstances such as length and conditions of storage.

Legal notice

The working method, the application conditions, the production cycle, the use of machinery, the ambient conditions, the characteristics of the supports used, the place of use, are beyond our control and our obligations. Therefore it is essential that you test our products and the information supplied by us to make sure that they are satisfactory and suitable for the use and application methods that you intend them for and for the results you wish to achieve. This specific analysis is exclusively your responsibility and must include assessment of suitability from a technical and procedural, environmental, health and safety point of view. Any written or verbal information given by our technical and/or commercial personnel is purely to illustrate the product and help the client, and does not constitute instructions or consultancy, which remains expressly excluded. The above mentioned written or verbal information is subject to changes without prior notice and does not imply any acceptance of responsibility by our company to you and to third parties. The product is supplied in perfect conformity with the contents of this document; we therefore guarantee the consistency of the chemical-physical characteristics of the product taking into account the allowances and data contained in our technical data sheets.
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