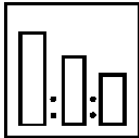
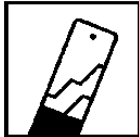


PROCLEAR 421



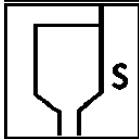
4:1:1
Proclear 421
Hardener 421
PU Thinner



2

Product and Additives:

Proclear 421
Hardener 421
PU Thinner



14-15

Basic Raw Materials:

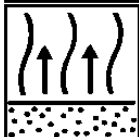
Proclear 421: acrylic resins.
Hardeners: polyisocyanate resins.



(syphon feed)
2*1
1.4-1.6 mm
4-5 bar

Suitable Substrates:

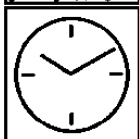
- Catinabase
- Catinacryl



8-12 mins.

Mixing Ratio by Volume:

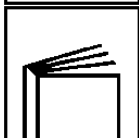
4 parts Proclear 421
1 parts of Hardeners 421
1 parts of PU Thinner



16 hrs. 20°C.
45 mins. 60°C.

Spraying Viscosity:

14-15s DIN Cup 4 at 20°C.



7.3.2.05

Potlife:

When mixed with Hard 421: 2½ hrs at 20° C



Spray gun fluid tip and working pressure:

Spray gun:	Fluid tip:	Working pressure:
Gravity feed:	1.2-1.5 mm	4-5 bar
Syphon feed:	1.4-1.6 mm	4-5 bar
Pressure feed:	1.1-1.2 mm	5-6 bar

Application Process:

Spray 2 single wet coats, allowing for a flash-off time of 7-10 minutes between coats.

Note: The specified flash-off times depend on temperature and air velocity. After allowing for a flash-off time of 8-10 minutes of the final coat of Proclear 421, it can be force dried at 60°C.

Lettering: Within 48 hours, Catinacryl can be applied directly over Proclear 421. After this 48 hour-period, previous scuffing with Scotch Brite Type S Ultra Fine or application of an intermediate coat of Catinacryl Sealer is required.

Film Thickness:

15-20 µm per coat

Cover rate:

Theoretical: 7 m²/l unthinned paint at 40µm.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

In PU Thinner, Catina Solvent or a nitrocellulose thinner.

Drying times:

	At 20°C:	
Hardener 421	20°C:	60°C:
Dust dry:	45 mins	5 mins
Tack-free:	4 hrs	20 mins
Dry to handle:	10 hrs	30 mins
Hard dry:	13 hrs	45 mins

Dust ingress and minor damage in the Procure 421 finish can be polished out after allowing for the following drying times:

Ready to polish:	At 20°C:	At 60°C:
	2 days	1.5 hrs

First flat out dust particles carefully with SF sandpaper, then polish the area manually or mechanically.

Packaging:

1 lt & 20 lt

HEALTH & SAFETY DATA concerning Procure 421:

For professional use only. (See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.
