

Product description / Produkt line: : Wöropur-Clearcoat : R3209

Product code	109494
Product description	2K solvent borne clearcoat
Colour	transparent, high gloss

Physical properties: 1) Delivery condition / 2) Preparation / 3) Ready-made

1) Delivery condition	Unit	Value	Tolerance (+/-)	Method
Solid content (grav.)	%	56	2	WW PVO 3-16 M5
Solid content (vol.)		48	2	Calculated
Density of paint (grav.)	g/cm ³	1,02	0,02	WW PVO 3-09 M2
Density of solid content (grav.)	g/cm ³	1,16	0,15	ISO 3233/AC 1999
Viscosity (ISO 5mm / 23°C)	sec	83	5	DIN EN ISO 2431
Brilliance (60°)	UB	95	5	WW PVO 2-02 M2
Conductivity (Ransburg)	kOhm	400	100	WW PVO 1-11
Flash point	°C	> 23		DIN 51755
Shelf life	monts	6		Tested
Storage temperature	°C	15	10	Tested

2) Paint preparation	Unit	Paint	Thinner	Hardener	Tolerance (+/-)	
Product code	-	109494	101343	60738	Hard.	Thinner
Density (grav.)	g/cm ³	1,02	0,90	1,06	0,02	0,02
Mixing ratio (grav.)	%	100	35	36	2	2
Mixing ratio (vol.)	%	100	39	33	2	2

Remarks: Mixing ratio for thinner relates only to clearcoat
Mixing ratio hardener relates to clearcoat already thinned

3) Ready-made paint	Unit	Value with Thinner	Tolerance	Method
Hardener		101343	(+/-)	
Viscosity with Thinner (ISO 4mm / 23°C)	sec	33	1	NF EN ISO 2431
Paint viscosity (with Thinner and Hardener) (ISO 4mm / 23°C)	sec	33	3	NF EN ISO 2431
Conductivity (Ransburg)	kOhm	270	30	WW PVO 1-11
Pot life (bei 20°C)	min	60		Tested
Solid content (grav.)	%	48	3	DIN53213/51755
Solid content (vol.)	%	36	3	Calculated
Density	g/cm ³	1,00	0,02	WW PVO 3-09 M2
Pinholes limit > 45µm		i.O/n.i.O		WW PVO 05-06
Sagging limit > 45µm	µm	>45		WW PVO 05-06
Theoretical consumption	g/m ²	72*		Calculated

*Remarks: 30µm film build

Physical properties: 4) Application conditions

4) Application conditions	Unit	Value	Tolerance(+/-)	Methode
Functional dry film build	µm	30	5	Tested
Application method		Pneumatic and electrostatic		
Application booth condition		Relative humidity 55-65 %, Booth temperatur > 15°C		
Flash off time	min	7-10 min room temperature		
Curing time	min	30		
Curing temperature	°C	80 (Part temp.)		

Remarks : - Parts must be clean before application

- Product must be well stirred up during 5-10 minutes before application