

# Technical Data Sheet

PROPELLING EXCELLENCE  
**PROXL**<sup>®</sup>

generation<sup>™</sup>  
**20**

## **XPRESS 605** *VHS CLEAR COAT*

This VHS clear coat incorporates a new rapid drying technology, resulting in superior flow out and gloss retention.



5 Minute Cure  
@ 60C



No  
Gloss Drop



Long  
Open Time

**SAVE ENERGY**  
**SAVE COSTS**

## Technical Data

### Technical info

Mixing ratio	Mix 2 parts VHS Clear Coat ( <b>X605G20-C</b> ) to 1 part VHS Hardener ( <b>X605G20-H</b> ) by volume
Thinning ratio	Not required
Resin	Acrylic
Specific Gravity	0.98 – 1.0 kg/lt @ 20°C
Dry Film Thickness	50 - 60 µm
Theoretical Coverage	10 - 12m <sup>2</sup> /lt
Viscosity	DIN 4: 15 - 17s at 20°C
Vol Solids	63% mixed by volume
VOC	2004/42/II B(d)(420)418: The EU limit value for this product (product category: II B.d) in ready to use form is max 420 g/litre of VOC.  The VOC content of this product is 418 g/litres.
Storage	Protect from freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage temperature: +10 to +30oc

## Surface Preparation



All surfaces must be dried or flashed-off in accordance with their TDS before application.

When applying on existing finishes the surfaces must be sanded and degreased before application.






## Application Guide

### Recommended Spraying Conditions

Temperature - 18 - 22°C

Relative Air Humidity - 40 - 60%

## Application Guide cont.

<b>1</b> 	Always wear protective equipment
<b>2</b> 	Freshly applied basecoats - prepare according to manufacturer's TDS. When applying on existing finishes the surfaces must be sanded and degreased before application.
<b>3</b> 	Mix 2 parts X605G20-C with 1 part X605G20-H. No thinners are required
<b>4</b> 	Use a Gravity spray gun with 1.3mm nozzle. Pressure as per manufacturers recommendations
<b>5</b> 	Apply ½ closed coat and 1 full wet coat with a 3 - 4 minute flash off between coats

### Drying times

Booth temperature	60°C	20°C
Dry to touch	4 mins	60 mins
Dry to polish	5 mins	2 h
Full hardness	4 days/20°C	4 days

NOTE: After baking for 5 min @60C, immediately remove car from booth to cool down

8 - 10 mins Keep the flash-off time before drying.	IR drying
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### IMPORTANT

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the products at a temperature below 18oc. Low application temperature changes the characteristics of the coatings finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

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