

# Technical Data Sheet

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



## **XPRESS405** *HS RAPID CURE CLEAR COAT*

This HS Rapid Curing Clear Coat uses its rapid dry + anti-scratch technology, to give superior results in flow out and long term gloss retention.



5 Minute Cure  
@ 50C



Anti-Scratch  
Technology



Long  
Open Time

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



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## Technical Data

### Technical info

Mixing ratio	Mix 2 parts HS Clear Coat ( <b>X405G20-C</b> ) to 1 part HS Hardener ( <b>X405G20-H</b> ) by volume
Thinning ratio	Not required
Resin	Acrylic
Specific Gravity	0.98 – 1.0 kg/lt @ 20°C
Dry Film Thickness	35 - 50 µm
Theoretical Coverage	10 - 12m <sup>2</sup> /lt
Viscosity	DIN 4: 15 - 17s at 20°C
Vol Solids	46% mixed by volume
VOC	Actual 510 g/lt in the ready for use form 2004/42/IB(e)(840)510: The EU limit value for this product (product category: IIB.d) in ready to use form is max 840 g/litre of VOC.
Storage	Protect from freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage temperature: +10 to +30oc
Pot Life	60min @ 20°C

## 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.

	Always wear protective equipment
	Freshly applied basecoats - prepare according to manufacturer's TDS. When applying on existing finishes the surfaces must be sanded and degreased before application.
	Mix 2 parts X405G20-C with 1 part X405G20-H. No thinners are required
	Use a Gravity spray gun with 1.3mm nozzle. Pressure as per manufacturers recommendations
	Apply 2 wet coats with a 3 - 5 minute flash off between coats

### Drying times

Booth temperature	50°C	20°C
Dry to touch	4 mins	60 mins
Dry to polish (Polish within 24 hours)	5 mins*	2 h
Full hardness	4 days/20°C	4 days
*NOTE: After baking for 5 min @50°C, immediately remove car from booth to cool down before polishing		
5 - 10 mins Keep the flash-off time before drying.		IR drying

### 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 18°C. 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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