Automotive Refinish
Technical Data Sheet

KURUMA CLEAR 4:1 K-SILVER

Rev.01/26

Product Description

Kuruma Clear 4:1 K-Silver is two-pack acrylic polyurethane topcoat with excellent gloss retention.
It is designed for exterior. It has excellent durability, good adhesion, and excellent chemical resistance.
It is a high gloss. Can be applied on NC lacquer, acrylic lacquer and 2K urethane paint.

Substrate preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Mixing Ratio

- Two Component System

	Weight	Volume
Kuruma Clear 4:1 K-Silver Part A	100	100
Kuruma Clear 4:1 K-Silver Part B	25	25
Thinner	0-5	0-5

Mix Part A and Part B, strictly follow mix ratio recommendations before and stir for 2-3 minutes until the mixture is homogeneous before application.
- Pot life 4 hour after mixing @30^{0}C

Thinner

Kuruma Standard Thinner No.20

Viscosity For Spray

Viscosity Cup	Viscosity (sec) @30^{o}C
Ford Cup No.4	13.5 - 15.5

Spray gun

Gravity Feed

Set-up

Full pattern, Flow - 2.5 turns from fully closed set-up

Nozzle size

1.3 - 1.4 mm. (Please refer to spray gun manufacturer)

Spray pressure

1.5 - 2.0 Bar

Number of spray coats

Recommended apply 2 coats
- Light to medium first coat
- Full wet second coat
- Dry film thickness 55 to 60 Microns

Flash-off time

Between coat : 2 - 3 mins

Drying time

Drying time	Air dry (30 ^{o}C)
Surface dry	15 - 20 mins
Polishing time	4 - 5 hrs
Full cure	7 days

Handling and Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

- 48 months at <40 ^{0}C

Safety and Disposal

- Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.