



ADVANCED REFINISH COMPONENTS

Technical Data Sheet

ARC HS+ CLEAR

DESCRIPTION:

ARC 31590 is a High Solids European Clearcoat that works well in air dry or baking applications. ARC 31590 retains excellent gloss and durability.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Euro HS+ Clear	31590	5 L
Fast HS+ Clear Activator	31591	2.5 L
Medium HS+ Clear Activator	31592	2.5 L
Slow HS+ Clear Activator	31593	2.5 L

COMPATIBLE SUBSTRATES:

ARC HS+ Clear can be applied over any acrylic or polyester basecoat.

SAFETY ASPECTS:


Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS and product label are available upon request.

MIXING RATIOS:

2 parts ARC HS+ Clear
1 part ARC HS+ Clear Activator; Fast, Medium, or Slow


GUN SETUP:


TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity:	1.3 mm - 1.6 mm	35 - 45 psi @ gun
Siphon	1.4 mm - 1.8 mm	35 - 45 psi @ gun
HVLP Gravity	1.3 mm - 1.4 mm	8 - 10 psi @ gun

NUMBER OF COATS:

2 full wet coats

FLASH TIMES:

5 to 10 minutes at 75°F / 24°C with medium hardener.

PURGE TIMES:

10 minutes @75°F (24°C).

DRYING TIMES:


METAL TEMP	DRY TIME
75°F (24°C)	6 to 8 hours
140°F (60°C)	40 minutes



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RECOATABILITY:	ARC HS+ Clear may be recoated after bake cycle when metal has completely cooled down. For best results in air dry situations wait over night.
FILM THICKNESS:	Approximately 1.0 mil per coat (DFT)
DRY TO POLISH:	Air Dry: 6 - 8 hours @ 75°F Force Dry: After cool down
DECALS:	Decals, lettering or stripes can be applied after 24 hours.
CLEANING EQUIPMENT:	Clean equipment immediately with ARC lacquer thinner.

TECHNICAL DATA:



Color	Clear	
Activator/Hardener	ARC HS+ Clear Activator	
Mix Ratio	2:1	
Pot Life	1 hour @ 68-75°F (20-24°C)	
Number of Coats	2 full wet coats	
Flash Time	5 - 10 minutes @75°F (24°C)	
Purge Time	10 minutes @75°F (24°C)	
Dry Time	Air Dry	6 - 8 hours @75°F (24°C)
	Force Dry	40 mins @ 140°F (60°C)
Gun Set Up	Refer to table on page 1	
Air Pressure at Gun	Refer to table on page 1	
Regulatory V.O.C.	3.83 lbs/gal (459 g/l)	
Actual V.O.C.	3.33 lbs/gal (399 g/l)	
Sprayable V.O.C.	4.02 lbs/gal (482 g/l)	
% Solids RTS by weight	47%	
Package Size	5 Liter	
Number per Case	2	
Shelf Life	12 months unopened	

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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