



HiChem Industries Pty Ltd.
73 Hallam South Road Hallam, Vic 3803
Phone (03) 9796 3400 Fax (03) 9796 4500
ACN 006-542-767



PRODUCT INFORMATION SHEET

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2 PACK ISO-FREE CLEAR

Description:

A versatile isocyanate free 2 Pack Clear that offers a tough and durable coating with excellent gloss and film clarity. It offers outstanding outdoor weather resistance, durability, chemical resistance, and gloss retention.

Uses:

For auto, industrial and marine application.

- Suitable for use over -
- (a) Motospray Acrylic Colours (Solid and COB).
 - (b) HiChem 2 Pack Basecoat Colours.
 - (c) HiChem Iso Free Finish.

Properties:

Isocyanate free
Faster air drying than conventional Two Pack clears.
Easier to compound and polish than conventional two pack clears.
Excellent adhesion.

Surface Preparation:

Acrylic Colours (Solid and COB):

- (a). Freshly applied Colours-Allow the paint to **dry thoroughly**. (Ideally 24 hours at 20⁰C . Longer in colder weather)
Note! Excessive, heavy coats of freshly applied colour may lead to solvent entrapment which can cause “dulling off” of the Clear. Ensure the paint is thoroughly dry before applying Iso Free Clear as per application method below.
(b). Sound existing Colours.- Degrease with *Prepwash*. Lightly sand with Superfine Wet and Dry to remove all gloss. Degrease again with *Prepwash* immediately prior to application of the Iso-Free Clear.

HiChem 2 Pack Basecoat Colours:

Iso Free Clear may be applied after the Basecoat has dried for 15-20 minutes at 20⁰C.

HiChem Iso Free Finish (Solids and Metallics):

Iso-Free Clear may be applied immediately after the Iso-Free Finish has dried for 10-15 minutes at 20⁰C.
Alternatively allow minimum 12 hours drying, clean surface with *Prepwash*, then apply Iso-Free Clear.
If Iso-Free Clear is to be applied after 7 days, abrade the surface with Superfine W&D paper and wash with *Prepwash* before application.

Mixing /Thinning:

Mix 3 parts by volume of *2 Pack Iso-Free Clear* with 1 part by volume of *2 Pack Hardener 31(Normal or Slow)*.
If required add 5 to 10% thinner 701N or 701S to the total mixed material. Ensure that the 2 Pack Hardener 31 is tightly resealed after use.

Application viscosity should be approx. 20 secs. by Ford cup no. 4 at 20C.

N.B. Choose Hardeners and Thinners according to size of object and/or temperature prevailing at the time. Drying time will vary accordingly. For example : If the temperature is above 20⁰C and large areas are to painted use Iso-Free Hardener 31 (Slow) and Thinner T701S (Slow). For full vehicle respray a combination of Slow Hardener and Slow Thinner is recommended.

Application:

- Apply 2 or 3 single wet coats allowing a flash-off time of 10-15 minutes between coats.
- Apply using a spray gun with a nozzle size of 1.8 – 2.0 mm.
- *2 Pack Iso-Free Clear* must not be applied when the surface temperature falls below 10⁰C or when dew is present on the surface.
- Excessive film builds may give rise to yellowing on light colours. (eg whites and light silver metallics)
- **DO NOT** force dry Iso-Free Clear when applied over Acrylic Colours (Solid and COB). Air dry only.
- Iso-Free Clear may be force dried when applied over 2 Pack Basecoat Colours or Iso-Free Finish. However the surface must be touch dry before force drying, otherwise solvent entrapment may occur.

Drying Time:

Air dry: Tack free in 30 minutes at 20C and ready for assembly in 24 hours.

Low Bake: A 15 minute flash-off time is required before force drying for 60 minutes at 60° C metal temperature.

Infra-red: Medium wave 17KW. Flash off for 10 minutes. Expose for 35 minutes on medium power at a distance of 40-60 cm.

Full cure, under ambient conditions, is achieved in 7 days.

Recoating and Repairing Iso-Free Clear

Please follow the curing requirements in 1,2,3 below before recoating.

1. Air Dry

Substrate Temp (°C)	You must adhere to either of the two rework periods.		
10	Rework within 24hrs	OR	wait for 7 days before rework
20	Rework within 24hrs	OR	wait for 6 days before rework
30	Rework within 16hrs	OR	wait for 4 days before rework
35	Rework within 10hrs	OR	wait for 3 days before rework

2. Low bake: allow to cool to room temperature before rework.

3. Infra-red: allow to cool to room temperature before rework.

Lightly flat the surface with P800 paper. **Do not sand through to Basecoat.**

Wipe the surface with *Prepwash*. Tack rag prior to painting.

Apply 2-3 coats of Iso-Free Clear.

If sanding during rework results in breaking through the clear then isolate area with *Motospray Isolator* or *HiChem 2 Pack Iso-Free Primer-Isolator*. Reapply base colour and clear.

Polishing:

After 24 hours drying, wet sand the area with 1500 to 2000 grit WD paper using warm soapy water, then buff with Motospray Machine Grade Cutting Compound and polish with Motospray Non Silicone Polish. For best results compounding and polishing should be performed between 3 and 6 days after the application of the 2 Pack Iso Free Clear.

Pot Life :

8 hours at 20° C.

Coverage:

Theoretical coverage at 50 microns average film thickness is 8.7 m² per litre.

Material losses during application will vary and must be taken into account when calculating requirements.

Clean Up:

Use *Superglow Multipurpose Thinner* or *Gunwash*.

Standard Packaging and Product Codes

System Components	Size	Prod.Code	Prod.Code
2 Pack Iso Free Clear	15 Litre	IFC15	
	3 Litre	IFC3	
	750 mls	IFC750	
		Normal	Slow
2 Pack Hardener 31 Normal & Slow	5 Litre	2PIFH5	2PIFHS5
	1 Litre	2PIFH1	2PIFHS1
	250 mls	2PIFH250	2PIFHS250
Thinner 701 Normal & Slow	20 Litre	T701N20	T701S20
	4 Litre	T701N4	T701S4
	1Litre	T701N1	T701S1

Health & Safety:

Refer to the safety guidelines and warnings set out on the labels and in the Material Safety Data Sheets.

The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.