

9400 X40 Semi Gloss, HS semi gloss clear coat 9410 X41 Matt, HS matt clear coat

Ver.: 2022-1

Description

X40 and X41 are HS semi-gloss and matt clear coats specially developed to reproduce a wide range of gloss levels by mixing them. Easy application delivers good looking smooth matt/semi-gloss appearance. The system is suitable for full body or panel repair.

Features & Benefits

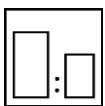
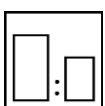
- Easy to apply, easy to reach a uniform finish without clouds
- Uniform low gloss/matt effect (9410)
- Uniform semi-gloss effect (9400)
- Smooth surface, high scratch resistance

Substrate preparation

When applying a masking tape onto the original matt finish, the tape must be removed before baking to avoid marking of the original finish which may not recover.

The 9400/9410 clearcoats must be applied on top of a clean and dust-free basecoat. The light use of a tack cloth is recommended after the basecoat has flashed off. Care should be taken to avoid dirt inclusion at all stages of painting. Removal of dirt inclusion in matt finishes is not possible after the final coat of clearcoat.

Application data

X40 	Mixing ratio /9400	<u>By volume</u>
	9400 X40 Semi Gloss	2
	9230/9250/9270 2K Hardener	1
	7050 Thinner	30 %
X41 	Mixing ratio /9410	<u>By volume</u>
	9410 X41 Matt	3
	9230/9250/9270 2K Hardener	1
	7050 Thinner	30 – 50 %




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Gloss levels (weight %)

	Matt 1 Flatt	Matt 2 Matt	Matt 3	Matt 4 Satin	Matt 5 Semi-Gloss
% of gloss	0 – 10 %	10 – 20 %	20 – 30 %	30 – 45 %	50 – 60 %
X41 matt	100	80	50	30	0
X40 semi-gloss	0	20	50	70	100
Mixing ratio	3 : 1	2 : 1	2 : 1	2 : 1	2 : 1

9400 and 9410 can be mixed in all other mixing ratios to achieve the desired matt/gloss level.

	<p>Spray gun set /air inlet</p> <p>Gravity feed 1.2 – 1.4 mm 1.8 – 2.0 bar</p> <p>Suction feed Verify spray gun manufacturer's info</p>
	<p>Application</p> <p>Number of coats 2 medium-wet closed coats with cross layer application</p> <p>Total dry film build 40 – 50 microns</p> <p>Flash off between layers 10 min (20°C/68°F)</p> <p>Flash off before baking 30 min (20°C/68°F)</p> <p>Application temperature 15 – 30°C (59-86°F)</p> <p>* The gloss level can depend on several factors: type of application (cross-over or not); flash off times between layers and before baking, applying the mist layer or not, end film thickness.</p>
	<p>Drying</p> <p>Dust free (20°C/68°F) 10 min</p> <p>Through dry (20°C/68°F) 18 – 24 h</p> <p>Through dry (60°C/140°F) 30 min</p> <p>Dry to tape (20°C/68°F) Next day</p> <p>Dry to tape (60°C/140°F) After cooling down</p> <p>Pot life 30 min</p>
<p>Complementary products</p>	
<p>- 9230 (fast), 9250 (standard), 9270 (slow) 2K Hardener</p> <p>- 7050 Maxx Thinner (standard)</p>	

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Testing of the material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Prod. Nr.	Description	Volume	Packaging Box
9400-1	/	1 L	6
9410-1	/	1 L	6

VOC

VOC 2004/42/IIB(e) (840) <680

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Table 1.1 – Mixing ratio by weight

Volume of RFU paint required (ml)	Weight: Clearcoat	Weight: Clear Coat + Hardener	Weight: Clear Coat + Hardener + Thinner
100	67	89	101
250	166	222	252
330	220	293	332
500	333	445	503
750	499	667	755
1000	665	889	1007

Additional Information

Do not expose the clear coat to the moisture min. 24 hours after the drying time. FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation. Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version. All products mentioned in this data sheet are trademarks owned by Silco.