

## TECHNICAL DATA SHEET

### NOBEL 2300 HS CLEAR COAT

#### PRODUCT DISCRITION

#### NOBEL 2300 HS CLEAR COAT

is a 2K high solids acrylic clearcoat especially formulated for applying over solvent-based basecoats. It gives high gloss and It offers high durability and weathering resistance. When used in conjunction with nobel hs hardeners 355 Normal, 350 Fast, 360 Extra Fast or nobel 2400 delivers high gloss and excellent finish

#### Uses

- Suitable for use in all vehicle refinishing process.
- Provides protection and glossy appearance.

#### product features

- Easy and reliable application.
- Excellent gloss and gloss retention.
- High weathering and chemicals resistance.
- Transparent with perfect mechanical properties.

#### technical information

Finish	Gloss
Color	Transparent
Solid content	75 % ± 2%
Density at 25°	1 ± 0.05 gm. /cm3
Viscosity	1 min ± 10 seconds
Gloss level /60	88-92 GU (angle 60°)



## Substrate and surface preparation

- The surface must be clean and free from oil, grease, dirt and any other foreign contaminants
- New Surface: Must be sanded and cleaned by suitable Degreaser.
- Old or Original Surfaces: well sanded and cleaned by Nobel Cleanser.

## Application


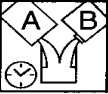


(Nobel 2300) acrylic clearcoat can be applied by spraying

### (Nobel HS Hardener)





Nobel a810 Thinner-normal

Nobel a820 Thinner-slow

NOTE: Nobel ax830 slow thinner is recommended for high temperatures

	Mixing ratio: 100:50:5-10	<b>Mixing ratio by volume:</b>		
	Hardener: (Nobel H hardener)	2:1:0.1-0.2		
	Thinner: Nobel a810- 820			
	Pot life: 3-4 hours at 25°C			
	<b>Application viscosity:</b> 15-18 s (DIN4/20°C)			
	<b>Spray gun tips:</b>			
	<b>Spray Nozzle</b>	<b>Inlet pressure</b>	<b>Atomization pressure</b>	
	Compliant	1.6-1.8	2 bars (26- 29 psi)	
	HVLP	1.6-1.8	2 bars (26- 29 psi)	0.7bar (8-10 psi)
	Conventional	1.6-1.8	3-3.5 bar (45-50 psi)	
Refer to the spray gun manufacturer's recommendation.				

## Drying time

	<p><b>Number of coats:</b> Apply 2-3 single coats Total dry film thickness 40-50 microns</p>												
	<p style="text-align: center;"><b>Drying time at</b></p> <table border="1"> <thead> <tr> <th>Hardener</th> <th>20 °c</th> <th>60 °c</th> </tr> </thead> <tbody> <tr> <td>(Nobel H350 ms Hardener) fast</td> <td>12-14 h</td> <td>25 min</td> </tr> <tr> <td>(Nobel H355 ms Hardener) normal</td> <td>14 – 16 h</td> <td>30 min</td> </tr> <tr> <td>(Nobel H360 ms Hardener) slow</td> <td>16 -18 h</td> <td>35 min</td> </tr> </tbody> </table>	Hardener	20 °c	60 °c	(Nobel H350 ms Hardener) fast	12-14 h	25 min	(Nobel H355 ms Hardener) normal	14 – 16 h	30 min	(Nobel H360 ms Hardener) slow	16 -18 h	35 min
Hardener	20 °c	60 °c											
(Nobel H350 ms Hardener) fast	12-14 h	25 min											
(Nobel H355 ms Hardener) normal	14 – 16 h	30 min											
(Nobel H360 ms Hardener) slow	16 -18 h	35 min											
	<p><b>Flash off time:</b> 5-10 min/20°C between coats 20 min/20°C before baking</p>												
	<p><b>IR Drying:</b> Short wave*: 10-15 min *Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets up.</p>												

## color

transparent

## Theoretical coverage

- 6 – 8 m<sup>2</sup>/L per coat at 60-70 microns

DFT The practical material consumption depends on several factors, such as geometry of the object, surface formation, application method, spray gun setting and type, inlet pressure, etc.

## Rectification and polishing

- **NOBEL 2300 HS CLEAR COAT** does not require polishing as it offers excellent gloss.
- In a case that some dirt has occurred, polish by machine using wax Polish compound. Polishing is easiest up to 24 h after the drying time.

## Shelf life

36 months in the original package, tightly closed at a temperature of 25 ° C and away from direct sunlight and heat

## Remarks

- Material has to be at room temperature (20-25°C) before use.
- Close can of hardener Nobel clear coat 2000 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Clean the spray gun thoroughly immediately after use of 2K products.
- Allow additional time for preheating up to panel temperature.
- The choice of Reducer should be made according to application temperature and size of repair

## Health and Safety

1. For full Health and Safety information please refer to the Material Safety Data Sheet.
2. Observe the precautionary notices displayed on the container.
3. Good ventilation must be provided in the working environment