

AB-FCSC 2277 HS Fast Cure 2:1 Clear Coat

Field of application

Suitable for passenger cars and commercial vehicles. For application as a clear top coat over basecoats.

General Information

AB-FCSC 2277 HS Fast Cure 2:1 Clear Coat is a product containing high-quality acrylic resins. Even though it dries quickly, unlike similar fast clear coats, it can be used easily in both partial and complete vehicle coating. It is a full performance product that is resistant to atmospheric conditions, has high gloss, high scratch resistance and fuel resistance, also an excellent surface and spreading feature.

AB-FCSC 2277 HS Fast Cure 2:1 Clear Coat, which dries in **15 minutes at 60 °C and 120 minutes at 20 °C**, saves time and energy for the sprayer, while also reducing labor costs with its easy paste polish feature.

*****Should only be used with AB-FCSC 1177 HS Fast Cure 2:1 Hardener!**

Preparation of Substrate

Apply on top of a clean and dust free basecoat (the use of a tack rag is recommended to remove dust from the basecoat film).

Hardener and Reducer Selection

AB-FCSC 1177 HS Fast Cure Hardener

***** At low temperatures, a maximum of 5 % AB-URDC 5001 Universal Urethane Reducer Fast can be added.**

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Mixing Ratio



Mixing Ratio with Hardener

2 : 1 AB-FCSC 2277 HS Fast Cure 2:1 Clear Coat : AB-FCSC 1177 HS Fast Cure 2:1 Hardener
Application Viscosity DIN4 20 °C : 17-19''

Mix Table (According to the hardener)

	Mixing Ratio	Volume (L)	Weight (gr)
AB-FCSC 2277 HS Fast Cure 2:1 Clear Coat	2	1,030	1.000
AB-FCSC 1177 HS Fast Cure 2:1 Hardener	1	0,515	500
Total Weight (g)		1,545	1.500,00
Application Viscosity DIN4 20 °C	17-19''		
Pot life at 20 °C	2-3 hours		

Application



Spray gun nozzle (mm)	1,2-1,4
Air Pressure (Bar) RP, LVLP	1,8-2,2
Conventional Guns Air Pressure (Bar)	3,0-3,5
HVLP (Bar)	0,5-0,7
Number of Coats	1,5-2 coats
Between Coats	5-10 minutes

*** The first coat should be applied closely and quickly.

*** Mask entire vehicle to eliminate unwanted overspray

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Drying Times



	Air Dry 20 °C	Forced Dry 60 °C
Flash Off	10 minutes	10 minutes
Dust free	60 minutes	-
Dry to handle	90 minutes	15 minutes
Dry to polish	120 minutes	after cooling down
Total Film Build	50-55 µm	

*** Dry to handle at Forced Dry 40 °C : 30 minutes, Dry to handle at Forced Dry 50 °C : 20 minutes

***All these drying conditions occur under standard application conditions (20-25 °C and 50-55 % relative humidity.) All conditions may change depending on temperature, relative humidity, and environmental conditions.

*** If there are too many coats or not enough time is waited between applications, there may be matting

Sanding

Required before recoating to ensure good adhesion

DRY : P500

WET : P800

Polishing

If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time. Denib with P1200, followed by P1500 dry disc. Lightly damp a 3M Trizact P3000 disc or similar with clean water ensuring that the P1500 scratches are eliminated.

Gloss : High Gloss

Storage life : Under normal storage conditions and unopened tins up to 2 years.

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Cleaning of Equipment



After use, clean all equipment with Cleaning Thinners

Protection



Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



For more detailed information please see Safety Data Sheet.