
BH-A1004 4:1 Urethane Clear Coat

Field of application

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

General Information

c is the second layer of the two-coat metallic-acrylic paint system. **BH-A1004 4:1 Urethane Clear Coat** is a non-yellowing, high-gloss and highly resistant clear coat. Fast drying, easy to use properties respond quick workflow with strong spreading and resistance to fuel. Can be both air-dried and forced-dried.

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 Thinner Selection

Temperature	HS Hardeners	Universal Thinners
Up to 18 °C	Blue Horse A2004 Hardener Fast	Universal Thinner Fast
18-25 °C	Blue Horse A2004 Hardener Standard	Universal Thinner Standard
25-35 °C	Blue Horse A2004 Hardener Slow	Universal Thinner Slow
Over 35 °C	Blue Horse A2004 Hardener Slow	Universal Thinner Very Slow

Mixing Ratio



Mixing Ratio with Hardeners and Thinners

4 : 1 BH-A1004 4:1 Urethane Clear Coat: Blue Horse A2004 Hardeners + max. %5 Universal Thinners

Application Viscosity DIN4 20 °C : 15-17"

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Mix Tables (According to Thinner Ratio)

	Regular % 5-10 Thinner	
	Volume	Weight
BH-A1004 4:1 Urethane Clear Coat	4	1.000,0
Blue Horse A2004 Hardeners	1	255,0
Universal Thinners	0,1	43,0
Total Weight (g)		1298,00
Application Viscosity DIN4 20 °C	16-18"	
Pot life at 20 °C	90-120 minutes	

Application



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

*** Mask entire vehicle to eliminate unwanted overspray

Drying Times



	Air Dry 20 °C	Forced Dry 60 °C
Flash Off	5-10 minutes	5-10 minutes
Dust free	20-30 minutes	
Dry to handle	5-6 hours	
Dry to polish	12 hours	30-35 minutes
Total Film Build	40-45 µm	

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

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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.

Cleaning of Equipment



After use, clean all equipment with Universal Acrylic Thinners and Cleaning Thinners

Protection



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



For more detailed information please see Safety Data Sheet.

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